

Nissan KAB Ultimate Metal Silver

FOR PROFESSIONAL USE ONLY

Definition and description

The repair system for NIS KAB Ultimate Metal Silver consists of three different layers creating a special colour effect, based on

- 1st step: Application of the Colorbuild Plus foundation colour.
- 2nd step: Application of Autowave MM666 / MM600 (60:40) followed by the Autowave effect colour.
- 3rd step: Application of the clearcoat to provide gloss and protection.

Preparation

Repair with recommended bodyfillers and / or undercoats, preferably Colorbuild Plus CBP006 Light Grey.

Surface preparation

Colorbuild Plus area



Final sanding step P500

- Initial sanding steps may be executed with a coarser sanding grit; P360 - P400
- Respect a maximum 100 sanding grit step difference or less throughout the sanding procedure.
- For detailed surface preparation see TDS S8.06.02

Note: The final topcoat is sensitive to sanding scratches, therefore use colorbuild Plus Non Sanding CBP006 (Light Grey) over sanded primer areas.

Autowave MM666 / MM600 area



Final sanding step P1000 Dry

- Blend areas final sanding P1000 dry
- For detailed surface preparation see TDS S8.06.02

*Take care when sanding blend area's as the final topcoat is sensitive to sanding scratches

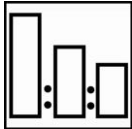


Surface cleaning; remove any surface contamination using an appropriate surface cleaner.

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Colorbuild Plus foundation colour

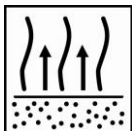


100	Colorbuild Plus CBP006 (+ 10% Elast-o-Actif or Autoclear LV Superior Fast)
25	Colorbuild Plus Hardener Non Sanding
35	Colorbuild Plus Reducer Non Sanding

For detailed information on the amount of Elast-o-Actif, see TDS S8.06.03c

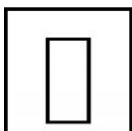


Apply Colorbuild Plus to the area under repair until opacity is achieved.



Allow each coat to flash-off naturally until the surface is completely matt.

Do not force-dry by air support.

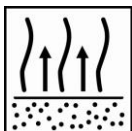


For blending of the foundation color use Plus Reducer



Dissolve the overspray edge with Plus Reducer

Note: Make sure the edge is as smooth as possible!



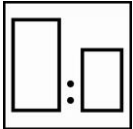
Allow to flash-off naturally until the surface is completely matt, do not force-dry by air support.



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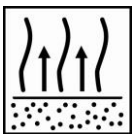
Autowave effect colour



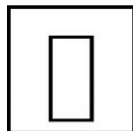
100 Autowave MM666 / MM600 (60:40)
 10-20 Activator WB



Apply one even closed wet coat of Autowave MM666/MM600 (60:40) to the entire area under repair.



Flash-off by increasing airflow and or heat until completely dry.
If necessary allow the surface to cool down.



Autowave NIS KAB Ultimate Metal Silver
RFU

*Temperatures above 28°C may require the addition of 10% activator WB to the color, though this will impact the opacity as this may require extra layers.



Stir thoroughly before use



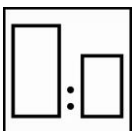
Spray gun set-up: 1.3 mm Application pressure Autowave NIS KAB Ultimate Metal Silver
 1.7 bar
 *Do not reduce air pressure!



First apply a 25% layer of Autowave NIS KAB slightly extending the Colorbuild Plus area and allow to dry.
 Next apply five 75% layers to achieve opacity. Make sure each layer exceeds the previous one. After each layer take sufficient flash off into account.

"Optional" effect colour application

Note: In case the metallic effect colour appears too coarse proceed by following the below final effect coat application steps. This final step will decrease the coarsness of the effect colour appearing finer and reduce any mottle/cloudiness improving final appearance.



100 Autowave NIS KAB Ultimate Metal Silver
 50 Activator WB

**By stick or weight*
Note: Temperatures above 28°C may require additional Activator WB



Stir thoroughly before use

Nissan KAB Ultimate Metal Silver

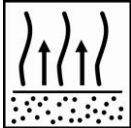
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Application effect layers*

Apply 2 mist coats by increase spray gun distance approx (50cm) from panel during application, apply coats in an even layer taking care not to overwet or overapply. Do NOT reduce air pressure

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



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

Option 1: 30 minutes at 25°

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

Humidity and airflow will influence the Autowave flash-off and drying times.

Clearcoat



Apply Autoclear LV Superior according to the respective TDS.

Important Note:

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

*Tack cloth between coats to help minimize texture especially blend / fade-out areas

*Avoid spraying Nissan KAB Ultimate Metal Silver in extreme heat as this will impact on texture, metallic sparkle & cloudiness.

*Surface preparation is critical as color is sensitive to sanding scratches

*To reduce mottle/cloudiness or effect colour coarsness proceed with the optional application method.

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