

Autowave Optima MAZ51 Rhodium White

FOR PROFESSIONAL USE ONLY

Definition and description

Mazda 51K is a three stage Autowave Optima MM basecoat system that consists of three separate layers to be applied to create this special effect color based on the following steps

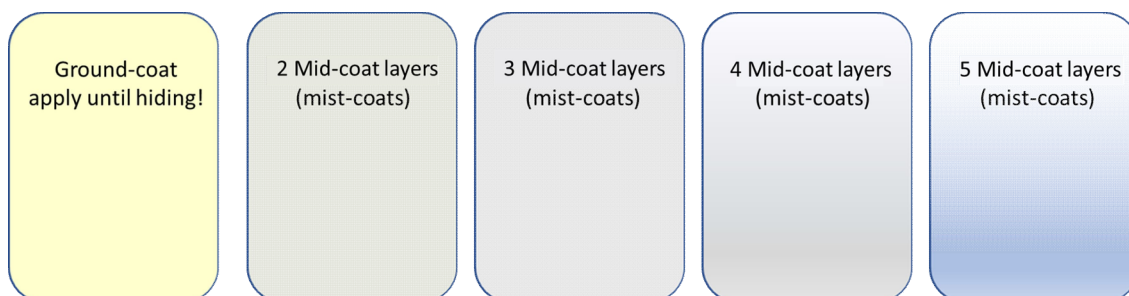
1. Basecoat ground coat color (Layer 1)
2. Basecoat Effect color (Layer 2)
3. Clearcoat finish



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 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 amount of Layer 2 to be applied
2. Distribute spray out panels evenly in the required number of panels usually 3-5
3. Apply a white filler
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. Adjust the fluid needle setting from fully closed to one full turn out**
7. Next apply one single coat of Layer 2* color to the unmasked panel
 * **Layer 2 should be applied by application of a mist coat**
8. Allow sufficient flash-off time of the Layer 2 and **remove the masking from one panel** before continuing
9. Next apply one single coat of Layer 2 to all panels
10. Repeat steps six and seven, this will result in 2 to 5 spray-out panels
11. Allow for a 10-15 minutes flash-off time at 75°F (25°C) prior to clearcoat application
12. Before clearcoat application mask of a part of the panel to show the final basecoat color (without Clearcoat) which can be used to check the color during the repair process
13. Apply two single layers of clearcoat



- By using these panels the technician can determine the right amount of layer 2 layers for a good color match
- Number each panel, indicating the number of Mid coats applied 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 end color

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Suitable Substrates

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

Surface Preparation



Final sanding step P600

- Initial sanding steps may be executed with a coarser sanding grit; P400-P500
- 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

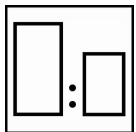
Final sanding step P1000

- Initial sanding steps may be executed with a coarser sanding grit 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.

Layer 1 Mixing / Application



- | | |
|-------|---------------------------------|
| 100 | Autowave Optima MM Layer 1 |
| 10-30 | Autowave Optima WB Activator(s) |



Spray gun set-up:

- 1.2-1.3mm
- 1.4 HT conditions

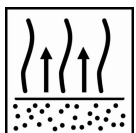
Application pressure:

- 1.7-2.0 bar at the air inlet
- HVLP max 0.6-0.7 bar at the air cap



Apply Layer 1 until complete hiding, 1 + 0.5 coats with no flash-off between each coat

Note: ensure a smooth transition from the ground-coat (layer1) color to the OEM end color



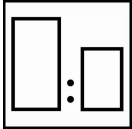
Flash off by increasing airflow until completely dry after each coat
 Has to be flashed off until completely dry before application of Wet Bed and layer 2



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Wet Bed Mixing / Application



60	Autowave Optima Blending Agent
40	Autowave Optima MM Toner C063
25	Autowave Optima WB Activator(s)

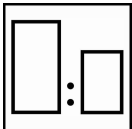


Spray gun set-up:	Application pressure:
1.2-1.3mm	1.7-2.0 bar at the air inlet
1.4 HT conditions	HVLP max 0.6-0.7 bar at the air cap



Apply 1 full wet coat with no flash-off before application of layer 2

Layer 2 Mixing / Application

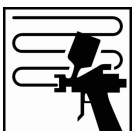


100	Autowave Optima MM Layer 1
50	Autowave Optima WB Activator(s)



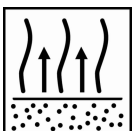
Spray gun set-up:	Application pressure:
1.2-1.3mm	1.7-2.0 bar at the air inlet
1.4 HT conditions	HVLP max 0.6-0.7 bar at the air cap

Note: Adjust the fluid needle setting from fully closed to one full turn out



Apply the number of required layer 2 coats as per sprayout selection

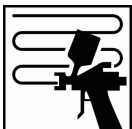
Apply each coat as a mist coat



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

Flash-off until completely matt and dry before application of clearcoat

Clearcoat



Apply clearcoat as per TDS

See Technical Data Sheet of clearcoat selected

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Akzo Nobel Coatings LTD

Address: Unit 2B, Didcot Park
Churchward, Southmead Industrial Estate
Didcot, Oxfordshire, OX11 7HB
Tel: +44 (0)1235 862226

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Head Office

AkzoNobel Car Refinishes B.V., PO Box 3 2170 BA Sassenheim, The Netherlands. www.sikkenscr.com