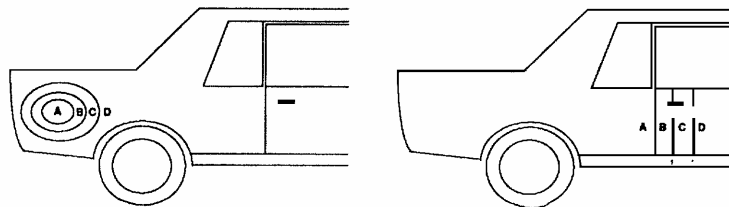


SPOT REPAIRS WITH AUTOCRYL®

DESCRIPTION: The term spot repair is understood to include all repairs to damaged areas resulting in the repaired area blending invisibly 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 repair to be made invisible.

PREPARATION: (These notes apply for both solid and 1 step metallic colors.)



Clean all areas: first degrease with M600 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 #P600 to #P800 grit paper wet. Thoroughly compound areas "C" and "D" (whole panel) with a medium grade compound. Clean and degrease all areas with M600 Surface Cleaner.

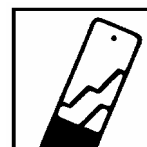
APPLICATION OF AUTOCRYL:



Contains xylene and other ingredients. When mixed, also contains isocyanates.



3:1:1+10%
Autocryl
Autocryl Hardener Rapid
Autocryl Reducer
Additional Autocryl Reducer Fast



Use the Sikkens Measuring Stick #9 (Grey)

Mixing Ratio:


3 parts by volume Autocryl
1 part by volume Hardener Rapid
1 part by volume Autocryl Reducer
10% Autocryl Reducer Fast

ALTERNATE MIXING RATIO:



100 parts by volume Autocryl
50 parts by volume Sikkens Standard Hardener
30 parts by volume Sikkens Production or Rapid Activator
For easy and accurate mixing, use the Sikkens Measuring Stick #1 (Black).

SPOT REPAIRS WITH AUTOCRYL®

5.  3x1
HVLP Siphon
0.071"–0.087" (1.8–2.2 mm)
HVLP Gravity
0.051"–0.059" (1.3–1.5 mm)
Max 10 psi (max 0.8 bar)

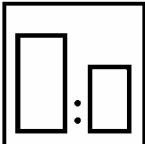
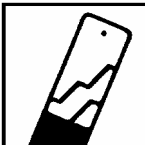

Application Method: Spray single coats in areas A & B until opacity is achieved. Allow 5–10 minutes flash off time between coats.

Fade out each coat into area C, with each succeeding coat extending slightly beyond the previous one. After each application, remove dry overspray carefully from areas C and D with a Sikkens 1-2-3 Tack Cloth.

6.  5–10 minutes at 70°F (20°C)

BLENDING:

For Autocryl solid colors:

1.  100:50
Autocryl, ready to spray
Reducer SRA 7.0
2.  Use the Sikkens
Measuring Stick # 1 (black)
3.  1x1
HVLP Siphon
0.071"–0.087" (1.8–2.2 mm)
HVLP Gravity
0.051"–0.059" (1.3–1.5 mm)
Max 10 psi (max 0.8 bar)

Application Method: Add to the ready to spray paint, 50 parts by volume Reducer SRA 7.0.

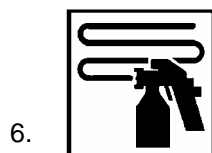
4. 
5.  Sikkens Reducer SRA 7.0
ready to spray

With this over-reduced material, extend the application, fading out into area D.

SPOT REPAIRS WITH AUTOCRYL®

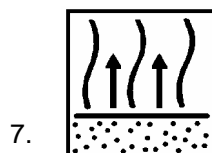
BLENDING:

For Autocryl solid colors: (Continued):



2x1
20–30 psi
(1.3–2.0 bar)

Use pure Reducer SRA 7.0 to dissolve overspray edge. Spray 1 medium coat. Flash for 15 seconds. Apply final thin coat.



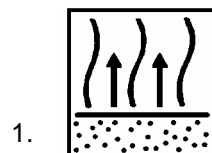
15 seconds at 70°F (20°C)
between coats of Reducer
SRA 7.0



Allow appropriate dry time for
hardener and reducer used.

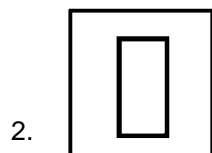
BLENDING:

For Autocryl 1 step metallic colors:

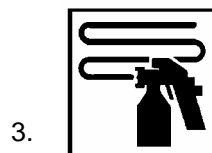


10 minutes at 70°F (20°C)

Application Method: After the last coat of Autocryl Metallic. Flash for a minimum of 10 minutes. (Do not add extra reducer to fade out into area D.)

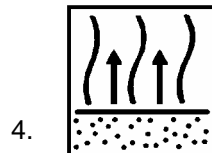


Reducer SRA 7.0
ready to spray

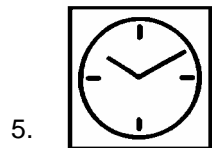


2x1
20–30 psi
(1.3–2.0 bar)

Use pure Reducer SRA 7.0 to dissolve overspray edge. Spray 1 thin coat, flash for 15 seconds, apply final thin coat.



