


# Autowave Optima MAZ46G Machine Grey

FOR PROFESSIONAL USE ONLY

## Definition and description

	<p>Machine Grey 46G is one of Mazda's state of the art finishes to compliment Kodo design using its Takuminuri paint technology. The repair of this color is based on the standard 2 stage TDS application with an additional 2-3 over thinned basecoat layers, this to achieve it's specific fine effect and finish of this particular color.</p> <p>The description of this color by Mazda is:</p> <p><i>"This color gives the impression that the vehicle's body has been sculpted from a solid steel ingot"</i></p>
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The following steps are mandatory to meet the appearance of the original car color:

## Preparation of the substrate before Basecoat color application

The preparation of this particular color with it's fine metallic is of utmost importance. To avoid the visibility of disoriented fine metallic, sanding the blending areas with fine grit P1500 or P2000 is mandatory.

### Application over sanded (Dark Grey / black) filler:

Remove any texture by sanding the filler with P500 / P600 followed by P1000 as a minimum, degrease and proceed with the application of the 46G color.

### Preparation of the blending area on the original clearcoat:

Remove any texture by sanding the original clearcoat with P1200 and finish with P1500 as a minimum.

## Surface preparation

### Filler area



Final sanding step P1000

- Initial sanding steps may be executed with a coarser sanding grit ( P500 – P600)
- Remove (orange peel) structure of the filler

### Wet bed preparation blending area



Final sanding step P1500

- Initial sanding steps may be executed with a coarser sanding grit (P1000 or P1200)
- Remove (orange peel) texture of the OEM clearcoat



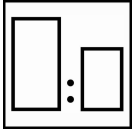
### Surface cleaning

Remove any surface contamination using an appropriate surface cleaner.

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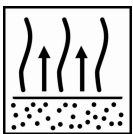
## Autowave Optima Wet Bed



- 60 Autowave Optima Blending Agent
- 40 Autowave Optima C063
- 20 Autowave Optima WB Activator

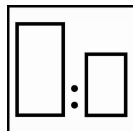


Apply one flowing coat of Autowave Optima Wet Bed

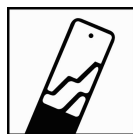


Flash-off by increasing airflow until completely dry

## Autowave Optima MM MAZ46G mixing and application



- 100 Autowave Optima MM
- 10 - 20 Autowave Optima WB Activator

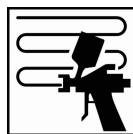


Use Sikkens measuring stick  
**14** Blue



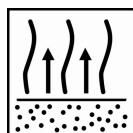
Spray gun set-up:  
 12.mm - 1.3 mm

Application pressure @ spraygun inlet  
 1.7 - 2.2 bar (25-29 psi)



Application metallic color:

2 x 1 coat no flash-off between coats  
 Followed by a drop coat after flash - off



Before Drop Coat:  
 Until completely matt and dry

Prior to clearcoat application:  
 Until completely matt and dry

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

The coarseness and effect may differ due to different models/production locations, and therefore we advise to produce a set of 4 sprayout panels applied over a SGS5 - black filler sanded with a minimum of P1000 grit

**Application:**

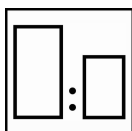
Place the 4 sprayout panels next to each other:

- 1<sup>st</sup>. Apply Autowave Optima MM MAZ46G according to TDS on all panels including a final drop-coat.  
Remove and store 1 panel marked as number 1.
- 2<sup>nd</sup>. Add 200% of WB Activator to the applied Autowave Optima MM MAZ46G (100:10 - 20 mixture) mixed color and apply as explained below.  
Apply the overthinned mixture as a standard drop coat application over the remaining 3 panels with an increased distance during application.  
Remove 1 panel and mark it as number 2
- 3<sup>rd</sup>. Apply the overthinned mixture as a standard drop coat application over the remaining 2 panels with an increased distance during application.  
Remove 1 panel and mark it as number 3
- 4<sup>th</sup>. Apply the overthinned mixture as a standard drop coat application over the remaining panel with an increased distance during application.  
Remove the panel and mark it as number 4

**Note:** ensure to use the same application technique on the vehicle!

After the final drop coat / control coat leave the basecoat to flash off completely, and / or cure for 10 minutes at 60°C and leave to cool down before applying the clearcoat

**Autowave Optima MM Mazda 46G Finer Effect: Mixing and application**



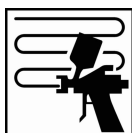
100 Autowave Optima MM MAZ46G RTS  
 200 Autowave Optima WB Activator



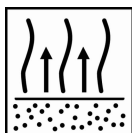
Use Sikkens measuring stick  
 Or use scale



Spray gun set-up: Application pressure @ spraygun air inlet  
 1.2mm - 1.3 mm 1.7 - 2.2 bar (25-29 psi)



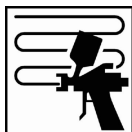
Application finer effect layers\* 1-3 drop coats\*  
 \*Increase distance during application, apply coats in an even layer taking care not to overapply \*Due to the low viscosity, shake spraygun prior to application of the next coat



Between coats: Prior to clearcoat application:  
 Until completely matt and dry Bake for 10 minutes @ 60°C. prior to clearcoat.

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Clearcoat application  
 See clearcoat T.D.S.

With the application of the clearcoat, apply a thin closed 1<sup>st</sup> layer



Use suitable respiratory protection

Akzo Nobel Car Refinishes recommends the use of a fresh air supply respirator.

## Useful tips:

### Preparation:

The recommended preparation of the substrate with this 46G color is mandatory. The substrate has to be flat and smooth, any structure and/or too coarse scratches in the OEM clearcoat will be visible after clearcoat application, especially with blending of the overthinned color on the OEM finish.

Therefore: to avoid disorientation of the fine metallic, the use of a fine sanding grit as described is of utmost importance for the preparation of the substrate

**Preparation filler substrate:** abrade with a minimum grit of P1000 and ensure to remove all texture.

It is advised to apply a wet bed (pre-coat) over the prepared blending area of the OEM clearcoat, abrade blending area with P1500 minimum and ensure that all texture of the OEM clear-coat is removed, after removing dust and degreasing the substrate, apply one smooth closed flowing layer Autowave Optima Wet Bed as described.

### Application in general:

-After application of every single basecoat layer completely flash off the basecoat before prior to the next layer

-Do not reduce pressure when applying the over-thinned effect layers.

-Apply the effect layers in cross coat application on larger areas

-Apply the first clearcoat layer not too heavy.

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