

Autowave 2.0 Honda B605P Andaro Blue

FOR PROFESSIONAL USE ONLY

Definition and description

The repair system for Honda B605P Andaro Blue consists of different layers creating a special color effect, based on the following layers

- Autowave 2.0 Groundcoat color
- Autowave 2.0 Midcoat color
- Clearcoat

Color check by spray out samples

Groundcoat:

Apply groundcoat till completely covered and apply drop coat for optimal orientation. All coats should be completely dry before next coat is applied. Groundcoat is applied as standard Autowave 2.0.

Midcoat:

Correct color match needs to be determined by producing a number of color spray-out samples. The color depends on the number of coats applied of the midcoat. Distribute spray out panels according to the following matrix.

1. Apply the groundcoat till coverage followed by a drop coat.
2. Apply 2, 3 and 4 layers of the midcoat to the panels, from left to right.

Groundcoat	2 layers Midcoat	3 layers Midcoat	4 layers Midcoat

3. Allow for a 10-15 minutes flash-off time at 25°C prior to clearcoat application.
4. Apply two single layers of clearcoat.

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

- Number each panel on the reverse, indicating the number of groundcoat and midcoat layers applied on the panels.

DO NOT SPRAY EACH PANEL SEPARATELY.

- The application will vary depending on temperature, humidity and applicator and therefore could have an influence on the number of midcoat layers.

Suitable substrates

All Existing OEM finishes.
 All current Sikkens preparatory products with the exception of Washprimers.



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Surface preparation



Primer (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

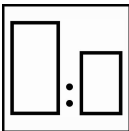
Final sanding step P1000

- 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
- Do NOT use Autowave MM666/MM600 as pre-coat; it will change the depth of the OE color.
- Clear Midcoat can be used as a pre coat; it has to be dried completely before application of Groundcoat color.



Surface cleaning: remove contamination using an appropriate surface cleaner.

Groundcoat application



100 parts by volume of Groundcoat
 10 - 20 parts by volume Activator WB



Use Sikkens measuring stick

14 Blue



Spray gun set-up:

1.3 mm

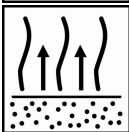
Application pressure:

1.8 bar at the air inlet

HVLP max 0.6-0.7 bar at the air cap



Apply groundcoat until completely covered, flash-off after each coat and apply a controlled drop coat.



Flash off by increasing airflow until completely dry after each coat.

Drop coat has to be flashed until completely dry before midcoat application.

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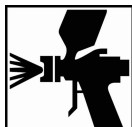
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Midcoat application



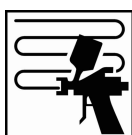
100 grams of Midcoat
 4 grams of Autowave MM700
 10-20 grams of Activator WB

Use the scale for accurate mixing

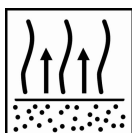


Spray gun set-up:
 1.3 mm

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

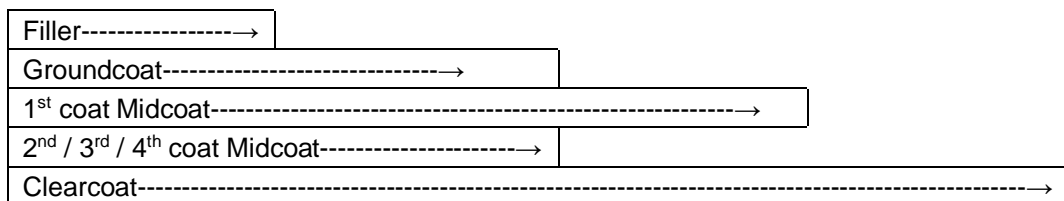


Apply the number of midcoat layers until the desired color is achieved, flash-off after each coat till completely matt.



Flash off by increasing airflow until completely dry after each coat and before Clearcoat application.

Repair Process



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Clearcoat

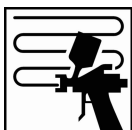


See Clearcoat T.D.S.



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 of a Tri-Stage color is the same as a Three Stage Pearl effect color.

For further information please refer to Technical Bulletin Autowave 2.0 Three Stage Pearl application process.

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