

Autowave 2.0 MAZDA 46V Soul Red Crystal

FOR PROFESSIONAL USE ONLY

Definition and description

Repair system for Mazda 46V Soul Red Crystal consists of different layers creating a special color effect, based on the following layers:

- Colorbuild Plus
- Basecoat Ground coat color
- Basecoat Mid coat color
- Clearcoat



Color check by spray out samples

Correct color match needs to be determined by producing a number of color spray-out samples. The color depends on the number of coats of the mid coat applied. Distribute spray out panels according to the following matrix and apply ground coat in 3-4 coats till completely covered and apply drop coat for optimal orientation. All coats should be completely dry before next coat is applied. Apply mid coat in 2 to 5 closed coats. All applied coats of the mid coat should be completely dry before next coat is applied.

Create a set of sprayout panels as below:

3-4 coats Ground coat Until hiding + Drop-coat				
	2 coats midcoat	3 coats midcoat	4 coats midcoat	5 coats midcoat

Allow for a 15-20 minutes flash-off time at 25°C prior to clearcoat application and apply Clearcoat according T.D.S.

The operator can determine the right color match by use of these color samples.
 - Number each panel, indicating the number of foundation and effect coats on the panel.

NOTE: DON'T SPRAY PANELS SEPARATELY.

Surface preparation

Colorbuild Plus (Sanding) area



Final sanding step P500

- Initial sanding steps may be executed with a coarser sanding grit; P360 - P400
- Respect a maximum 100 sanding grit step difference or less throughout the sanding procedure.
- For detailed surface preparation see TDS S8.06.02

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 S8.06.02

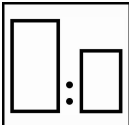



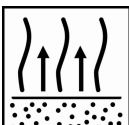
Note: Do NOT use Autowave MM666/MM600 as pre-coat, it will change the depth of the OE color.



-Surface cleaning: Remove contamination using an appropriate surface cleaner.

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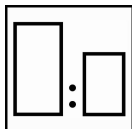
Ground coat application	
	<p>100 parts by volume of MAZ46V Groundcoat 10-20 parts by volume Activator WB</p>
	<p>Use Sikkens measuring stick 14 Blue</p>
	<p>Spray gun set-up: 1.3 – mm</p> <p>Application pressure: 1.8 bar at the air inlet HVLP max 0.6-0.7 bar at the air cap</p>
	<p>Apply 2-3 coats of the ground coat until completely covered, flash-off between each coat and apply a dropcoat.</p>
	<p>Flash off by increasing airflow until completely dry between each coat. Dropcoat has to be flashed until completely dry before mid coat application.</p>



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Mid coat application



100 grams of Autowave Mazda 46V mid coat
 4 grams of Autowave MM700
 10-20 grams of Activator WB

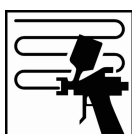


Use scale



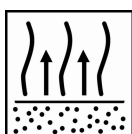
Spray gun set-up:
 1.3 mm

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



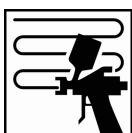
Apply 2-5 coats of the mid coat until desired color is achieved, flash-off between coats.

Note: Apply overlapping coats towards and over the Groud-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 by increasing airflow until completely dry between each coat and before Clearcoat application.

Clearcoat

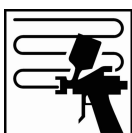


See Clearcoat T.D.S.



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

Notes



- Ensure that each coat is thoroughly flashed-off.
- Application Mazda 46V is applied in the same way as a Three Stage Pearl effect colour. For further information please refer to to Technical Bulletin Autowave 2.0 Three Stage Pearl application process.

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