Toyota 8Y7 Force Blue

FOR PROFESSIONAL USE ONLY

Definition and description

Toyota 8Y7 (TOY8Y7) is a three stage basecoat system that consists of three separate layers to be applied to create a special effect color based on the following;

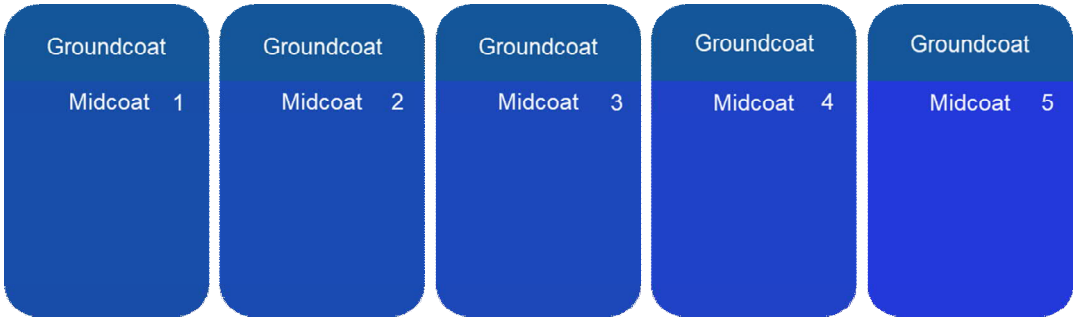
1. Basecoat ground coat color
2. Basecoat mid-coat color
3. Clearcoat gloss finish

Note: *Please ensure that Midcoat Special Blue RM006 is available to order from stock

Color check by spray out samples

Correct color match needs to be determined by producing a number of color spray-out samples. The color is determined by ahcieveing 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



- 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 makes it recommended that each painter creates their own spray-outs
- To obtain an accurate color match, spray the panels as if applying to a vehicle, i.e. place all spray-outs on one larger panel and spray complete panel for each coat

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

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Suitable substrates

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

Surface preparation

Primer (Sanding) area

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 S8.06.02

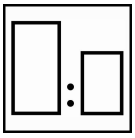
Basecoat blend area

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 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.

Groundcoat mixing / application



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

Use Sikkens measuring stick
14 Blue

Spray gun set-up:

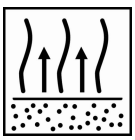
1.3mm

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 fully
Apply mist coat for even metallic orientation



Flash off by increasing airflow until completely dry after each coat
Mist coat has to be flashed until completely dry before midcoat application

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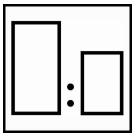
Midcoat mixing / application

Mix the mid-coat using toner RM006 to achieve the final color



100 parts by volume of Midcoat
20-30 parts by volume Activator WB*

* When Activator WB is added apply Midcoat Toy8Y7 on the same day

Use Sikkens measuring stick
14 Blue

Spray gun set-up:

1.3mm

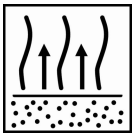
Application pressure:

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

Check the correct color match using the pre-determined sprayout panels without clearcoat application



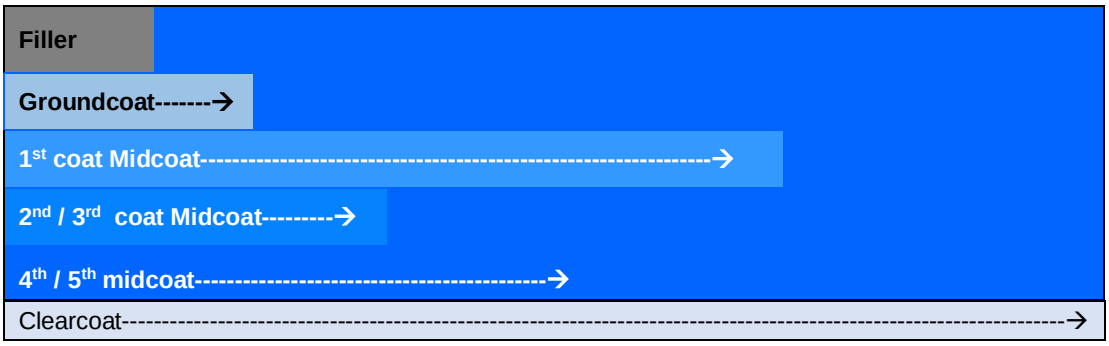
Flash off by increasing airflow until completely dry after each coat and before Clearcoat application.

Repair Process

Apply groundcoat as per Autowave 2.0 TDS

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

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



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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 three stage color is the same as with 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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