

OCTOBASE ECO PLUS SYSTEM: MAZDA 46G MACHINE GREY

PREPARATION



Colour check

Always determine the right colour and/or colour variant. This should be done at the earliest stage possible, preferably when estimation of the repair is done. Creating a spray-out at this stage is best practice. A multi layer colour requires multi spray cards one with two layers, one with three layers and one with four layers to identify the correct number of layers to use in a repair.

NOTE: Spraying to full hide can affect colour match.



Cleaning

Clean with TD20 Silicone Remover and/or TD80 Octobase Eco Degreaser.



Surface preparation

Use sanding paper grit P600 or finer on repair area, and P1500 on blending area.



Protection

Use suitable respiratory protection (fresh air supply respirator is strongly recommended).

STEP 1



Application

Apply W23 + 10% TW80 Octobase Eco Thinner @ 2,0 bar 29 psi over the blending area, this could also be applied over the entire repair area (optional).

	NOZZLE (MM)	AIR PRESSURE (PSI)
HVLP	1,1-1,3	2,0 bar / 29 psi
HE	1,1-1,3	2,0 bar / 29 psi



Flash-off

Until a uniform matte surface.

STEP 2



Application

After flash-off, apply recommended Special UC + 10% - 30%* TW80 Octobase Eco Thinner @ 29 psi.
* Refer to mix ratio recommendation chart for proper reduction.
* 20% reduction will achieve best results in this step.



Blending

Blend into the adjacent panel.



Flash-off

Until a uniform matte surface.

STEP 3



Application

Apply two coats Wet-on-Wet or single layer 46G + 20 - 30% TW80 Octobase Eco Thinner @ 1,6/1,8 bar 23/26 psi till uniform. Apply colour until the correct number of layers is achieved that was identified in the colour check. Until uniform @ 90% hiding.
* See mix ratio recommendation chart to determine correct reduction



MIX RATIO RECOMMENDATIONS

Environment	Temperature / Humidity	Mix Ratio
Cool and Humid	60°F—68°C / >55%	10%
Moderate	68°F—95°C / 20—80%	20%
Hot/Warm and Dry	85°F / <20% °C	30%

Application - Metallic Orientation/Mist Coat

* See mix ratio recommendation chart to determine correct reduction ratio. In order to ensure that the metallic particles remain properly oriented on the surface the following application method is recommended.

Prepare colour and add 10% - 30%* TW80 Octobase Eco Thinner to 46G.
Apply a crossed layer "mist-coat" @ 1,6/1,8 bar 23/26 psi and double distance. Allow to flash between coats. Do not apply the "mist-coat" wet this will create a sparkling effect instead of a flat mirror effect.



Blending

Blend into the adjacent panel.



Flash-off

Until a uniform matte surface.

STEP 4



Application

Apply a recommended clearcoat suitable for the Octobase Eco Plus System.



Note

Tack between each layer and before clearcoat, the repair and blend area.

Apply a mist (tack) coat first when applying clear. 5 minute flash off before next coat.