

Basecoat WB MAZ46V Soul Red Crystal

Technical Bulletin

09/11/2019

L8.07.10b UK & Ireland

DESCRIPTION

This color can be repaired by use of the color formulas of the Mazda 46V Groundcoat and Midcoat. This step by step application instruction provides a simple method for obtaining an invisible repair.

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 a 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:

Groundcoat Until hiding + Drop-coat				
	2 coats Midcoat	3 coats Midcoat	4 coats Midcoat	5 coats Midcoat

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

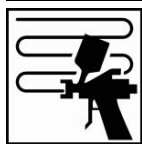


100 Basecoat WB GT Groundcoat Mazda 46V
10-20 Activator WB



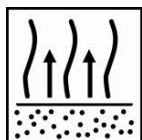
Spray gun set up :
1.3-1.4 mm

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



Apply the groundcoat until completely covered, flash-off between coats and apply a drop coat.

Note: For an optimal blend-edge a mini/compact spray gun can be used



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

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BASECOAT WB GT MIDCOAT



100 Basecoat WB GT Midcoat Mazda 46V
 4 Basecoat WB GT MM05
 10-20 Activator WB



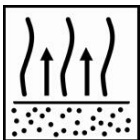
Spray gun set up :
 1.3-1.4 mm

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



Apply 2-5 coats of the midcoat until the desired color is achieved. Flash-off between coats.

Note: Apply overlapping coats towards and over the Groundcoat. Start 1st coat as wide as possible. With the second and following coats within the previous coats until desired color is achieved



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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