15 seconds at 70°F (20°C)
between coats of Reducer
SRA 7.0



Allow appropriate dry time for
hardener and reducer used.

AFTER TREATMENT:

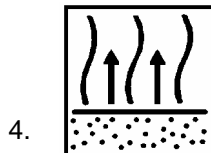
After the repair is completely dry, the fade out area may be polished with an ultra-fine polishing compound and waxed. (Please see the dry to polish time of the materials being used.)

SPOT REPAIRS WITH AUTOCRYL®

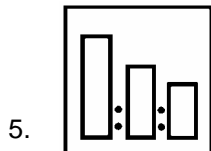
ALTERNATE PROCESS: (FOR AUTOCRYL SOLIDS AND 1 STEP METALLICS):



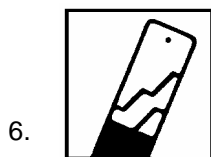
M600 Surface Cleaner



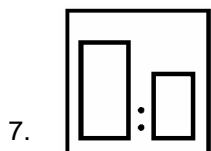
10 minutes at 70°F (20°C)



100:50:30
Autoclear III
Sikkens Standard Hardener
Sikkens Production Activator



Use the Sikkens Measuring
Stick #1 (Black).



100:50
Autoclear III (Ready to
Spray)
Reducer SRA 7.0

Preparation: Sand areas A and B with waterproof #P600 to #P800 grit paper wet. Scuff areas C and D (whole panel) with a white scuff pad, Blend-Prep and water. Rinse with clean water.

Thoroughly clean all areas with M600 Surface Cleaner.

Application method: Refer to the above data for application and fade out to Autocryl solid color and/or 1 step metallic and fade out.

After the fade-out in area D, flash for a minimum of 10 minutes.

MIX AND APPLY AUTOCLEAR III AS FOLLOWS:

100 parts by volume Autoclear III
50 parts by volume Sikkens Standard Hardener
30 parts by volume Sikkens Production Activator

With this normal mixture of Autoclear III (Ready to Spray), add 50% Reducer SRA 7.0.

SPOT REPAIRS WITH AUTOCRYL®

ALTERNATE PROCESS:

(FOR AUTOCRYL SOLIDS AND 1 STEP METALLICS) CONTINUED:

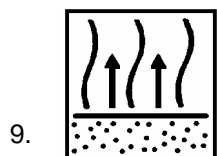


2–3x1
HVLP Siphon
0.071"–0.087" (1.8–2.2 mm)
HVLP Gravity
0.051"–0.059" (1.3–1.5 mm)
Max 10 psi (max 0.8 bar)

With this over reduced Autoclear III, first spray a thin coat only on fade out area D. Flash for 3–5 minutes. Apply one or two single coats of the same mixture of Autoclear III over the whole panel*. If this is not possible, dissolve overspray edge with pure Reducer SRA 7.0.

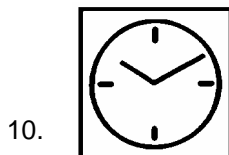
NOTE:

*If blending of the clearcoat is inevitable (sail panels), the preparation should be as follows: restore gloss and color with a medium grade compound, then clean with M600 Surface Cleaner.



3–5 minutes at 70°F (20°C)

Allow 3–5 minutes flash time between coats of clear.



Allow appropriate dry time for activator used.

ALTERNATE PROCESS (FOR AUTOCRYL METALLICS):

First spray a single coat of Autoclear III (mixing ratio: 100:50:30, then add to this ready-to-spray clear, 50% Reducer SRA 7.0) over areas A, B, C and D. Then spray Autocryl (standard mixing ratio) in area A until complete opacity is achieved. Control color in area B. After approximately 10 minutes at 70°F (20°C), apply 1, maximum 2, single coats of Autoclear III (mixing ratio: 100 parts ready to spray + 50% Reducer SRA 7.0) over areas A, B, C and D. Immediately thereafter, fade out with normally mixed Autocryl metallic into the clearcoat.

Refer to the following Technical Data Sheets for more information:

- Autocryl
- Autoclear III



SPOT REPAIRS WITH AUTOCRYL®

SAFETY ASPECTS:

READY TO SPRAY VOC:

Autocryl (3:1:1):	4.6 lb/gal	550 g/liter
Ready To Spray Autocryl (100:50) with Reducer SRA 7.0:	5.7 lb/gal	680 g/liter
Autoclear III (100 ready to spray + 50% Reducer SRA 7.0):	5.3 lb/gal	635 g/liter

NOTICE:

Do not handle until the Material Safety Data Sheets have been read and understood. Regulations require that all employees be trained on Material Safety Data Sheets for all chemicals with which they come in contact. The manufacturer recommends the use of an air-supplied respirator when exposed to vapors or spray mist.