

# Autobase Plus

## MAZDA 46G Machine Grey RM

FOR PROFESSIONAL USE ONLY

### Definition and description

**Mazda 46G Machine Grey** is a special effect color which contains a special fine Bright Aluminium. This Aluminium, due to its nature, is transparent, therefore a foundation coat is required.

- Basecoat Foundation color (Is used for hiding the primer & is also useful for scratch filling)
- Basecoat Effect color
- Clearcoat

### Color check

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

The color depends on the basecoat foundation (layer 1) and number of coats applied of effect color (layer 2) due to it's transparency

Application technique and temperature will also impact on final color accuracy.

Use suggested gun set ups / application techniques to achieve the best possible color accuracy while minimizing cloudiness & mottling.

See section: *Spray gun set up & application*

- Apply the foundation color until opacity is achieved over 2 spray-out panels.
- Apply 2 medium coats and an orientation coat to panel sample 1
- Apply 3 medium coats and an orientation coat to panel sample 2

NOTE: Excessive or too dry orientation coat will result in a more coarse metallic STRUCTURE!

Follow recommended flash off times between coats.

Allow for a 10-15 minutes flash-off time at 25°C prior to clearcoat application.

Apply two single layers of clearcoat.

The operator 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.

### Surface preparation



**Primer Area:** Final sanding step of primer needs to be P600 dry.

**Note:** Please be aware that the final topcoat is sensitive to sanding scratches, therefore use your foundation color over sanded primer areas.

**Basecoat Blend Area:**

Final sanding step P800 - P1000 dry

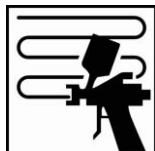
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## Mixing & Application

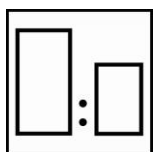
### Method:

- Step 1.** Apply Autobase Plus Blending agent to the blend areas
- Step 2.** Apply Foundation/groundcoat(s)
- Step 3.** Apply Final layer 2 coat(s)
- Step 4.** Apply Clear Coat after flash off



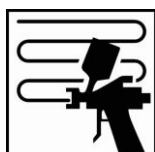
Apply 1 flowing coat of Autobase Plus Blending agent (RTS) to the blend areas.

Allow to flash-off completely



100 parts foundation/groundcoat color (*Layer 1*)  
50 parts Plus Reducer

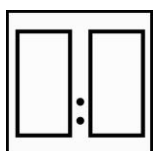
*Note: Select the correct reducer in relation to object size, ambient temperature and air flow around the object. See TDS S1.03.02*



Apply 2 single coats to the primer area or until opacity is reached.  
Extend the second coat over the edge of the previous coat.

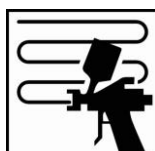
Blending foundation color:

Mix the RTS Autobase Plus solid foundation/groundcoat color 100:100 with Plus Reducer .



100 parts effect color (*Layer 2*)  
100 parts Plus Reducer

*Note: Select the correct reducer in relation to object size, ambient temperature and air flow around the object. See TDS S1.03.02*

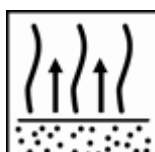


Apply 2-3 medium coats, and gradually extend into fade-out areas  
Apply 1 orientation coat (and simultaneously finish fade-out areas)

*Note:*

*Use a tack cloth between coats. (In case of metallic standing up)*

*\*Respect flash times between coats*



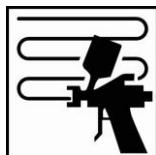
Before clearcoat application, allow to completely flash-off & dry

Option 1: 20 minutes at 25°

Option 2: Heat up the spraybooth for 10 minutes at 60°C and then allow to cool down

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All current Sikkens clearcoats  
With the exception of;  
Autoclear LV Superior  
Autoclear Aerodry

## Equipment

Spray gun Type	Devilbiss GTi Pro	Devilbiss Pro Lite	Iwata WS400
Air cap	110	TE20	LS400-05 HVLP
Fluid tip size	1.3	1.3	1.3
Fluid adjustment Air pressure 2-3 medium coats	2 ½ turns out 1.7 bar	1 ½ turns out 1.5 bar	2 ½ turns out 1.8 bar
Fluid adjustment Air pressure Orientation (drop coat)	1 turn out 1.2 bar	1 turn out 1.2 bar	1 ¾ turns out 1.5 bar

### Important Note:

For effect color, an approximate spray gun distance to panel is 30cm with an 80% overlap. This will help effect color to be applied evenly.  
Apply medium to wet coats reducing mottle and dry overspray.

\*Avoid dry dusty coats, since this will create more texture and metallic sparkle.

\*On all the body samples we received, the metallic orientation and structure was quite flat.

\*Structure and sparkle may vary on different models!

\*Fade-out is always recommended!

### Note:

In some cases it may be difficult to blend into large flat areas due to color and coarseness variation. For example: you may be required to refinish multiple adjacent panels for a minor repair depending on the damaged area.

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## Machine Grey Local Formulations

Foundation/groundcoat Color	
Toner	1Litre (Absolute weight Grams)
Q140	439.0
Q065	247.8
Q120	390.2

Mazda 46G AUS – Autobase Plus RM (May 2021)	
Toner	1Litre (Absolute weight Grams)
*Q878SA (Non Standard toner)	508.9
Q671	4.3
Q680	19.7
Q673	30.3
Q766	35.6
Q065	101.3
Q140	249.4

### Important Note:

\* Q878SA is a Non Standard MM toner.

Contact your local distributor to order \* Q878SA toner or 46G Machine Grey as a Readymix Color .

**Akzo Nobel Pty Ltd T/A Akzo Nobel Car Refinishes Australia**  
**Address: Unit 3/344 Lorimer Street, Port Melbourne, VICTORIA, 3207**  
**Tel: +61 3 9644 1711**

### FOR PROFESSIONAL USE WITH SUITABLE HS&E EQUIPMENT

**IMPORTANT NOTE** The information in this data sheet is not intended to be exhaustive and is based on the present state of our knowledge and on current laws: any person using the product for any purpose other than that specifically recommended in the technical data sheet without first obtaining written confirmation from us as to the suitability of the product for the intended purpose does so at his own risk. It is always the responsibility of the user to take all necessary steps to fulfill the demands set out in the local rules and legislation. Always read the Material Data Sheet and the Technical Data Sheet for this product if available. All advice we give or any statement made about the product by us (whether in this data sheet or otherwise) is correct to the best of our knowledge but we have no control over the quality or the condition of the substrate or the many factors affecting the use and application of the product. Therefore, unless we specifically agree in writing otherwise, we do not accept any liability whatsoever for the performance of the product or for any loss or damage arising out of the use of the product. All products supplied and technical advices given are subject to our standard terms and conditions of sale. You should request a copy of this document and review it carefully. The information contained in this data sheet is subject to modification from time to time in the light of experience and our policy of continuous development. It is the user's responsibility to verify that this data sheet is current prior to using the product.

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