

Basecoat WB FA12RR Ruby Red

Technical Bulletin

09/11/2019

L8.07.08b UK & Ireland

DESCRIPTION

The repair system for Ford FA12: RR Ruby Red consists of different layers creating a special color effect, based on the following layers:

- Basecoat WB GT Groundcoat
- Basecoat WB GT Midcoat
- Clearcoat

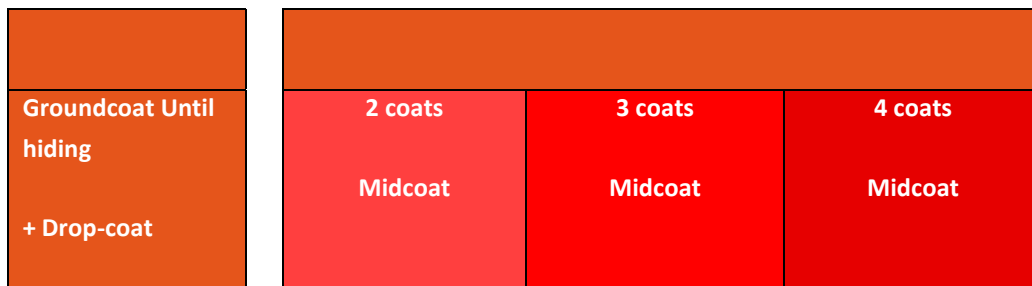
COLOR CHECK

Correct color match needs to be done by producing a number of color spray-out samples, the color changes dependent on the number of coats applied of the effect color.

Proceed as follows

- Apply the foundation color until opacity is achieved on 1-5 different spray-out panels.
- Next apply one single coat of the effect color to all panels.
- Allow sufficient flash-off time and **remove one** panel before continuing this application process, resulting in spray-outs panels ranging with 1-5 coats of the effect coat.
- Allow for a 10-15 minutes flash-off time at 70°F (20°C) prior to clearcoat application.
- For optimum flash-off, dry the panels for several minutes in an oven or during a drying cycle in the spray booth.
- Apply two single layers of clearcoat to all color spray-out panels, securing brightness and color depth.

Create a set of spray out panels as below:



The operator can determine the right color match by using these color samples.

- Number each panel, indicating the number of effect coats on the panel.
- **Do not spray each panel separately.**

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BASECOAT WB GT GROUNDCOAT



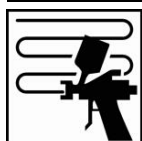
100
10-20

Basecoat WB GT FA12: RR Groundcoat
Activator WB

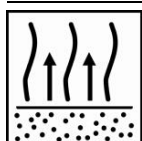


Spray gun set up :
1.3-1.4 mm

Application pressure :
1.7-2.2 bar at the air inlet
HVLP max 0.6-0.7 bar at the air cap



Apply Mix 1 until completely covered, flash-off between coats.
Apply the drop coat directly into the wet final coat.



Flash off by increasing airflow until completely dry between coats.
Drop coat has to be flashed off until completely dry before midcoat application.

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BASECOAT WB GT MIDCOAT



100
20

Basecoat WB GT FA12: RR Midcoat
Activator WB



Spray gun set up :
1.3-1.4 mm

Application pressure :
1.7-2.2 bar at the air inlet
HVLP max 0.6-0.7 bar at the air cap



Apply 2-4 coats of the midcoat until desired color is achieved.
Flash-off between coats.



Flash off until completely dry between each coat and allow to flash off for 20-30 minutes before clearcoat application.

CLEARCOAT



See clearcoat TDS:



Use suitable respiratory protection
Akzo Nobel Car Refinishes recommends the use of fresh air supply respirator

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