

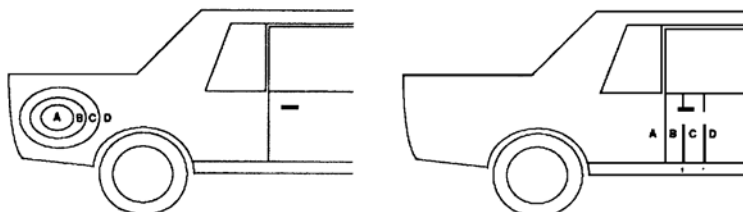
Sikkens Autowave[®] Spot Repairs

FOR PROFESSIONAL USE ONLY

Description

The term spot repair and blending is understood to include all repairs to damaged areas resulting in an invisible repair or blend into the still intact existing finish. As a result, the car refinisher is not compelled to spray large panels in the case of minor damage. The spot repair technique also enables minor differences in color and effect between the original car finish and the refinish to be made invisible. The application method and technique described below is applicable for spots and blends of Autowave color and the Sikkens clearcoats.

Spot and blend area preparation



Clean all areas: first degrease with a VOC compliant surface cleaner.

In the above drawings, area "A" is the area under repair. Shape it and build up the area using the appropriate products. After the products have dried, sand the area under repair "A" as well as the adjacent area "B". When spot repairs are made, wet sanding by hand is preferred.



Sand areas "A" and "B" with waterproof #P800 to #P1000 grit paper wet. Thoroughly scuff areas "C" and "D" (whole panel) with a *grey* scuff pad, Sikkens Blend-Prep and water, or alternately prepare areas "C" and "D" with a good quality DA sander using a 3M interface pad and #P1000 grit sanding disk.

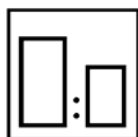


If blending of the clearcoat is inevitable (sail panels), apply some Sikkens Blend-Prep on a damp sponge, and scuff until gloss is removed, or alternately prepare (sail panels) by scuffing with a 3M Clear Blend Prep Pad #07745 (gold). Trizact 3000 may also be used to prepare this area. Thoroughly clean areas with a compliant Sikkens Surface Cleaner.



Use suitable respiratory protection

Akzo Nobel Car Refinishes Inc. recommends the use of a fresh air supply respirator



100 Autowave
10-30 Activator WB

- Stir color thoroughly prior to adding Activator WB

For accurate mixing always use the Sikkens measuring stick #14 (blue) or mix on the scale using Addit.

- Up to 30 parts Activator WB may be used when spraying difficult metallic colors, or when the humidity is less than RH 40%

Read complete Autowave TDS 5.0.2 for detailed product information.

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Application process



When making spot repairs apply thin coats until opacity is achieved. Dry until matt between each coat before fading out well beyond the edges.

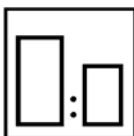
- In case of metallic colors lower air pressure may be needed for color control. Extend each coat until coverage is obtained. Finally apply an orientation coat fading out well beyond the coverage coats.

With some metallic colors it may be necessary to slightly increase the gun distance to achieve the optimal invisible repair.

Blending application

In the case of high hiding colors and fading out, the color transparency can be increased by adding MM666 RTS to the RTS mixed color. (Mix Autowave MM666 with Activator WB, ratio of 100:20 to achieve the Ready To Spray mixture). Place these together as follows; *at a ratio of 100 parts color and 50 parts MM666.*

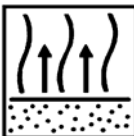
Autowave MM666 pre-coat



Autowave MM666 can also be used as a pre-coat to facilitate a smoother fade-out transition.

Mix 100 parts MM666 to 20 parts Activator WB and apply one single closed coat to the maximum fade-out area. Apply the color into the semi-wet pre-coat and continue color application keeping within the pre-coat area. Ensure flash off times of subsequent color coats are observed.

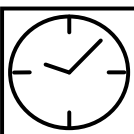
Drying and air acceleration



Humidity and airflow will influence the Autowave flash off and drying times. These times can be reduced to a minimum by using air accelerator systems at a distance of 3 feet from the object, thus increasing the airflow over the object.

