

Mit P62 - Red Diamond Autowave 2.0

FOR PROFESSIONAL USE ONLY

Definition and description



Mitsubishi P62 Diamond Red is a 3 stage basecoat system consisting of different layers creating a special color effect.

- Basecoat Ground-coat color
- Basecoat Mid-coat color
- Clearcoat

Color check by spray out samples

The right amount of Mid-coat layers needs to be determined by producing a number of color spray-out samples. The color depends on the Ground-coat color and the number of coats applied of the Mid-coat color.

Distribute the spray-out panels according to the following matrix:

1. Apply the Ground-coat color till opacity is reached on all panels according to the TDS application of Autowave MM 2.0.
2. Flash off in between each layer/s
3. Leave to flash off for 15-20 minutes @ 20°C before Mid-coat application
 (or raise temperature 5-10 minutes up to 60°C)
4. Apply 2, 3, and 4 layers of the Mid-coat color to the panels.

Create a set of sprayout panels as below:

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

5. Allow for 15-20 minutes flash-off time at 25°C prior to clearcoat application.
6. Mask half of the panels to be left unpainted for checking the color during application on the vehicle.
7. Apply clearcoat according to TDS.

NOTE: DON'T SPRAY PANELS SEPERATELY

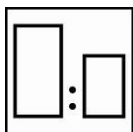
The painter can determine the right color match by use of these color samples

- Number each panel, indicating the number of foundation and effect coats on the panel.



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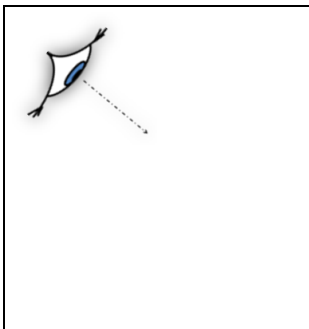
Mix Ground-coat

100 parts by volume MIT P62 Ground-coat
 10-20 parts by volume Activator WB

Mix Mid-coat

100 parts by volume MIT P62 Mid-coat
 10-20 parts by volume Activator WB

Check Spray-out panels and choose the panel closest to the repair.



Check spray-out panels close to or adjacent to the repair and determine the amount of Mid-coat layers needed for imitating the OEM color.

Surface preparation

Prepare Filler/OEM as normal for basecoat color

Filler area



Final sanding step P500-P600

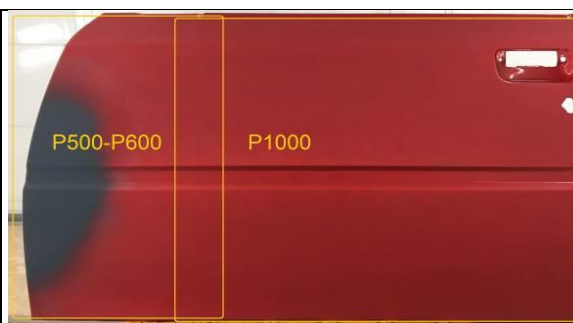
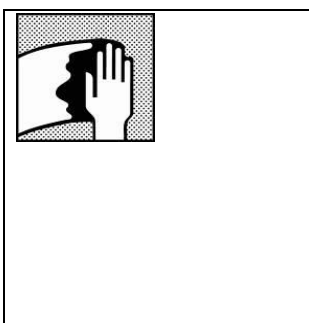
- Initial sanding steps may be executed with a coarser sanding grit; P360 - P400
- Respect a maximum 100 sanding grit step difference or less throughout the sanding procedure.
- For detailed surface preparation see TDS S8.06.02

Blending area (OEM)



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



Surface cleaning: Remove contamination using an appropriate surface cleaner.

(Tack rag prior to painting the Ground-coat)

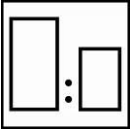
Picture 1: Prepared and degreased area under repair



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Repair process



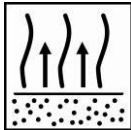
Mix Ground-coat

100 parts by volume MIT P62 Ground-coat
 10-20 parts by volume Activator WB
 -Use Sikkens measuring stick **14 Blue**

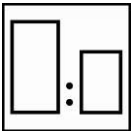


Apply Ground-coat according to TDS respecting flash off times in between layers

Repair process

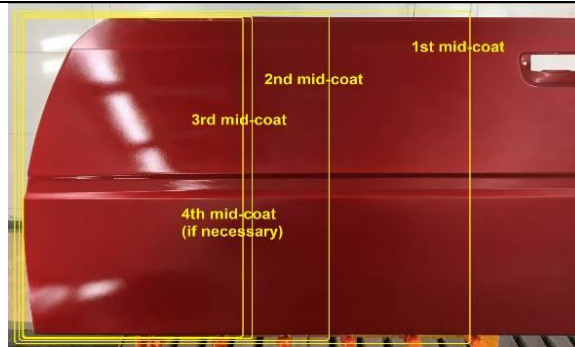
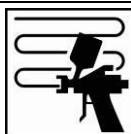


Leave to flash off for 15-20 minutes @25°C minutes before the Mid-coat application
 (or raise temperature 5-10 minutes up to 60°C)



Mix Mid-coat

100 parts by volume MIT P62 Mid-coat
 10-20 parts by volume Activator WB
 -Use Sikkens measuring stick **14 Blue**



As with all 3 stage basecoat colors apply the first coat of the Mid-coat as far as possible to determine the outer border, from there work towards the Ground-coat. (Outside inwards)

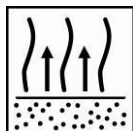
Leave to flash off until matt between coats.



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		<p>Check repair inbetween Mid-coats to ensure the amount of coats applied is sufficient.</p>
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Leave to flash off for 15-20 minutes @25°C minutes before the clear-coat application (or raise temperature 5-10 minutes up to 60°C)

Clearcoat application

		<p>Apply clear-coat according to TDS clear-coat used.</p>
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