

WaterBase 900+ Series: Mazda 46G Machine Grey 3- Stage

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. A multi layer colour requires multi spray cards one with two layers, one with three layers and one with four layers to identify the correct number of layers to use in a repair.
 NOTE: Spraying to full hide can affect colour match.



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 P600 or finer on repair area, and P1500 on blending area.

STEP 1




Application

Apply 977 + 10% 9-151 WaterBase 900+ Series Thinner @ 2,0 bar 29 psi over the blending area, this could also be applied over the entire repair area (optional).

	NOZZLE (MM)	AIR PRESSURE (PSI)
HVLP	1.1-1.3	2.0 bar / 29 psi
HE	1.1-1.3	2.0 bar / 29 psi



Flash-off

Until a uniform matt surface.

STEP 2




Application

After flash-off, apply recommended Special UC + 10% - 30%* 9-151 WaterBase 900+ Series Thinner @ 2,0 bar 29 psi.
 * Refer to mix ratio recommendation chart for proper reduction.
 * 20% reduction will achieve best results in this step.



Blending

Blend into the adjacent panel.



Flash-off

Until a uniform matt surface.

STEP 3




Application - Coverage Coat

Apply two coats Wet-on-Wet or single layer 46G + 10% - 30%* 9-151 WaterBase 900+ Series Thinner @ 1,6/1,8 bar 23/26 psi till uniform. Apply colour until the correct number of layers is achieved that was identified in the colour check.
 * See mix ratio recommendation chart to determine correct reduction

MIX RATIO RECOMMENDATIONS

Environment	Temperature / Humidity	Mix Ratio
Cool and Humid	60°F-68°C / >55%	10%
Moderate	68°F-95°C / 20-80%	20%
Hot/Warm and Dry	85+°F / <20% °C	30%

Application - Metallic Orientation/Mist Coat

* See mix ratio recommendation chart to determine correct reduction ratio. In order to ensure that the metallic particles remain properly oriented on the surface the following application method is recommended.



Prepare colour and add 10% - 30%* 9-151 WaterBase 900+ Series Thinner to 46G. Apply a crossed layer "mist-coat" @ 1,6/1,8 bar 23/26 psi and double distance. Allow to flash between coats. 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 clearcoat suitable for the Waterbase.



Note

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

Apply a mist (tack) coat first when applying clear. 5 minute flash off before next coat.