

Autowave[®] MM Optima – Blending Process

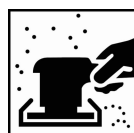
Description

The Autowave MM Optima is a comprehensive, one-stop, waterborne basecoat application system known for its excellent hiding properties. It facilitates the application of all basecoat layers using a wet-on-wet technique, without flash-off between coats, when blending and executing a spot repair. This one-stop application includes the use of a Wet-Bed prior to application of the color, allowing an invisible blend into the existing finish or adjacent panels.



P500
P600

Priming Filler area
Repair area



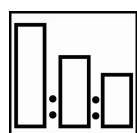
P1000

Blending area
OEM finish

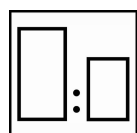


Surface
cleaning

Clean the surface to paint thoroughly removing all surface contamination using an appropriate cleaner



60 Autowave MM Optima Blending Agent
 40 C063 Converter (*stir thoroughly*)
 0-30 Activator WB (*stir thoroughly*)



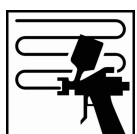
100 Autowave MM Optima color formula
 0-30 Activator WB (*stir to thoroughly*)



Spray gun set-up:
 1.2-1.3 mm
 1.4 HT/LH*

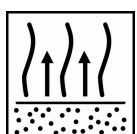
Application pressure: at spray-gun air inlet
 1.7-2.0 bar
 HVLP at the air cap 0.6-0.7 bar

**Select a wider set-up at low humidity and higher temperatures for optimal application*



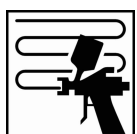
Wet-Bed
 1 full flowing coat
 No flash-off

Solid and Metallic Effect colors:
 1 coat
 No flash-off prior to basecoat application



Until completely matt and dry
 Before clearcoat application

Recoat time
 Maximum 24 hours at 20°C
 Should this maximum time be exceeded, abrade the surface and apply another coat



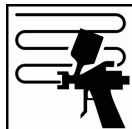
Sikkens clearcoats
 Autoclear LV Superior
 Autoclear 2.0

Autoclear Aerodry (*see WB Hardener section*)

Read the complete Technical Bulletin and the product Technical Data Sheet (TDS) for detailed product information.

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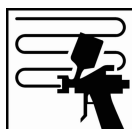
Autowave MM Optima Wet-Bed application



Wet-bed application (Blending Agent / C063 ConverterMix)

Apply a full wet flowing coat of the Wet Bed over the area where the color is to be blended.
Do NOT allow this wet-bed to flash-off; continue directly with the Autowave MM Optima color application

Autowave MM Optima color application

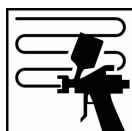


Solid color application

First, apply the color to the wet-bed area with a 15-20 cm panel distance, using an outside-in blending technique creating a smooth color transition, extend this coat the furthest into the wet-bed

Proceed directly by applying an even flowing wet coat (80% opacity) over the complete repair area and into the wet first coat. Apply at an 15-20 cm spray-gun distance
Ensure to close the edge between this coat and the first coat

Continue application of the final coat, an intermediate coat without any flash-off, reaching full opacity over the repair area, and into the first coat area, ensure to stay within the first coat blend area
Apply at an 15-20 cm spray-gun distance from the surface

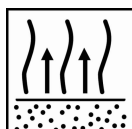


Metallic and effect basecoat color application

First, apply the color to the wet-bed area with a 20-30 cm panel distance, using an outside-in blending technique creating a smooth color transition, extend this coat the furthest into the wet-bed

Proceed directly by applying an even flowing wet coat (80% opacity) over the complete repair area and into the wet first coat. Apply at an 15-20 cm spray-gun distance
Ensure to close the edge between this coat and the first coat

Continue application of the final coat, an intermediate coat without any flash-off, reaching full opacity over the repair area, and into the first coat area, ensure to stay within the first coat blend area
Apply at an 20-30 cm spray-gun distance from the surface



Flash-off

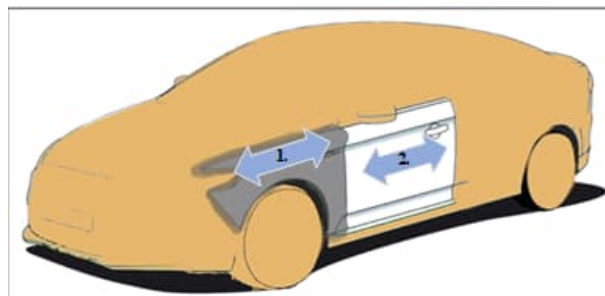
Allow the basecoat to flash-off until completely matt and dry before clearcoat application
Apply clearcoat within 24 hours at 20°C

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Area to repair, color blend into adjacent panel

