

Carbon Paint Process

FOR PROFESSIONAL USE ONLY

Description

This bulletin describes the optimum repair system for carbon substrates.

Surface Preparation (Non-visible Carbon)



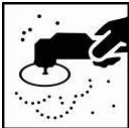
The surface first must be cleaned with warm water and pH neutral cleaner.

*Note: In case of **New parts**, pre-bake for 30 minutes @ 60°C and completely cool down*



Degrease using M200: See TDS S4.03.01
 then use, M700 Anti Static Silicone Remover: See TDS S4.02.02

Always use 2 cloths, the surface has to be cleaned with the selected surface cleaner using a clean cloth. Immediately thereafter, the surface has to be wiped dry thoroughly with another clean high quality absorbent degreasing cloth.



Abrade the substrate as recommended by machine using P280 / P320 grit.

Note: Careful NOT to sand through the resin exposing the carbon fiber filaments



Abrade by hand with Scotch Brite Red in difficult to reach areas



Blow off with compressed air and check for pinholes!

- ****In case pinholes are found, wipe in MM444 matting paste with a lint free cloth, making sure to work the paste into the pinholes.**
- Allow to dry for 15-20 minutes until powdery.
- Gently sand off the MM444 residue, taking care to leave the filler in the pinholes.
- Then blow off dust with compressed air.



Degrease using M700 Anti Static Silicone Remover

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Primer



Apply Colorbuild Plus Sanding version

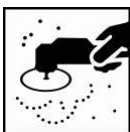
Note: Respect recommended flash-off and drying times. See TDS S2.02.02



Use suitable respiratory protection

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

Read complete TDS for detailed product information



Abrade the primer filler using P500



Degrease using M700 Anti Static Silicone Remover

Final clean with Waterborne Cleaner M200 when applying Autowave MM 2.0

Basecoat



Apply Sikkens basecoat as per TDS recommendations.

Clearcoat



Apply Sikkens clearcoat as per TDS recommendations



Optional:

In case of a matt finish use the Mix and Matt swatch to determine the gloss level



Apply Autoclear Mix & Matt as per TDS recommendations in the required gloss level

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Surface Preparation (Visible Carbon)



The surface first must be cleaned with warm water and pH neutral cleaner.

*Note: In case of **New parts**, pre-bake for 30 minutes @ 60°C and completely cool down*



Degrease using M200: See TDS S4.03.01
 then use, M700 Anti Static Silicone Remover: See TDS S4.02.02

Always use 2 cloths, the surface has to be cleaned with the selected surface cleaner using a clean cloth. Immediately thereafter, the surface has to be wiped dry thoroughly with another clean high quality absorbent degreasing cloth.



Abrade the substrate as recommended by machine using P400-P500.

Note: Careful NOT to sand through the resin exposing the carbon fiber filaments



Abrade by hand with Scotch Brite Red in difficult to reach areas



Degrease using M700 Anti Static Silicone Remover

Allow a minimum of 15 minutes at 20°C prior to next steps

Primer

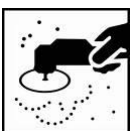


Apply Autoclear Rapid. See TDS S1.05.04

* Clearcoat is used as a primer, because of visible carbon.



After the stated flash off time dry for 45 minutes at 60°C.



Abrade the clear "primer" using P500-P800 grit.

- Take care not to sand through!
- Abrade with Scotch Brite Grey in difficult to reach areas.

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Clean the complete panel carefully as the surface is still sensitive; *avoid using solvent borne silicon removers. Waterborne Cleaner M200 are the preferred one, optional clear demineralized water can be used as well.*

Clearcoat



Apply Sikkens clearcoat as per TDS recommendations



Optional:

In case of a matt finish use the Mix and Matt swatch to determine the gloss level



Apply Autoclear Mix & Matt: See TDS S1.05.19

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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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