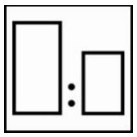
Application and Repair of Autobase Plus Red Tri -Stage Candy Colors

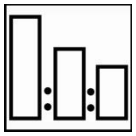
FOR PROFESSIONAL USE ONLY

Description

Sikkens Autobase Plus Ready Mix (RM) Groundcoat and Midcoat are a unique color package that requires a specialized blend of pigments and toners designed to provide a color match for Candy Colors. This balanced combination of products, along with step by step application instructions, provides the user a simpler method for obtaining an invisible repair.



Ground coat
100 parts by volume Autobase Plus RM Groundcoat
50 parts by volume Plus Reducer



Midcoat Color
100 parts by volume Autobase Plus RM Midcoat
25 parts by volume P25 Hardener
35 parts by volume Plus Reducer Fast, Medium

HVLP Gravity Compliant	1.3-1.5 mm	Max 0.7 bar at cap
Gravity	1.2-1.4 mm	Per manufacturer

Metallic Groundcoat Application
Apply 2-3 or until covered coats of the ground coat
If the basecoat appears uneven apply an orientation coat.

Midcoat Application
Apply 2-4 coats of the midcoat color.

Recoatable with Sikkens Clearcoats:
Autoclear Expert HS
Autoclear Xcel

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

Read complete TDS for detailed product information

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Suitable substrates

All existing OEM finishes
Sikkens preparatory products with thexeception of acid containing wash primers
Recommended Colorbuild Plus colors for maximum
coverage include:
CBP032
CBP037
2 parts CBP Black to 1 part CBP White by
volume

Product and additives

Product	Autobase Plus RM/MM Groundcoat Autobase Plus RM/MM Midcocat Note: Hardener must be added to the basecoat
Hardeners	P25 Hardener When applying over soft, foam spoilers, 5% of P25 Hardener can be added to Autobase Plus Groundcoat color prior to the addition of Plus Reducer.
Reducers	Sikkens Plus Reducer FAST Spot and panel repairs (21°C – 30°C) Sikkens Plus Reducer MEDIUM Larger areas and complete respray - temperature range (30°C – 35°C) Sikkens Plus Reducer SLOW For complete respray over 35°C

Basic raw materials

Autobase Plus RM Groundcoat – Physically drying binders
Autobase Plus RM Midcoat – Acrylic polyol binders
Plus Reducers – Special solvent blends
Hardeners – Polyisocyanate resin

Substrate preparation

Dry sanding
Initial sanding steps may be executed with a coarser sanding grit P320-P400. Final sanding steps use P500-P600.
Note: Respect a maximum 100 sanding grit step difference or less throughout the taken sanding steps.

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Wet sanding
Initial sanding steps may be executed with coarser sanding grit #P500. Final sanding step P600 to P800
Note: Respect a maximum 200 sanding grit step difference or less throughout the sanding steps.

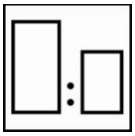
Surface Cleaning
M700 Anti Static Silicon Remover
M600 Degreaser

Product Agitation

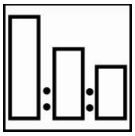
Autobase Plus Groundcoat and Autobase Plus Midcoat: vigorously shake by hand or on a shaker before use.

Autobase Plus Groundcoat and Midcoat must be stirred thoroughly before and after reduction.

Autobase Plus Reduction

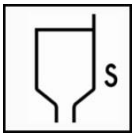


Add Plus Reducer to Autobase Plus groundcoat color prior to application using the following ratio:
100:50 parts Plus Reducer by volume



Autobase Plus Midcoat Color
100 parts by volume Autobase Plus Midcoat color
25 parts by volume P25 Hardener
35 parts by volume Plus Reducer FAST (Medium can be used for larger jobs or over 30°C)

Viscosity When Mixed



DIN Cup #4 at 20°C.
Autobase Plus RM Groundcoat at 100:50 ratio – 16-17 seconds
Autobase Plus RM/MM Midcoat at 100:25:35 ratio – 10-12 seconds

