

Autowave 2.0 Mazda 46G Machine Grey

FOR PROFESSIONAL USE ONLY

Definition and description



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.

The description of this color by Mazda is:

"This color gives the impression that the vehicle's body has been sculpted from a solid steel ingot"

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:

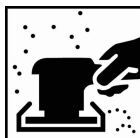
Remove any texture by sanding the filler with P500 followed by P1000 as a minimum, degrease and proceed with the application of the 46G color.

Preparation of the blending area on the original clearcoat:

Remove any texture by sanding the original clearcoat with P1500 grit as a minimum. Apply a single flowing coat of AW666 or a mixture of AW666/AW600 as a pre-coat and leave to flash off completely.

Surface preparation

Filler area



Final sanding step P1000

- Initial sanding steps may be executed with a coarser sanding grit (P500 – P800)
- Remove (orange peel) structure of the filler

Wet bed preparation blending area (60 parts AW666 : 40 parts 600) or AW 666 toner (recommended)



Final sanding step P1500

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



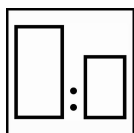
Surface cleaning

Remove any surface contamination using an appropriate surface cleaner.

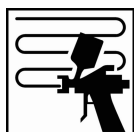
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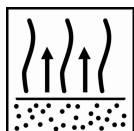
Autowave Pre coat / wet bed, mixing and application



100 Autowave MM666
 or
 100 Autowave MM666 / MM600 (60%/40%)
 20 Activator WB

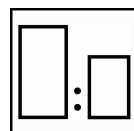


Apply one flowing coat of Autowave MM666 or mixture MM666 / MM600 to the entire area under repair.



Flash-off by increasing airflow until completely dry.

Autowave MM 2.0 MAZ46G mixing and application

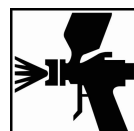


100 Autowave MM / 2.0 MAZ 46G
 20 Activator WB



Use Sikkens measuring stick

14 Blue



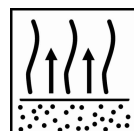
Spray gun set-up:
 1.3 mm

Application pressure:
 1.7 bar at the air inlet
 HVLP max 0.6 bar at the air cap



Application metallic color:

2 x 1 coat followed by a Drop-coat*
 * Autowave MM 2.0 application



Between coats:

Until completely matt and dry
 *Tack cloth between coats removing dry overspray

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 black filler sanded with a minimum of P1000 grit.

Application:

Place the 4 sprayout panels next to each other, dry completely between every coat:

1st. Apply Autowave MM 2.0 MAZ46G according to TDS on all panels including a final mist-coat.
 Remove and store 1 panel marked as number 1.

2nd. Add 100-200% of Activator WB to the applied Autowave MM 2.0 MAZ46G (100:20 mixture) mixed color and apply as explained below.
 Apply the overthinned mixture as a standard mist- application over the remaining 3 panels with an increased distance during application approx (50cm) Note: Do Not reduce the air pressure.
 Remove 1 panel and mark it as number 2

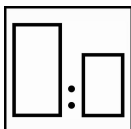
3rd, Repeat the overthinned mist-coat application over the remaining 2 panels
 Remove 1 panel and mark it as number 3

4th. Repeat the overthinned mist-coat application over the remaining panel
 Remove the panel and mark it as number 4

After the final mist-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
 Please ensure to use the same application technique on the vehicle!

When applying each additional 100-200% overthinned mist-coat layer, the color will appear slightly lighter and finer on the face and darker on the flop.

Autowave MM 2.0 Mazda 46G extra effectlayers: Mixing and application



100 Autowave MM / 2.0 MAZ 46G RTS

100 - 200 Activator WB *Note: in dry hot conditionss above 30°C, 200% activator is suggested



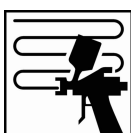
Use Sikkens measuring stick
 Or use scale



Spray gun set-up:
 1.3 mm

Application pressure Autowave MM/2.0:
 1.7 bar

*Do not reduce air pressure!

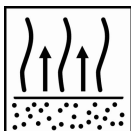


Application effect layers*

1-3 mist coats*

*Increase spray gun distance approx (50cm) from panel during application, apply coats in an even layer taking care not to overwet or overapply

*Due to the low viscosity, shake spraygun prior to application of the next coat



Between coats:
 Until completely matt and dry

Prior to clearcoat application:

Bake for 10 minutes @ 60°C. prior to clearcoat.

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Suitable Clearcoat: Autoclear® LV Superior

See clearcoat T.D.S. S1.05.01

With the application of the clearcoat, apply a thin closed 1st layer, followed by a full wet coat.



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 MM666 or the mixture MM666/MM600 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.

*Do NOT add Autowave 2.0 hardener if you intend to overcoat with clearcoat.

This will make metallic structure too COARSE.

(However it is OK to use 10% hardener in Engine bays without clearcoating.)

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