- When heat is used for drying, allow object to cool down to application temperature before proceeding with color or clearcoat application.

Recoat time



Prior to clearcoat application:

Minimum 15 minutes at 75°F (24°C).
Maximum 24 hours at 75°F (24°C).

Recoatable with



- Autoclear II LV.
- Autoclear HS + LV.
- Autoclear Superior 250.
- Autoclear HS + (national VOC rule)

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Application of clearcoat

Autowave is sufficiently dry to clear coat after 15 minutes at 75°F (24°C).

- Carefully tack the entire repair area and apply clearcoat.



Apply clearcoat according to T.D.S. recommendations

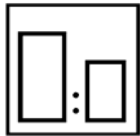
- On complete panels; extend the 2nd coat beyond the 1st coat



According to T.D.S. of the selected clearcoat at 70°F to 75°F (20°C to 24°C)

Blending of clearcoat

Akzo Nobel Coatings/Sikkens strongly recommends the application of clear coat over the whole panel. There are, however, instances where this is not practical. Such as repairs on older vehicles where economics would dictate that a warranty is not required. In these instances, it may be acceptable to blend the clear coat into small areas such as a rocker panel or sail panel, vertical areas only. This procedure is not warranted or OE approved.



100:50 with Reducer SRA 7.0

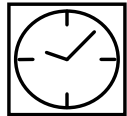
Reduce the ready to spray clearcoat mixture by 50% Reducer SRA 7.0, shake / stir thoroughly before application.



- Because of the extra thinned material the viscosity of the paint is much lower, therefore apply the following blending steps with reduced application pressure.

When blending of the clear is inevitable (sail panel). Hard line each coat (do not fade out) and extend the application of the reduced final coat, hard line this coat. Apply partial trigger during this application.

Drying



Drying of the topcoat according product TDS recommendations.
Drying is related to object temperature and applied layer thickness.

- Let the object cool down to ambient temperature prior to polishing



Additional drying by infra red will secure optimal through hardening in the blend area.

- Let the object cool down to ambient temperature prior to polishing

Polishing of the blended area



Polish the blended area by hand with 3M 06070 Trizact – Spot Finishing Material or a similar fine polishing compound.

In case more effort is required, polish by machine, a ultra fine polishing compound and soft compound pad.

- Do not use an abrasive polishing compound.
- One option is to lightly prepare the hard line edge with Trizact 3000 and buff using the process stated above.



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Cleaning of equipment after Autowave application

Clean and rinse the spray gun thoroughly after use with Autowave Gun Cleaner.
Purge the spray gun with Activator WB prior to Autowave use.

- *Do not use any conventional thinner unless removing dried Autowave deposits.*
- *Do not soak the spray gun for long periods either with Autowave Gun cleaner or Activator WB.*

VOC

Autowave, unreduced: 2.9 lb. / gallon (348 gr/lit)
The VOC content of this product in ready to use form is <3.5 lb. /gallon. (<420 gr/lit)

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IMPORTANT NOTE: The information in this data sheet is not intended to be exhaustive and is based on the present state of our knowledge and on current laws: any person using the product for any purpose other than that specifically recommended in the technical data sheet without first obtaining written confirmation from us as to the suitability of the product for the intended purpose does so at his own risk. It is always the responsibility of the user to take all necessary steps to fulfill the demands set out in the local rules and legislation. Always read the Material Data Sheet and the Technical Data Sheet for this product if available. All advice we give or any statement made about the product by us (whether in this data sheet or otherwise) is correct to the best of our knowledge but we have no control over the quality or the condition of the substrate or the many factors affecting the use and application of the product. Therefore, unless we specifically agree in writing otherwise, we do not accept any liability whatsoever for the performance of the product or for any loss or damage arising out of the use of the product. All products supplied and technical advices given are subject to our standard terms and conditions of sale. You should request a copy of this document and review it carefully. The information contained in this data sheet is subject to modification from time to time in the light of experience and our policy of continuous development. It is the user's responsibility to verify that this data sheet is current prior to using the product.

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