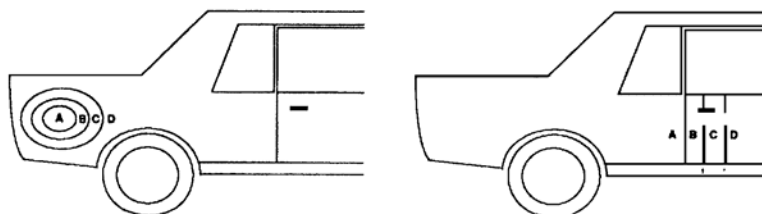


SPOT REPAIRS WITH AUTOBASE[®] PLUS

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 refinish to be made invisible.

PREPARATION:



Clean all areas: first degrease with M600 Surface Cleaner. In areas where VOC emission regulations apply, use recommended compliant Sikkens 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 scuff areas "C" and "D" (whole panel) with a *grey* scuff pad, 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 lightly scuffing with a 3M Clear Blend Prep Pad #07745 (gold). Thoroughly clean areas with a compliant Sikkens Surface Cleaner.

APPLICATION OF AUTOBASE PLUS SPOT REPAIRS:

1.



Contains acrylic resins and other ingredients.

3.



Use the Sikkens Measuring Stick #1 (Black).

2.


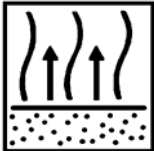


100:50
Autobase Plus
Autobase Plus Reducer

SPOT REPAIRS WITH AUTOBASE® PLUS

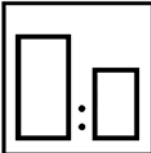



APPLICATION CONTINUED

For Autobase Plus solid colors:

4.  2X1
HVLP Siphon
1.8–2.2 mm
HVLP Gravity
1.3–1.5 mm
Max 10 psi (max 0.8 bar)
5.  3–5 minutes at 70°F (20°C)
- Application Method:**
Spray single coats of Autobase Plus in areas A & B until opacity is achieved. Extend each coat slightly beyond the previous one. Flash between coats
- It is acceptable to accelerate flash by blowing air on the spot repair with the spray gun. Tack off between coats.

SOLID COLOR FADEOUT:


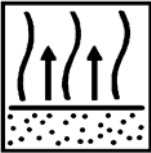



Prior to applying the fade out coats, add to the ready to spray color, 50 parts by volume Reducer SRA 7.0. This will make the color transparent, facilitating a more uniform blend with the original color.

6.  100:50
Autobase Plus Color RTS
Reducer SRA 7.0
7.  1x1
HVLP Siphon
1.8–2.2 mm
HVLP Gravity
1.3–1.5 mm
Max 10 psi (max 0.8 bar)
8.  15–20 minutes at 70°F (20°C)
9.  Apply Autoclear III or
Autoclear HS +
- Mix as follows:**
100 parts by volume Autobase Plus RTS
50 parts by volume Reducer SRA 7.0
- With this transparent color, spray 1 thin coat, extending beyond the repair area. Fading out into area “C”.
- Allow 15–20 minutes at 70°F (20°C) before final tack and applying the clearcoat.

SPOT REPAIRS WITH AUTOBASE[®] PLUS

APPLICATION:

For Autobase Metallic Colors:

4.  2x1
HVLP Siphon
1.8–2.2 mm
HVLP Gravity
1.3–1.5 mm
Max 10 psi (max 0.8 bar)
5.  3–5 minutes at 70°F (20°C)
6.  1–2x1
7.  15–20 minutes at
70°F (20°C)
8.  Apply Autoclear III or
Autoclear HS +

Application Method: Spray 1 medium coat of Autobase Plus metallic in areas “A” and “B”. After 3–5 minutes flash off, spray the same area under repair until opacity is achieved, extending each coat. Flash between coats.

It is acceptable to accelerate flash by blowing air on the spot repair with the spray gun. Tack off between coats.

Lower air pressure, apply in areas A and B, extend distance and fade out into areas “C” and “D”, extending well into these areas. Lowering the air pressure is not necessary with HVLP. However, it may be done for color control.

Allow 15–20 minutes at 70°F (20°C) before final tack and applying the clearcoat.

NOTES:

The best color control is usually achieved by adjusting the air pressure and gun distance. Tack off between coats.

Fade out by extending application into areas “C” and “D”. Do not trigger off while pointing the gun at the repair panel. After each application, remove dry overspray with a Sikkens 1•2•3 Tack Cloth.