PROTEC AUTOMOTIVE PAINTS

PROCESS INFORMATION

MAZDA 46G MACHINE GRAY AQUAMAX® EXTRA REPAIR PROCESS

PROCESS DESCRIPTION

Mazda 46G Machine Gray is a special effect colour and requires a specific application process as outlined below.

PRODUCTS

Mixed Colour (*AquaMax* Extra)	Mazda 46G Machine Gray
Base Incolore	E010
Nero Assoluto	E904
Alluminio Liquido 2	AL05
Aquamax Extra VOC WB Thinner	9970

1. REPAIR AND PREPARATION OF SUBSTRATE

1.1 The damaged body work of the vehicle should be repaired using the approved PROTEC® repair and undercoating system for the substrate of the body panels being repaired (Aluminium, Steel, Plastic, etc.)

1.2 Sealing the repair with a M6 Multigrey wet-on-wet (WOW) primer shade as a first step is recommended followed by E904 Nero Assoluto tinter as a groundcoat colour over repaired areas used in Step 2 of the process.

2. GROUNDCOAT AND PREPARATION OF SUBSTRATE

2.1 When preparing the substrate as recommended below, suitable colour panels should be prepared alongside for use when checking the colour/effect of the basecoat, as OEM colour variation can differ.

2.2 For the Mazda 46G Machine Gray *AquaMax* Extra colour process, E904 Tinter thinned 20% is applied prior to the topcoat colour. When using the 46G *AquaMax* Extra mixed colour thinned 20%, full coverage/opacity must be achieved. This also needs to be applied to the colour panels when being prepared for the Colour check process.

2.3 If only part of a body panel is repaired and primed, M6 WOW primer should applied over the sanded/primed repair areas first. This should be followed by SUA860 blend thinner, applied and blended on M6 edges. This should be followed by E904 Nero Assoluto tinter applied over complete M6 wet-on-wet areas.

2.4 Where blending of the basecoat will occur as part of the repair, the area of the panel from the basecoat blend to the edge of the panel should be finished with P1000 Abralon damp using a 150MM orbital sander. One wet coat of E010 Base Incolore should be applied to the blend area as per normal blending process.

3. MAZDA 46G MACHINE GRAY *AQUAMAX* EXTRA MIXED COLOUR APPLICATION

3.1 Due to possible variation of the colour of a particular vehicle, it is essential that a colour check panel is prepared using the colour panels prepared as mentioned in Section 2 and using the basecoat application process recommended in this section (3).

3.2 Apply one wet coat of E010 Base Incolore thinned 20% to the prepared blend area for smooth lay down.

3.3 Mix E904 at 20% thinner. Ensure E904 is applied 1 wet double coat to seal repair and enhance laydown of 46G colour.

3.4 Thin 46G *AquaMax* Extra mixed colour at 20% with 9970 thinner. Ensure 46G mixed colour is thoroughly stirred prior to AND after thinning.

3.5 Spraygun recommended is Sata WSB HVLP (@ 1.3 - 1.5 bar).

3.6 Apply one double wet coat of E904 @ 1.3 - 1.5 bar with material 1.5 turns open from closed position and the fan fully open. Flash off until satin.

3.7 Apply 1st double medium wet coat of 46G mixed colour @ 1.3 - 1.5 bar with material 1 ¼ turns open from closed position and the fan fully open. Flash off until satin.

3.8 Apply 2nd double coat from a distance of approx. 20 - 30cm from panel and evenly applied @ 1.3 - 1.5 bar with material 1 ¼ turns open from closed position and the fan fully open. Flash off until satin.

3.9 **If the metallic control appears even and free from patches and opacity is achieved at this stage, proceed to step 3.10.**
If not repeat Step 3.8.

3.10 Apply 1 even technique coat at a reduced pressure of 1.1 bar with material 1 turn open from closed position and the fan fully open. Apply a light control coat from a distance of approx. 15 - 20cm onto the dry film. Flash off until satin.

3.11 Minor defects may be de-nibbed with 3000 abralon in between coats and tackragged.

3.12 Care should be taken to apply this final basecoat layer very lightly and evenly.

3.13 Flash off for 15 - 20 minutes until completely satin before applying Clearcoat.

3.14 To blend the basecoat, apply the first double coat to the primed area, then extend each subsequent coat a little further into the blend area using normal blending techniques to achieve an even blend into the original colour. As with full panel application, care should be taken apply this final basecoat blended edge very lightly and evenly without over-wetting of the basecoat.

4. CLEARCOAT APPLICATION

4.1 Clearcoat with an approved MAXMEYER® clearcoat.

4.2 The first coat of clearcoat must be applied as a light mist coat. Avoid wetting this first coat too much, over-application can move the basecoat leading to patchiness.

4.3 Apply second coat of clear as recommended for the appropriate *MaxMeyer* Clearcoat.

4.4 Bake as indicated in TDS for the Clearcoat selected.

4.5 Polish as necessary to achieve finish required.

NOTES:

- P800 followed by P1000 abralon damp with 150mm orbital sander to prepare blend areas. Do not hand sand afterwards.
- Apply M6 WOW Primer on all new panels and blend over any correctly prepared and sanded areas including sanded primer areas. Where WOW edges may exist around primer patches apply Aerosol Blending thinner over the top to smooth the edges.
- Use E010 thinned 20% blending into adjacent panels. This will assist with the polished metal look required.
- Use E904 thinned 20% over repaired areas. This will assist with the polished metal look and assist with the OEM process, plus help control mottle.
- Thin 46G mixed colour 20% with 9970 thinner.
- Use a SATA HVLP WSB setup for the best mottle control and colour accuracy.
- Gun settings at 1 ¼ turns of fluid at 1.3 - 1.5 bar, technique coat at 1 turn of fluid at 1.1 bar with drop coat motion.
- Basecoat may be de-nibbed with Abralon 3000 dry, once it is flashed off.
- Humidity may play a part in the wetting of the basecoat however, this may stay slightly wetter longer.
- Paraglaze range Primers and Clearcoats may be used in place of *MaxMeyer* Primers and Clearcoats.

HEALTH AND SAFETY

Refer to Safety Data Sheets (SDS) for full Health and Safety details, as well as product can labels.

Protec hardeners and activated products contain isocyanate and therefore particular safety precautions must be taken; please refer to SDS for full health and safety details.

These products are for professional use only.
The information given in this sheet is for guidance only. Any person using the product without first making further inquiries as to the suitability of the product for the intended purpose does so at his or her own risk and we can accept no liability for the performance of the product or for any loss or damage (other than death or personal injury resulting from our negligence) arising out of such use. The information contained in this sheet is liable to modification from time to time in the light of experience and our policy of continuous product development.
Drying times quoted are average times at 25°C/77°F. Film thickness, humidity and shop temperature can all affect drying times.

PPG Industries Australia Pty Ltd, 14 McNaughton Rd
Clayton, V.I.C. 3168 Australia

EMERGENCY RESPONSE NUMBER, Australia: 1800 883 254

PPG Industries New Zealand Pty Ltd, 5 Vestey Dr, Mt Wellington
Auckland, New Zealand

EMERGENCY RESPONSE NUMBER, New Zealand: 0800 000 096

Protec and the *Protec Logo* are registered trademarks of Protec Pty Ltd.
MaxMeyer and *AquaMax* are registered trademarks of PPG Industries Europe SARL.