

Basecoat WB GT TOY8Y7 Force Blue

Technical Bulletin

15/10/2021

L8.07.15b UK & Ireland

Description

TOY 8Y7 is a 3 stage basecoat system consisting of different layers creating a special color effect:

- **Basecoat Groundcoat color**
- **Basecoat Midcoat color** **Note: *Please ensure that Midcoat Special Blue RM006 is in stock**
- **Clearcoat**

Correct color match needs to be determined by producing a number of color spray-out samples. The color is determined by achieving full hiding of the ground coat color, then by applying a number of coats with the mid coat color to determine the correct color match. The correct process to determine the correct color match is as follows:

1. Mark the spray out panels on the back with the number of mid-coat layers to be applied
2. Distribute spray out panels evenly in the required number of panels usually 3-5
3. Apply the correct foundation primer
4. Apply the ground coat color until hiding on all panels as per basecoat TDS
5. Mask of all panels individually except one, should be masked in a way that after each layer the masking can be removed from one panel at a time
6. Next apply one single coat of the mid-coat color to the unmasked panel
7. Allow sufficient flash-off time of the mid-coat and remove the masking from one panel before continuing
8. Next apply one single coat of the mid-coat to all panels
9. Repeat steps six and seven until all panels have been coated with the midcoat, resulting in spray-outs panels ranging with 1-5 coats of the mid-coat
10. Allow for a 10-15 minutes flash-off time at 75°F (25°C) prior to clearcoat application
11. Before clearcoat application mask of a part of the panel to show the final basecoat, color which can be used to check the color during the repair process
12. Apply two single layers of clearcoat



DO NOT SPRAY EACH PANEL SEPARATELY.

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- By using these panels the technician can determine the right amount of midcoat layers for a good color match
- Number each panel, indicating the number of effect coats on the panel
- Personal application differences make it recommended that each painter creates its own spray-outs
- To obtain an accurate color match, spray the panels as if it would be applied to the vehicle, i.e. place all spray-outs on one larger panel and spray complete panel for each coat

SURFACE PREPARATION



Final sanding step P500

- Initial sanding steps may be executed with a coarser sanding grit; P320 - P400
- Respect a maximum 100 sanding grit step difference or less throughout the sanding procedure
- For detailed surface preparation see TDS L8.06.02



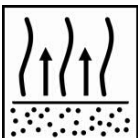
Basecoat blend area

Final sanding step P1000

- Initial sanding steps may be executed with a coarser sanding grit P600 - P800
- Respect a maximum 200 sanding grit step difference or less throughout the sanding procedure
- For detailed surface preparation see TDS L8.06.02
- Do NOT use Basecoat WB GT toner MM02 / MM04 or a mix of both as pre-coat, it will change the depth of the OE color



Surface cleaning: remove contamination using an appropriate surface cleaner.



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

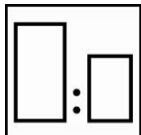
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BASECOAT WB GT GROUNDCOAT



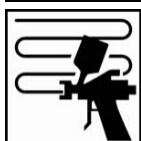
RFU Basecoat WB GT Groundcoat TOY8Y7

Note: To avoid overspray when painting larger objects or in warmer conditions / lower humidity, Activator WB can be added up to a maximum of 10 - 20%



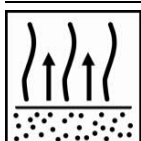
Spray gun set up :
1.3-1.4 mm

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.

Note: Ensure to create a smooth blend of the ground-coat on to the OEM



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

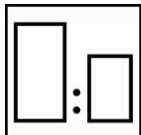
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BASECOAT WB GT MIDCOAT



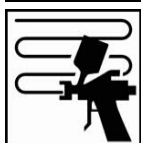
100 Basecoat WB GT Midcoat TOY 8Y7
 20-30 Activator WB*

*When Activator WB is added apply Midcoat TOY8Y7 the same day



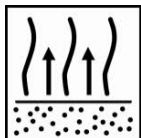
Spray gun set up :
 1.3-1.4 mm

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



Apply the number of midcoat layers until the desired color is achieved, flash-off after each coat till completely matt

Note: Apply overlapping coats towards and over the Ground-coat. 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 before clearcoat application.

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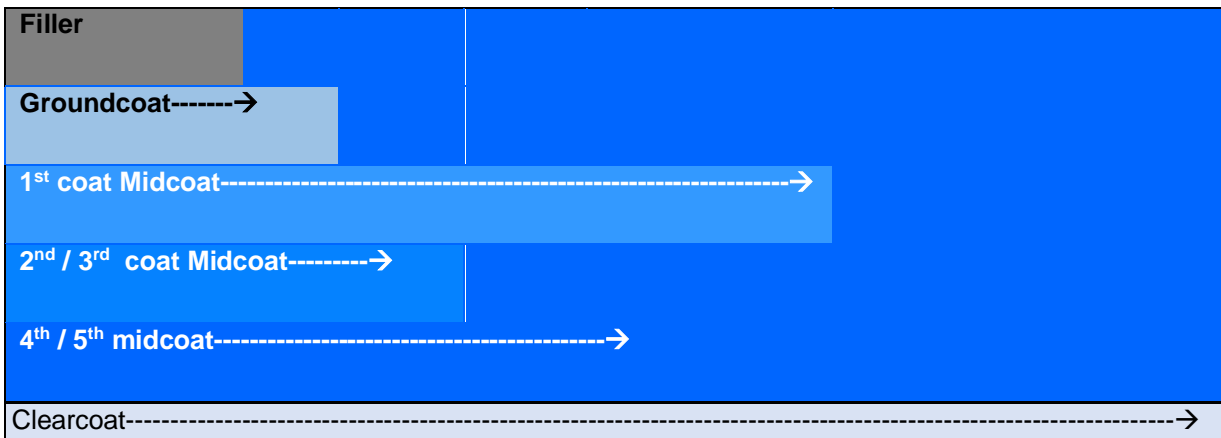
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Repair process

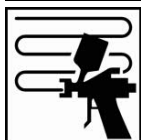
Apply groundcoat as per Basecoat WB GT TDS, create a smooth blend onto the OEM

First midcoat layer should be applied to the blend area as far as required to blend the color

Second and third layers should be applied beyond the ground coat layer but inside the first layer of midcoat along with the fourth and fifth layer if required



CLEARCOAT



See clearcoat TDS:



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

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