PROTEC AUTOMOTIVE PAINTS

PROCESS INFORMATION

NISSAN ULTIMATE SILVER (KAB) AQUAMAX® EXTRA REPAIR PROCESS

PROCESS DESCRIPTION

Nissan Ultimate Silver (KAB) is a special effect silver colour that gives a "Liquid Metal" appearance and requires a specific application process as outlined below.

PRODUCTS

Mixed Colour (*AquaMax* Extra)	Nissan Ultimate Silver (KAB)
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 Finishing the repair with M4 or M5 Multigrey wet-on-wet (WOW) primer shade is recommended as a groundcoat colour used in Step 2 of the process. A standard 2K Clearcoat layer can be applied directly to the M4 or M5 undercoat (after sanding if required).

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 Nissan Ultimate Silver (KAB), the M4 or M5 groundcoat colour is used with 2K clearcoat applied over. When using the Nissan Ultimate Silver (KAB) *AquaMax* Extra mixed colour, full coverage/opacity must be achieved. The M4 or M5 shade gives the best guide as to when full coverage is achieved.

2.3 If only part of a body panel is repaired and primed, the Clearcoat should be applied over the entire panel.

2.4 The Clearcoat is fully dried following the recommendations from the appropriate TDS, then sanded with P1200 dry to remove orange peel to result in a completely flat surface.

2.5 The area to be painted, then needs to be finished with P1000 (or equivalent), wet, or finer to minimize any scratches from the removal of the orange peel.

2.6 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 P3000 (or equivalent), wet.

3. *AQUAMAX* EXTRA KAB 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 Mix Nissan Ultimate Silver (KAB) using *AquaMax* Extra toner Alluminio Liquido 2 – AL05 and other *AquaMax* Extra toners.

3.3 Thin 50% with 9970 (2 / 1).

3.4 Spraygun recommended is Sata 1.0 - 1.1 HVLP (@ 2 bar).

3.5 Apply first double cross coat @ 2 bar with gun 1.25 - 1.5 turns open. Flash off until matt (using air blower).

3.6 Apply second double cross coat @ 2 bar with gun 1.25 - 1.5 turns open. Flash off until matt (using air blower).

3.7 **If the metallic control appears even and free from patches and opacity is achieved at this stage, proceed to step 3.8.**
If not repeat Step 3.6.

3.8 Apply 1 double / triple mist coat @ 2 bar with gun 0.75 turns open and flash off until matt (using air blower).

3.9 Care should be taken to apply this final basecoat layer very dry and even without any “wetting up” of the basecoat.

3.10 Flash off for 20 - 30 minutes before applying Clearcoat.

3.11 To blend the basecoat, apply the first double cross 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 to 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 Leave to flash off for 10 - 15 minutes, then apply 1 full coat (additional ½ coat applied immediately after the full coat may be required on horizontal surfaces).

4.4 Bake as indicated in TDS for the Clearcoat selected.

4.5 If necessary, to achieve the smoothest final finish, sand with P1200 or finer (dry) and then re-apply the Clearcoat.

4.6 Polish as necessary to achieve finish required.

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.