

WaterBase 900+ Series: Mazda 46V Soul Red Crystal 4- 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 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 P600 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 977 blending additive with 9-151 WaterBase 900+ Series Thinner. Mixing ratio: 977+ 10% 9-151. Apply one flowing coat of 977 on 2/3 of the blending area.

STEP 1



Application

Apply G5901 tack coat + full coat until covered. Mixing ratio 10% - 30%* 9-151, 2.0 bar / 29 psi.

- * For the best possible results apply G5901, depending on region and variant.
- * See mix ratio recommendations for proper reduction.
- * In this step best results will be obtained using 20% reduction.

Mask off the adjacent panel, do not blend G5901 into the blending area.



Flash-off

Until a uniform matte surface.



Application (Blending)

Apply a cross layered mist-coat with a mixing ratio of 10% - 30%* 9-151 @ 2.0 bar / 29 psi and blend into the adjacent panel.

- * See mix ratio recommendations for proper reduction.

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

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%



Flash-off

Until a uniform matte surface.

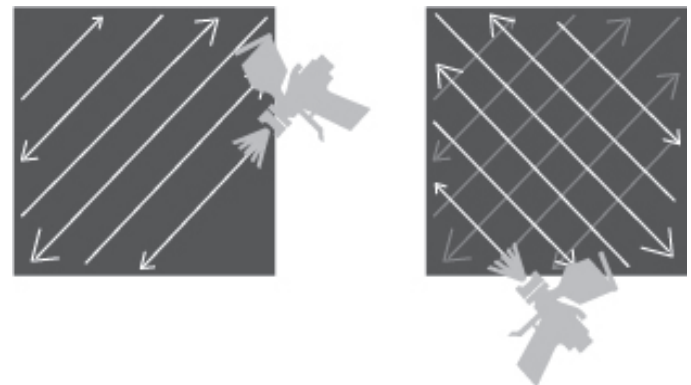
STEP 2



Application (Coverage Coat)

Apply UC special red metallic. Mixing ratio 10% - 30%* with 9-151@ 2.0 bar / 29 psi tack coat and let flash. 2. Apply a full wet coat and then a 75% medium wet coat, with no flash-off in between, until uniform at 90% hiding***.

- * See mix ratio recommendations for proper reduction.
- **Over application of special red metallic will affect side tone. tone.
- ***Only applicable in combination with G5901



Application (Mist/Orientation Coat)

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



Apply a crossed layered "mist-coat" @ 2.0 bar / 29 psi and double the 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. Keep the blending area with the colored under-coat as small as possible.
Reduce pressure to 1,0 bar / 14 psi to soften the blend edge.



Flash-off

Until a uniform matte surface.

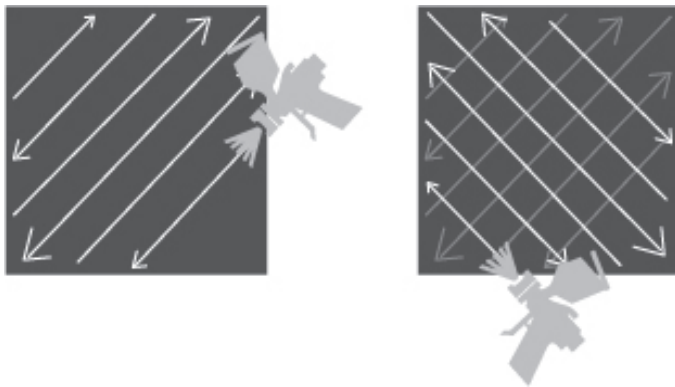
STEP 3



Application

Apply the mid coat MM9153 Waterbase 900+ Series Translucent Maroon (preferably in cross layer) mixing ratio 10% - 30%* 9-151. 2-3 layers depending on the required colour @ 2,0 bar 29 psi and allow to flash between coats.

* See mix ratio recommendations for proper reduction.



Blending

Blend into the adjacent panel.



Flash-off

Until a uniform matte surface.

STEP 4



Application

Apply a recommended clearcoat suitable for the Waterbase 900+ Series.



Note

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

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

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