

Autobase® Plus Three Stage System

FOR PROFESSIONAL USE ONLY

Definition and Description

An Autobase Plus three stage systems consists of three separate applied layers creating a special color effect, based on;

- 1st step: Application of the solid or metallic Autobase Plus foundation color.
This foundation coat can also be an prescribed Colorbuild primer
- 2nd step: Application of the Autobase Plus translucent, solid or pearl effect color (Final/Mid coat).
- 3rd step: Application of the clearcoat to provide gloss and protection.

The term spot repair is understood to include all repairs to damaged areas resulting in the repaired area blending invisibly into the still intact existing finish. As a result, the car refinisher is not compelled to spray large panels in the case of minor damage. The spot repair technique also enables minor differences in color and effect between the original car finish and the repair to be made invisible.

Color check by spray out samples

Correct color match needs to be determined by producing a number of color spray-out samples, the color changes dependent on the number of coats applied of the effect color. Proceed as follows:

1. Apply the foundation color until opacity is achieved on 5 different spray-out panels.
2. Next apply one single coat of the effect color to all panels.
3. Allow sufficient flash-off time and remove one panel before continuing this application process, resulting in spray-outs panels ranging with 1-5 coats of the effect coat.
4. Allow for a 10-15 minutes flash-off time at 25°C prior to clearcoat application.
5. For optimum flash-off, dry the panels for several minutes in a oven or during a drying cycle in the spraybooth.
6. Apply two single layers of clearcoat to all color spray-out panels, securing brightness and color depth.

The operator can determine the right color match by using these color samples.

- Number each panel, indicating the number of effect coats on the panel.
- Personal application differences makes it recommendable that each painter creates its own spray-outs.
- To obtain an accurate color match, spray the panels as if applying to a vehicle, i.e. place all spray-outs on one larger panel and spray complete panel for each coat.
DO NOT SPRAY EACH PANEL SEPARATELY.

Prior to painting

Preparation:

Although the aim is to keep a repair as small as possible, it is almost inevitable with any three stage pearl application to use an additional panel, required for color blend. This is caused mainly due to the multiple layers to apply, ensuring OEM color match.

Prior to preparation the decision has to be made on the number of panels (area required) to prepare.

Application foundation coat:

Decide the maximum distance for the foundation coat (consider sufficient additional space for blending the effect color) and apply until achieving full coverage. The third and optional fourth coat will be applied according the described methods, dependent on the type of foundation coat; Colorbuild, solid Autobase Plus color or metallic Autobase Plus color.

Apply the color blend of the foundation coat in such a way that a smooth transition is created from foundation color to the OEM color before proceeding with the application of the effect color.

Autobase® Plus Three Stage System

FOR PROFESSIONAL USE ONLY

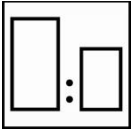
Prior to painting (continued)

Application effect color:

Decide the maximum distance for the effect color to be applied. Use the available area and do not keep the color blend unnecessary small. Then step back each subsequent coat until color is achieved.

When more coats are required for color match then indicated, then alternate the application with each layer of the effect color, thereby not overlapping in the same area.

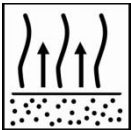
Autobase Plus solid foundation color



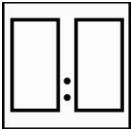
100 Autobase Plus foundation color
 50 Plus Reducers



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



Allow for a minimum flash-off time of 15 minutes at 20°C.



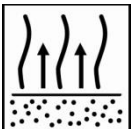
Blending foundation color (two options):

Mix the RTS Autobase Plus solid foundation color 100:100 with Plus Reducer
 Mix the RTS Autobase Plus solid foundation color 100:100 with the RTS pearl or solid effect color.



Apply one thin coat, gradually fading out this coat, facilitating a more uniform blend of the foundation color, and a smoother transition from the repair area to the OEM color.

In case of insufficient transparency add once more 100 parts RTS pearl or solid effect color into the Autobase Plus solid foundation RTS mixture, gradually fading out once more extending beyond the previous applied coat.



Allow for a minimum flash-off time of 15 minutes at 20°C.



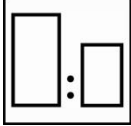
Use suitable respiratory protection
 Akzo Nobel Car Refinishes recommends the use of a fresh air supply respirator

Read complete TDS for detailed product information

Autobase® Plus Three Stage System

FOR PROFESSIONAL USE ONLY

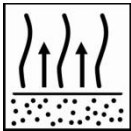
Autobase Plus metallic foundation color



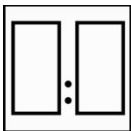
100 Autobase Plus metallic color
 50-80 Plus Reducers



Apply 1 full coat.
 Next apply an intermediate coat.
 *Only when needed, apply a drop coat (metallic orientation coat) by reducing the pressure to 1-1½ bar at the gun inlet and increase the distance while applying the drop coat with full trigger.



Allow for a minimum flash-off time of 15 minutes at 20°C.



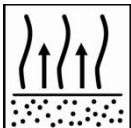
Blending foundation color:

Mix the RTS Autobase Plus metallic foundation color 100:100 with the RTS pearl or solid effect color.



Apply one thin coat, gradually fading out this coat, facilitating a more uniform blend of the foundation color, and a smoother transition from the repair area to the OEM color.

In case of insufficient transparency add once more 100 parts RTS pearl or solid effect color into the Autobase Plus metallic foundation RTS mixture, gradually fading out once more extending beyond the previous applied coat.



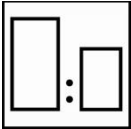
Allow for a minimum flash-off time of 15 minutes at 20°C.



Autobase® Plus Three Stage System

FOR PROFESSIONAL USE ONLY

Autobase Plus pearl or solid effect color

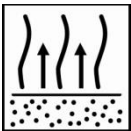


- 100 Autobase Plus pearl or solid effect color
- 50 Plus Reducers

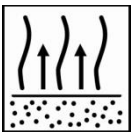


Apply the first coat of the effect color as far as possible from the repair area, within the maximum panel area. Next apply the pre-determined sequential numbers of coats, keeping each layer within the previous applied coat. Start by applying a thin coat, as if fading in, then building up the layer thickness as one comes closer to the repair area. Repeat this with each applied coat of the effect color.

- Apply the number of required coats, dependent on the spray-out sample selection.
- Do not lower the air pressure during application when applying the pearl or solid effect color.
- Alternate the application with each layer of the effect color, do not overlap in the same area.
- Application of the effect color must be executed similar as on the spray-out samples, ensuring similar layer thickness and color effect.
- Apply the indicated number of layers of the effect color until an even color appearance is achieved.



Allow for a minimum flash-off time of 15 minutes at 20°C between coats.



Allow for a minimum of 20-30 minutes final flash-off time at 20°C.

- Option 1; Allow for a minimum of 10-15 minutes final flash-off time at 40°C.
- Option 2; allow for a flash-off time of approximately 5-10 minutes at 60°C.
- When heat is used for drying, allow object to cool down to application temperature before clearcoat application.

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.

Brand names mentioned in this data sheet are trademarks of or are licensed to Akzo Nobel.

Head Office

AkzoNobel Car Refinishes B.V., PO Box 3 2170 BA Sassenheim, The Netherlands. www.sikkenscr.com