

WB Tri Stage Exclusive Colors

Technical Bulletin

09/11/2019

L8.01.05 UK & Ireland

DESCRIPTION

Repair system for the following Tri-stage colors which are based on the new MM3060 toner :

- FA12:RR
- FA12:R3
- MAZ46V
- LEX3T5
- HON9880
- HON9881
- HON9885
- GMA15:G1E
- GMA15:GPJ

The above colours consist of different layers creating a special effect:

Basecoat WB GT Basecoat Groundcoat color

Basecoat WB GT MM3060 Midcoat color

Clearcoat

NOTE: TDS does not apply for colors which are formulated based on MM02.

COLOR CHECK

Groundcoat Apply groundcoat till completely covered and apply mist coat for optimal orientation. All coats should be completely dry before next coat is applied.
Groundcoat is applied as standard Basecoat WB GT.

Midcoat Correct color match needs to be determined by producing a number of color spray-out samples. The color depends on the number of coats applied of the midcoat.
Distribute spray out panels according to the following matrix.

Note:

This matrix is an indication of the number of midcoats:

Always complete sufficient sprayout samples to determine the colour accuracy.

The application will vary depending on temperature, humidity and applicator and therefore could have an influence on the number of midcoat layers.

WB Tri Stage Exclusive Colors

Technical Bulletin

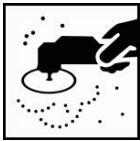
09/11/2019

L8.01.05 UK & Ireland

Midcoat	Advised Grey Shade	1 coat	2 coats	3 coats	4 coats	5 coats
FA12:RR			✓			
FA12:R3	G	✓				
MAZ46V						✓
LEX3T5	W/G		✓			
HON9880	G/B		✓			
HON9881					✓	
HON9885			✓			
GMA15:G1E	G	✓				
GMA17:GPJ	G	✓				

PREPARATION

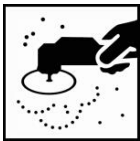
Primer area



Final sanding step P500

- Initial sanding steps may be executed with a coarser sanding grit; P360 - P400
- Respect a maximum 100 sanding grit step difference or less throughout the sanding procedure.
- For detailed surface preparation see TDS L8.06.02

Basecoat blend area



Final sanding step P1000

- Initial sanding steps may be executed with a coarser sanding grit P600 - P800
- Respect a maximum 200 sanding grit step difference or less throughout the sanding procedure.
- For detailed surface preparation see TDS S8.06.02
- **Do NOT use Basecoat WB GT MM02/MM04 as pre-coat;** it will change the depth of the OE color.
- Clear midcoat can be used as a pre coat; it has to be dried completely before application of groundcoat color.

Surface cleaning



Remove contamination using an appropriate surface cleaner.

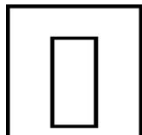
WB Tri Stage Exclusive Colors

Technical Bulletin

09/11/2019

L8.01.05 UK & Ireland

GROUNDCOAT APPLICATION

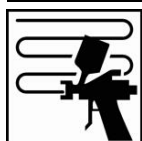


Ready For Use (RFU)



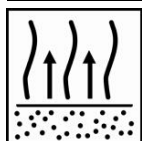
Spray gun set-up :
1.3 –1.4 mm

Application pressure:
1.8 bar at the air inlet
HVLP max 0.6-0.7 bar at the air cap



Apply Groundcoat until completely covered

Flashing-off in between each coat



Flash off by increasing airflow until completely dry between each coat.

Drop coat has to be flashed off until completely dry before Midcoat application.

WB Tri Stage Exclusive Colors

Technical Bulletin

09/11/2019

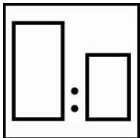
L8.01.05 UK & Ireland

MIDCOAT APPLICATION



Important!

Please use mixed paint within the same day

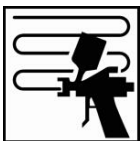


100 Parts of midcoat
10-20 Parts of Activator WB

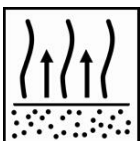


Spray gun set-up :
1.3 –1.4 mm

Application pressure:
1.8 bar at the air inlet
HVLP max 0.6-0.7 bar at the air cap



Apply the number of midcoat layers until the desired color is achieved.
Flash off until completely matt after each coat
Use the matrix as an indication for the number of layers required.



Flash off by increasing airflow until completely dry between each coat.
Drop coat must be flashed off until completely dry before clearcoat application.

CLEARCOAT



See clearcoat TDS



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

WB Tri Stage Exclusive Colors

Technical Bulletin

09/11/2019

L8.01.05 UK & Ireland

NOTES

**Ensure that each coat is thoroughly flashed-off.**

Application of a Tri-Stage Exclusive color is the same as a Three Stage Pearl effect color.

For further information please refer to Technical Bulletin Basecoat WB Three Stage Pearl application process.

Akzo Nobel Coatings LTD

Address: Unit 2B, Didcot Park
Churchward, Southmead Industrial Estate
Didcot, Oxfordshire, OX11 7HB
Tel: 00 44 (0)1235 862226

FOR PROFESSIONAL USE ONLY

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 fulfil 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.

Brand names mentioned in this data sheet are trademarks of or are licensed to AkzoNobel.

Head Office

Akzo Nobel Car Refinishes B.V., PO Box 3 2170 BA Sassenheim, The Netherlands. www.Lesonal.com