Pot-life when mixed

Autobase Plus Mixed Colors at 20°C.
Autobase Plus RM Groundcoat ready to spray: 6 months
Autobase Plus RM Midcoat ready to spray: 2 hours

Spray gun set-up / application pressure

HVLP Gravity Compliant	1.3-1.5 mm	Max 0.7 bar at cap
Gravity	1.2-1.4 mm	Per manufacturer

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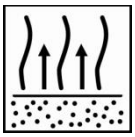
Application, Metallic 3 Stage – Full Panel or Complete

Primer Recommendations:
Recommended Colorbuild Plus colors for maximum coverage include:
CBP032
CBP037
2 parts CBP Black to 1 part CBP White by volume

Ground coat
1. Apply 2-4 coats or until opacity is reached.
2. The first coat is applied as a closed coat with a gun distance of 15 cm.
3. The 2nd-4th coats should be 80% closed with a gun distance of 15-20 cm from the panel, until coverage is achieved.
4. If the ground coat appears uneven, apply an orientation coat.
Allow a flash off time between coats of 3 to 5 minutes at 20°C. Flash time will be dependent on ambient temperature, applied paint wetness/thickness and available air-flow.



Flash Before Autobase Plus RM Midcoat
Allow groundcoat to flash for 15-20 minutes at 20°C before application of the Autobase Plus RM Midcoat color.

Midcoat Color
Apply 2-4 thin CLOSED coats of midcoat color with a gun distance of 15-20 cm from the panel until color is equal to original OE.
Note: The application must be consistent and even to avoid a cloudy appearance.
Altering the overlap areas between coats will help avoid darker areas between panels.
Allow a flash off time between coats of 3 to 5 minutes at 20°C flash time.

Flash Drying Before Clear-Coat
Allow midcoat to flash for 20-30 minutes at 20°C
If wanted the system can be baked for 15 minutes at 60°C (allow to cool), before application of clear coat.

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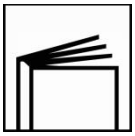
3 Stage Repair – Let-Down Panels

Let down panels are used as an aid to determine the number of midcoat layers needed to achieve a good color match for three stage colors and should be sprayed along with a larger surface.



The color of the groundcoat and the thickness of the midcoat determine the hue of three stage colors. Therefore the groundcoat color must be matched before assessing the midcoat. Some vehicles may have an area on the vehicle that has not had the second layer color applied.

This area can be used to confirm the accuracy of the first layer color.
When completed, your let down panel should also include an area that has not been painted with the second layer color. You can then use the let-down panel to assess both the first layer color and the midcoat color & application prior to painting the vehicle.

NOTE:

When spraying an actual repair stop one coat short of the estimated number of coats of the midcoat.

Using the midcoat side of the let-down do an evaluation of your progress and determine how many more coats of the second layer may be needed.

*USE SPOTLIGHT TO CHECK IF YOU HAVE ADEQUATE RICHNESS OF THE CANDY EFFECT IN BETWEEN COATS

Let-Down Panel Application

1) Apply the groundcoat to a spray-out panel and dry.
2) Mask off approximately 6 equal segments on the spray-out.
3) Apply midcoat to the first un-masked area.
   ***It is important to apply the midcoat exactly as you would if you were spraying a repair.**
   Flash dry.
4) Remove masking from the next application area and apply midcoat to the 1st application area and the 2nd.
5) Repeat until each area except one has been coated with midcoat color. Flash for 20 minutes.
6) Mask off 1/2 of the panel across the panel vertically.
7) Clearcoat the un-masked portion of the let-down panel.
8) Keep the panel for future use.

*Please note that separate sprayout cards can be used instead of masking off one card.

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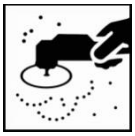
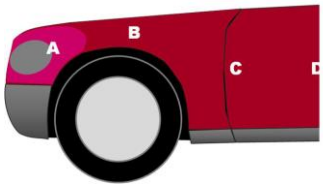
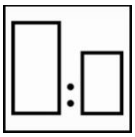
Application, Groundcoat - Metallic 3 Stage – Repair



Surface Prep
Sand area “A” using #P500-600 dry or #P600-800 wet.
Extend into area “B” 10-15 cm.
De-Gloss areas “C” and “D” with a D.A. using #P1000 dry and a 3M Interface pad or 3M Gray Scotch-Brite and BlendPrep and water.

