Autowave Optima MAZ51K Rhodium White

FOR PROFESSIONAL USE ONLY

Definition and description

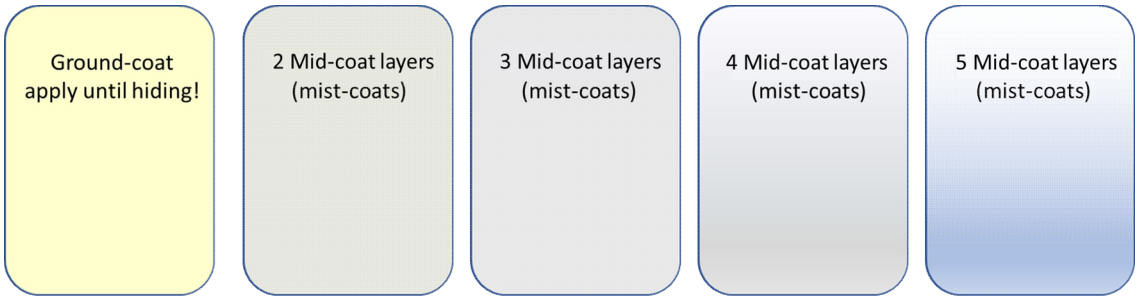
Mazda 51K is a three stage Autowave Optima MM basecoat system that consists of three separate layers to be applied to create this special effect color based on the following steps

1. Basecoat ground coat color (Layer 1) 2. Basecoat Effect color (Layer 2) 3. Clearcoat finish	

Color check by spray out samples

Correct color match needs to be determined by producing a number of color spray-out samples. The color is determined by achieveing full hiding of the ground coat color, then by applying a number of coats with the mid coat color to determine the correct color match. The correct process to determine the correct color match is as follows:

1. Mark the spray out panels on the back with the amount of Layer 2 to be applied
2. Distribute spray out panels evenly in the required number of panels usually 3-5
3. Apply a white filler
4. Apply the ground coat color until hiding on all panels as per basecoat TDS
5. Mask of all panels individually except one, should be masked in a way that after each layer the masking can be removed from one panel at a time
6. **Adjust the fluid needle setting from fully closed to one full turn out**
7. Next apply one single coat of Layer 2* color to the unmasked panel
   *** Layer 2 *should be applied by application of a mist coat***
8. Allow sufficient flash-off time of the Layer 2 and **remove the masking from one panel** before continuing
9. Next apply one single coat of Layer 2 to all panels
10. Repeat steps six and seven, this will result in 2 to 5 spray-out panels
11. Allow for a 10-15 minutes flash-off time at 75°F (25°C) prior to clearcoat application
12. Before clearcoat application mask of a part of the panel to show the final basecoat color (without Clearcoat) which can be used to check the color during the repair process
13. Apply two single layers of clearcoat



- By using these panels the technician can determine the right amount of layer 2 layers for a good color match
- Number each panel, indicating the number of Mid coats applied on the panel
- Personal application differences makes it recommended that each painter creates their 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.

- The application will vary depending on temperature, humidity and applicator and therefore could have an influence on the end color

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Suitable Substrates

All Existing OEM finishes
All current Sikkens preparatory products with the exception of Washprimers

Surface Preparation

Final sanding step P600

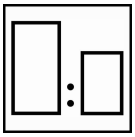
- Initial sanding steps may be executed with a coarser sanding grit; P400-P500
- Respect a maximum 100 sanding grit step difference or less throughout the sanding procedure
- For detailed surface preparation see TDS S8.06.02

Basecoat blend area
Final sanding step P1000

- Initial sanding steps may be executed with a coarser sanding grit P800
- Respect a maximum 200 sanding grit step difference or less throughout the sanding procedure
- For detailed surface preparation see TDS S8.06.02

Surface cleaning: remove contamination using an appropriate surface cleaner.

Layer 1 Mixing / Application



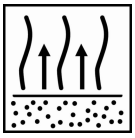
100	Autowave Optima MM Layer 1
10-30	Autowave Optima WB Activator(s) *(stir thoroughly)*

Spray gun set-up: (compliant)
1.2-1.3mm
1.4 HT conditions

Application pressure:
1.7-2.0 bar at the air inlet

Apply Layer 1 until complete hiding, 1 + 0.5 coats with no flash-off between each coat

Note: Ensure a smooth transition from the ground-coat (layer1) color to the OEM end color



Flash off until completely dry before application of the intermediate color coat

Extend flash-off time minimum 15 minutes at 25°C before layer 2 application

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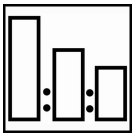
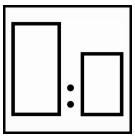
Intermediate layer & Wet Bed Mixing / Application (Mandatory when executing a spot repair / blending process)



Wet bed mixture

60	Autowave Optima Blending Agent
40	Autowave Optima MM Toner C063 *(stir thoroughly)*
25	Autowave Optima WB Activator(s) *(stir thoroughly)*



Intermediate mixture for a smooth colour transition

10	Autowave Optima MM layer 1 color (RTS)
90	Wet bed mixture (RTS) *(stir thoroughly)*

Note: A smooth flat surface is mandatory to have the metallic particles of the layer 2 consistently orientated.

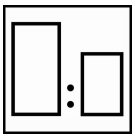
Spray gun set-up: (compliant)
1.2-1.3mm
1.4 HT conditions

Application pressure:
1.7-2.0 bar at the air inlet

Intermediate coat: Apply 1 full wet coat over the leading edge(s) of layer 1 for a smooth color transition. Flash off prior to applying the wet bed layer

Wet bed layer: Apply 1 full wet coat with no flash-off before application of layer 2

Layer 2 Mixing / Application



100	Autowave Optima MM Layer 2
50	Autowave Optima WB Activator(s) *(stir thoroughly)*

Spray gun set-up: (compliant)
1.2-1.3mm
1.4 HT conditions

Application pressure:
1.7-2.0 bar at the air inlet

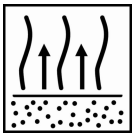
Note:

- **Adjust the fluid needle setting from fully closed to one full turn out**
- **Apply layer 2 at a minimum distance of 30 – 40 cm**

Apply the number of required layer 2 coats as per sprayout selection

Apply each coat as a mist coat

Do not over apply layer 2 and avoid over wetting of the layer(s)



Flash off by increasing airflow until completely dry after each mist coat

Flash-off until completely matt and dry before application of clearcoat

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Clearcoat

Before clearcoat application
Extend (double) the final flash-off time 30 minutes at 25°C is recommended before Clearcoat application
o Option 2; Allow 15-20 minutes final flash-off time at 40°C
o Option 3; Allow 10-15 minutes final flash-off time at 60°C
o When heat is used for drying allow object to cool down to application temperature before applying clearcoat, these times can also be reduced by increased air flow
Recoat time: Maximum 24 hours at 20°C
Should this maximum time be exceeded, abrade the surface and apply another coat.
See Technical Data Sheet of clearcoat selected

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

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