



BeroBase 500 Series: Mazda 46G Machine Grey

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.



Protection

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



Cleaning

Clean with 1-951 Silicone Remover and/or 9-851 WaterBase 900+ Series Degreaser.



Surface preparation

Use sanding paper grit P500 or finer on repair area, and P1500 on blending area.

STEP 1



Application

Apply 577 + 200% 1-161 Uni Thinner Slow @ 1,6 bar 23 psi over the blending area, this could also be applied over the entire repair area (optional).

	NOZZLE (MM)	AIR PRESSURE (BAR / PSI)
HVLP	1,2-1,3	1,6/22
HE	1,2-1,3	1,6/22



Flash-off

Until a uniform matt surface.

STEP 2



Application

After flash-off apply recommended Special UC + 100% 1-161 Uni Thinner Slow @ 1,6 bar 23 psi.



Blending

Blend into the adjacent panel.



Flash-off

Until a uniform matt surface.

STEP 3



Application

Apply two coats 46G + 300% 1-161 Uni Thinner Slow @ 1,6 bar 23 psi till uniform. With flash-off between coats.

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



Prepare colour and add 300% 1-161 Uni Thinner Slow to 46G. Apply a crossed layer "mist-coat" @ 1,6 bar 23 psi and double distance. Do not apply the "mist-coat" wet this will create a sparkling effect instead of a flat mirror effect.



Blending

Blend into the adjacent panel.



Flash-off

Until a uniform matt surface.

STEP 4



Application

Apply a recommended Clear Coat suitable for the BeroBase 500 Series.



Note

Tack between each layer and before clear coat, the repair and blend area.

Apply a mist coat first when applying clear. 5 minutes flash off before next coat.