



OCTORAL

OCTOBASE ECO PLUS 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. A multi layer colour requires multi spray cards one with 2 layers, one with three layers to identify the correct number of layers to use in a repair.



Protection

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



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.



Note

To fill any light scratches mix W23 blending additive with TW80 Octobase Eco Thinner. Mixing ratio: W23 + 10% TW80. Apply one flowing coat of W23 on 2/3 of the blending area.

STEP 1



Application

Apply GS901 tack coat + full coat until covered. Mixing ratio 10% - 30%* TW80, 2,0 bar 29 PSI.
*** For the best possible results apply GS901, depending on region and variant.**
*** See mix ratio recommendations for proper reduction.**
*** In this step best results will be obtained using 20% reduction.**
Mask off the adjacent panel, do not blend GS901 into the blending area.

	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

Application (Mist/Orientation Coat)

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

Apply a crossed layered "mist-coat" @ 2,0 bar 9 psi and double the distance.
Do not apply the "mist-coat" wet. This will create a sparkling effect instead of a flat mirror effect.

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%



Flash-off

Until a uniform matte surface.

STEP 2



Application (Coverage Coat)

Apply UC special red metallic. Mixing ratio 10% - 30%* with TW80 @ 2,0 bar 29 PSI tack coat and let flash. Apply a 75% coat and a full coat with flash-off in between, until uniform @ 90% hiding***.

*** See mix ratio recommendations for proper reduction. **Over application of special red metallic will affect side tone. ***Only applicable in combination with GS901**



Flash-off

Until a uniform matte surface.



Application (Blending)

Apply a cross layered mist-coat with a mixing ratio of 10% - 30%* TW80 @ 2,0 bar 29 PSI and blend into the adjacent panel.* **See mix ratio recommendations for proper reduction.**



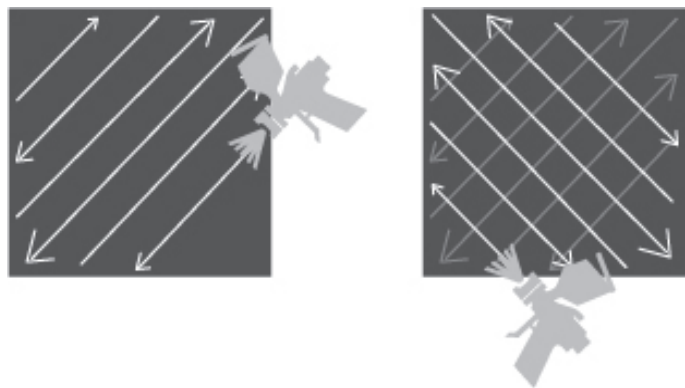
Blending

Blend into the adjacent panel. Keep the blending area with the colored under-coat as small as possible. Reduce pressure to 14psi to soften the blend edge.



Flash-off

Until a uniform matte surface.



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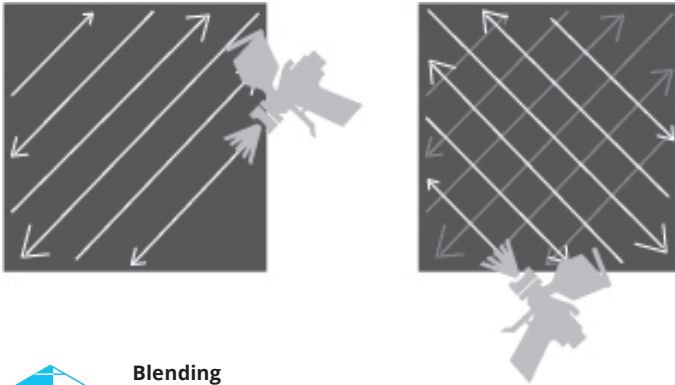
STEP 3



Application

Apply the mid coat W157 Octobase System Translucent Maroon (preferably in cross layer) mixing ratio 10% - 30%* TW80. 2-3 layers depending on the required colour @ 2,0 bar 29 psi and allow to flash between coats.

* See mix ratio recommendations for proper reduction.



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 clear coat, the repair and blend area.

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

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