

BeroBase 500 Series: Mazda 46V Soul Red Crystal

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 three stage colour requires multi spray cards one with 2 layers, one with three layers to identify the correct number of layers to use in a repair.



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.



Protection

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



Note

To fill any light scratches mix 577 blending additive with 1-161 Uni Thinner. Mixing ratio: 577+ 200% 1-161. Apply one flowing coat off 577 on 2/3 off the blending area.

STEP 1



Application

Apply GS901 tack-coat + full coat till covered mixing ratio 100% 1-161 @ 1,6 bar 23 psi.

Mask the adjacent panel, do not blend the GS901 into the blending area.

	NOZZLE (MM)	AIR PRESSURE (BAR / PSI)
HVLP	1,2-1,3	1,6/23
HE	1,2-1,3	1,6/23



Flash-off

Until a uniform matt surface.

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



Apply a crossed layer "mist-coat" @ 1,6 23 psi bar and double distance. Do not apply the "mist-coat" wet this will create a sparkling effect instead of a flat mirror effect.



STEP 2



Application

Apply ground colour mixing ratio 100% 1-161 @ 1,6 bar 23 psi tack coat + two full coats with flash-off in between, till uniform.



Flash-off

Until a uniform matt surface.



Blending

Blend into the adjacent panel. Keep the blending area with the colored under-coat as small as possible.



Application Mistcoat

Apply a cross-layered mist coat mixing ratio 300% 1-161 @ 1,6 bar 23 psi and blend into the adjacent panel.



Flash-off

Until a uniform matt surface.

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

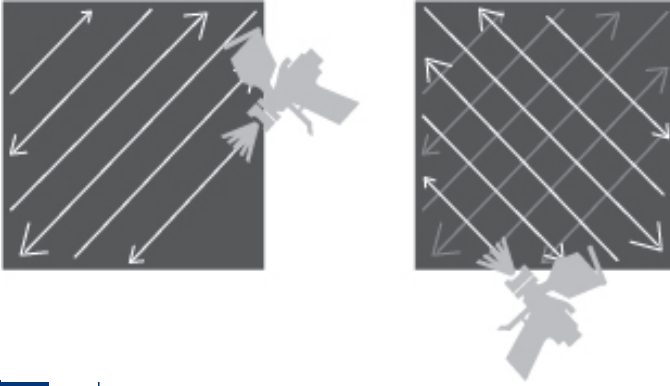
STEP 3



Application

Apply the mid coat special red (preferably in cross layer) mixing ratio 100% 1-161. 2-3 layers depending on the required colour @ 1,6 bar 23 psi.

Do not apply the mid-coat to wet to avoid strike-in.



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 before clear coat, the repair and blend area.

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