

Basecoat WB MAZ41V Soul Red

Technical Bulletin

09/11/2019

L8.07.08b UK & Ireland

DESCRIPTION

The repair system for Mazda 41V Soul Red consists of different layers creating a special color effect, based on the following layers:

- Basecoat WB GT Groundcoat
- Basecoat WB GT Midcoat
- Clearcoat

COLOR CHECK

Correct color match needs to be done by producing a number of color spray-out samples, the color changes dependent on the number of coats applied of the effect color.

Proceed as follows:

- Apply the foundation color until opacity is achieved on 5 different spray-out panels.
- Next apply one single coat of the effect color to all panels.
- Allow sufficient flash-off time and **remove one** panel before continuing this application process, resulting in spray-outs panels ranging with 1-5 coats of the effect coat.
- Allow for a 10-15 minutes flash-off time at 70°F (20°C) prior to clearcoat application.
- For optimum flash-off, dry the panels for several minutes in a oven or during a drying cycle in the spray booth.
- Apply two single layers of clearcoat to all color spray-out panels, securing brightness and color depth.

Create a set of spray out panels as below:

Groundcoat Until hiding + Drop-coat				
	2 coats	3 coats	4 coats	5 coats
	Midcoat	Midcoat	Midcoat	Midcoat

The operator can determine the right color match by using these color samples.

- Number each panel, indicating the number of effect coats on the panel.
- **Do not spray each panel separately.**

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BASECOAT WB GT GROUNDCOAT



Mix Groundcoat and Midcoat (1:1) (**Mix 1**)

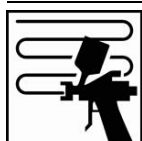


100 Basecoat WB GT **Mix 1**
10-20 Activator WB



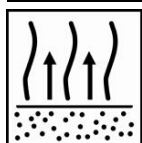
Spray gun set up :
1.3-1.4 mm

Application pressure :
1.7-2.2 bar at the air inlet
HVLP max 0.6-0.7 bar at the air cap



Apply Mix 1 until completely covered, flash-off between coats.

Note: For an optimal blend-edge a mini/compact spray gun can be used



Flash off by increasing airflow until completely dry between coats.
Drop coat has to be flashed until completely dry before midcoat application.

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BASECOAT WB GT MIDCOAT



Mix 1 and Midcoat (1:1) (**Mix 2**)

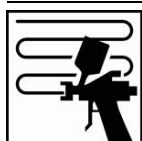


100 Basecoat WB GT **Mix 2**
50 Activator WB

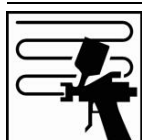


Spray gun set up :
1.3-1.4 mm

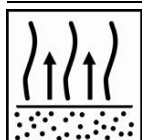
Application pressure :
1.7-2.2 bar at the air inlet
HVLP max 0.6-0.7 bar at the air cap



Apply 1 coat over the edge of mix 1



Apply 2 coats of the midcoat.
Flash-off between coats.



Flash off until completely dry between each coat and allow to flash off for 20-30 minutes before clearcoat application.

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CLEARCOAT



See clearcoat TDS:



Use suitable respiratory protection

Akzo Nobel Car Refinishes recommends the use of fresh air supply respirator

Akzo Nobel Coatings LTD

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