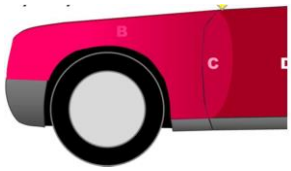




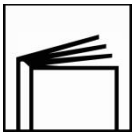
Application – Metallic Blending
Blending Agent should be utilized as a groundcoat to make layer 1 & 2 easier to blend and should be extended slightly beyond blend area.

Application – **Metallic Groundcoat**
Spray medium coats in areas “A” and “B” until covered.
Extend each coat slightly making the final coat fade into the original finish.
*Basecoat layers should be tacked between coats when performing a blend to avoid dry spray.

Application – **Metallic Blending Groundcoat**
Spray 1-2 single coats fading out into area “C”.
Note: Layer 1 must blend invisibly into the original finish.



When the 1st layer in a 3-Stage color is applied varying amounts of the original effect show through the application.
For this reason a corresponding amount of 2nd layer color most be applied to create a seamless repair. Therefore a staggered application is used.



Application – Midcoat (outside-in method may be useful)
Apply 2-4 thin closed coats of midcoat color with a gun distance of 15-20 cm from the panel until color is equal to original OE.

Apply additional coats if necessary to achieve color match to original OEM finish.

NOTE: if you spray wet coats of the 2nd Layer you may need to apply less coats.
Too WET coats will cause sagging (runs) in the midcoat, which will result in the need for baking and rectification will be necessay!

Take care on overlaps near door gaps.
Staggering overlaps is recommended to avoid “picture framing” effect (Darker on door gap area)

DO NOT use Tack Cloth on the MIDCOAT. There is a high chance you will deform it, which will result in baking and re-work!

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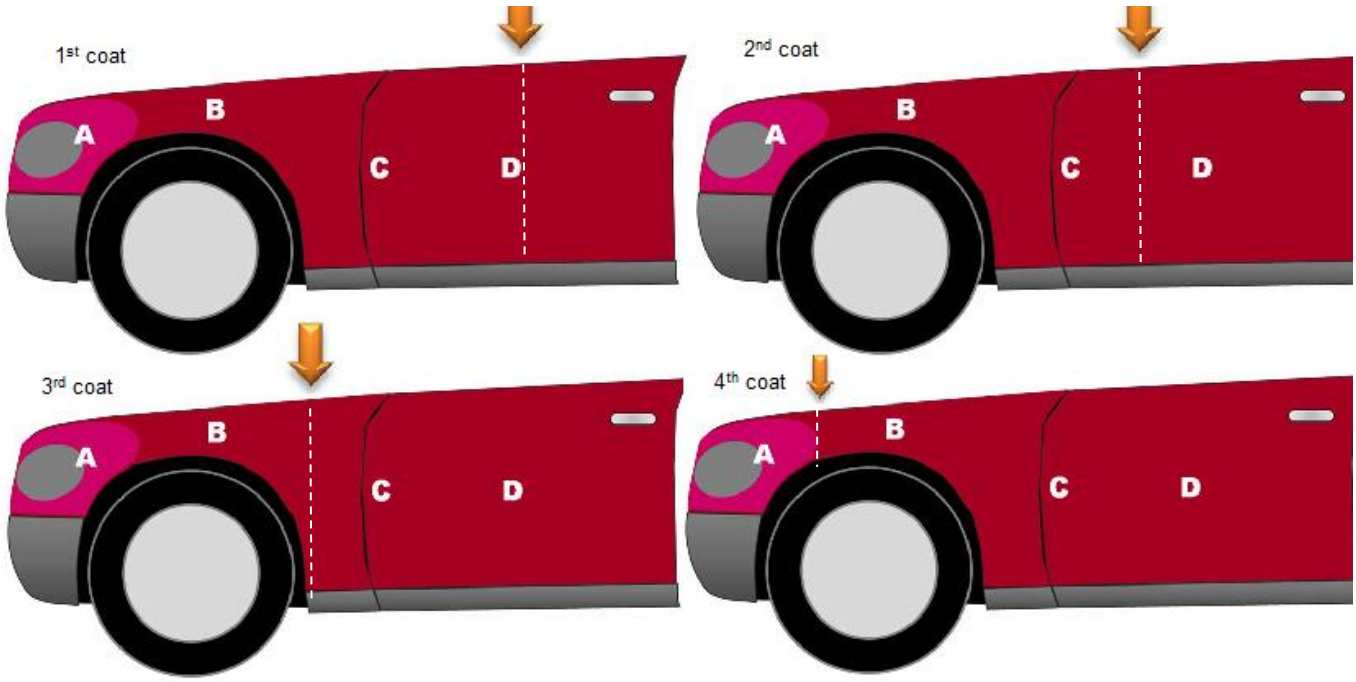
Application, Midcoat – Outside-in method 3 Stage – Repair (continued)