1. New panel or area being repaired after damage
2. Adjacent panel prepared for blending the color

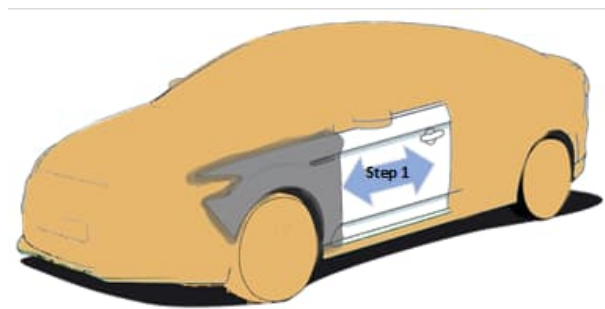


1. Wet-bed application (Blending Agent Mix)

Apply a full flowing coat of the Wet Bed over the area where the color is to be blended

Do NOT allow this wet-bed to flash-off; continue directly with the Autowave MM Optima color application

Wet-Bed allows for a smooth lay down of the Autowave MM Optima color

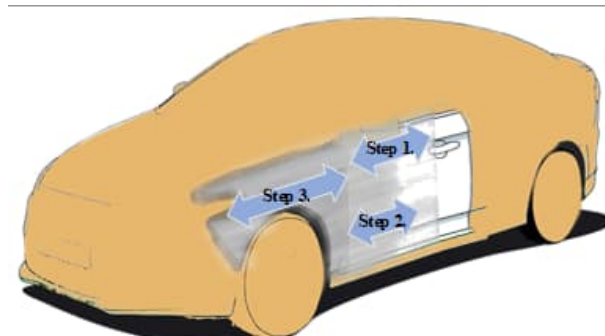


Solid color application

1. Apply the color to the wet-bed area with a 15-20 cm spray-gun distance, using an outside-in blending technique, extend this coat the furthest into the wet-bed

2. Apply at a 15-20 cm spray-gun distance, directly by applying an even flowing wet coat (80% opacity) over the complete repair area and into the wet first coat.. Ensure to close the edge between this coat and the first coat

3. Apply at a 15-20 cm spray-gun distance, application of the final intermediate coat without any flash-off, reaching full opacity over the repair area, and into the first coat area, ensure to stay within the first coat blend area

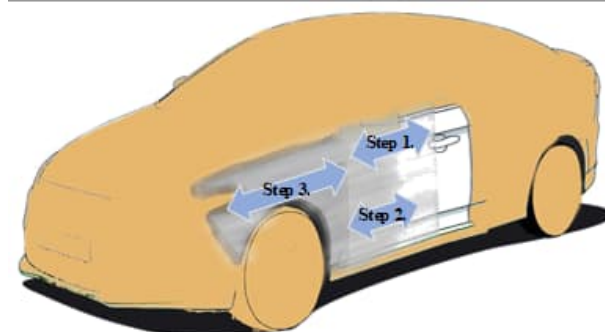


Metallic – Effect color application

1. Apply the color to the wet-bed area with a 20-30 cm spray-gun distance, using an outside-in blending technique, extend this coat the furthest into the wet-bed

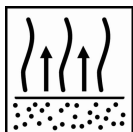
2. Apply at a 15-20 cm spray-gun distance, directly by applying an even flowing wet coat (80% opacity) over the complete repair area and into the wet first coat.. Ensure to close the edge between this coat and the first coat

3. Apply at a 20-30 cm spray-gun distance, application of the final intermediate coat without any flash-off, reaching full opacity over the repair area, and into the first coat area, ensure to stay within the first coat blend area



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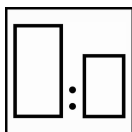
Flash-off

Allow the basecoat to flash-off until completely matt and dry before clearcoat application
Apply clearcoat within 24 hours at 20°C

Additional Information

Enhance transparency – support color blendability

Although the Autowave MM Optima colors are generally easy to blend it's color opacity and covering strength can be reduced, if desired, for easier blending by adding the RTS Blending Agent Mix.



100 Mixed Autowave MM Optima color – Mixed RTS
30 Wet Bed Mix - RTS

This diluted color can be applied according described recommendation in this Technical Bulletin.

Color blending after denibbing

What to do in case of dust ingress or minor basecoat surface contamination.

Allow Autowave MM Optima to flash-off until completely matt and dry.

Lightly sand the basecoat surface with a P1000, preferably soft backed dry sanding paper.

Next, thoroughly remove any sanding dust residue before reapplying Autowave MM Optima.

1. Apply one flowing coat of the Wet-Wed" (No flash-off)
2. Apply the Autowave MM Optima basecoat color within the "wet-bed" by the recommended application without flash-off between coats.
3. Allow the basecoat to flash-off until completely matt and dry before clearcoat application



Wear appropriate personal protection equipment

Use suitable respiratory protection, the use of a fresh air supply respirator is recommended

VOC - 2004/42/IIb(d)(420)420

The EU limit value for this product (product category: IIB. d) in ready to use form is max. 420 g/liter of VOC.

The VOC content of this product in ready to use form is max. 380 g/liter.

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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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