

OCTOBASE SYSTEM: MAZDA 46V SOUL RED CRYSTAL

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.



Cleaning

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



Protection

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



Surface preparation

Use sanding paper grit P500 or finer on repair area, and P1500 on blending area.



Note

To fill any light scratches mix B23 blending additive with TA920 Uni Thinner. Mixing ratio: B23+ 200% TA920. Apply one flowing coat off B23 on 2/3 off the blending area.

STEP 1



Application

Apply GS901 tack-coat + full coat till covered mixing ratio 100% TA920 @ 1,6 bar 23 psi.

Mask the adjacent panel, do not blend the GS901 into the blending area.

| | NOZZLE (MM) | AIR PRESSURE (BAR / PSI) |
|------|-------------|--------------------------|
| HVLP | 1,2-1,3 | 1,6/23 |
| HE | 1,2-1,3 | 1,6/23 |

In order to ensure that the metallic particles remain properly oriented on the surface the following application method is recommended.

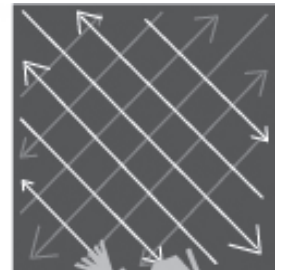


Apply a crossed layer "mist-coat" @ 1,6 bar 23 psi and double distance. Do not apply the "mist-coat" wet this will create a sparkling effect instead of a flat mirror effect.



Flash-off

Until a uniform matt surface.



STEP 2



Application

Apply ground color mixing ratio 100% TA920 @ 1,6 bar 23 psi tack coat + two full coats with flash-off in between, till uniform.



Flash-off

Until a uniform matt surface.



Blending

Blend into the adjacent panel.



Application Mistcoat

Apply a cross-layered mist coat mixing ratio 300% TA920 @ 1,6 bar 23 psi and blend into the adjacent panel.



Flash-off

Until a uniform matt surface.

Apply a mist coat first when applying clear. 5 minutes flash off before next coat.

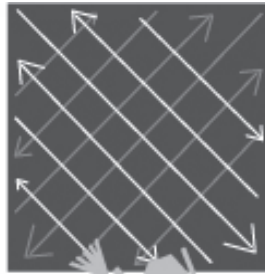
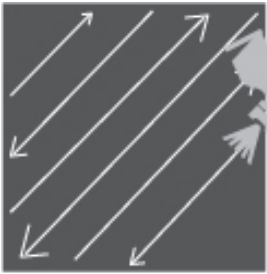
STEP 3



Application

Apply the mid coat special red metallic (preferably in cross layer) mixing ratio 100% TA920. 2-3 layers depending on the required colour @ 1,6 bar 23 psi.

Do not apply the mid-coat to wet to avoid strike-in.



Blending

Blend into the adjacent panel.



Flash-off

Until a uniform matt surface.

STEP 4



Application

Apply a recommended clear coat suitable for the OctoBase system.



Note

Tack before clear coat, the repair and blend area.

Apply a mist coat first when applying clear. 5 minutes flash off before next coat.