Film thickness – Using Suitable Application

8-10 µm per coat

Drying / Curing

Drying times are stated a recommended application method, film thickness and object temperature.

Allow Autobase Plus ground coat to dry for 15 to 20 minutes at 20°C before applying the midcoat. The maximum time Autobase Plus ground coat may be left before midcoat is 2 days.
Allow midcoat to flash for 20-30 minutes at 20°C or 15 minutes at 60°C (allow to cool), before application of clear coat. The maximum time the midcoat may be left before clearcoat is
12 hours.

Recoating

Autoclear Expert HS
Autoclear Xcel
See TDS

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Groundcoat Repair

If during the application of the Autobase Plus RM Groundcoat damage occurs:
1. Allow the Autobase Plus to flash off for 20 minutes at 20°C.
2. Lightly sand the damaged area with #P800 to #P1000 grit paper
3. Re-apply ground coat

Note: As there is no midcoat or clearcoat to protect the basecoat at this stage, care must be taken to clean up all sanding residue before re-application of basecoat.

MIDCOAT Repair

If during the application of the Autobase Plus MIDCOAT damage or dust ingress occurs:
1. Bake for 15 minutes at 60°C.
2. Lightly sand the damaged area with #P800 to #P1000 grit paper
3. Re-apply ground coat

Note: You cannot remove blemishes or dust ingress in the midcoat by sanding alone. This will reduce the thickness of midcoat layer in one spot resulting in a lighter area. You must re-apply Groundcoat, AND re apply MIDCOAT.

Cleaning of Equipment

Clean and rinse the spray gun thoroughly after use.

Theoretical Coverage

Theoretical coverage is dependent of many factors. These may include; the shape of the object, surface smoothness, application technique and other application variables among others. Calculations are done on ready to spray product at 25.4 micron dry film thickness and 100% transfer efficiency.

Autobase Plus RM/MM Groundcoat:	4.8 m^2/l
Autobase Plus RM/MM Midcoat mixed 100:25:35:	8.6 m^2/l

VOC

Ready to spray VOC:
Autobase Plus RM/MM Groundcoat: 788 g/L
Autobase Plus RM/MM Midcoat mixed 100:25:35 TBA

Notice: Do not handle until the Safety Data Sheets have been read and understood. Regulations require that all employees be trained on Safety Data Sheets for all chemicals with which they come in contact. The manufacturer recommends the use of an air-supplied respirator when exposed to vapors or spray mist.

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Product Storage

Product shelf-life is determined when products are stored unopened at 21°C.

Sikkens Autobase Plus RM/MM Groundcoat – 1 Year
Sikkens Autobase Plus RM/MM Midcoat – 1 Year
Sikkens P25 Hardener - 1 Year
Sikkens Autobase Plus Reducers - 4 years

Avoid extreme temperature fluctuation.

Product shelf life data see TDS S9.01.02

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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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