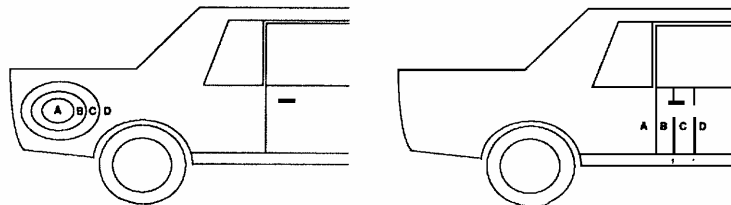


SPOT REPAIRS WITH AUTOBASE[®] PLUS — THREE STEP PROCESS

DEFINITION: A three step pearl color consists of 3 layers.
1st step – the foundation color (solid color).
2nd step – the Autobase Plus mica color (a very transparent pearl effect).
3rd step – the clearcoat (to provide gloss and protection).

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:



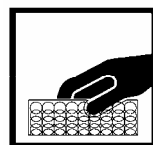
Clean all areas: first degrease with M600 Surface Cleaner. In areas where VOC emission regulations apply, use recommended compliant Sikkens Surface Cleaner.

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.



1.

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, 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.




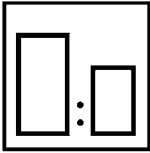
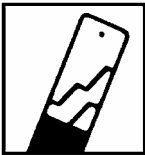
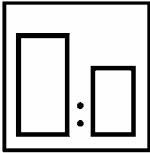


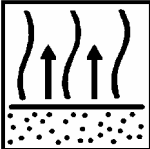
2.

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.

SPOT REPAIRS WITH AUTOBASE[®] PLUS — THREE STEP PROCESS

APPLICATION OF AUTOBASE PLUS (THE FOUNDATION COLOR):

TO COMPLY WITH NATIONAL RULE VOC LEVELS.

1.  Contains acrylic resins and other ingredients. When mixed, also contains isocyanates
2.  100:10
Autobase Plus (foundation)
Sikkens Standard Hardener
or Sikkens XP Hardener
3.  Use the Measuring Stick
14 (Blue)
4.  100:50
Autobase Plus (foundation)
Autobase Plus Reducer
5.  Use the Measuring Stick
#1 (Black)
6.  2x1
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)
7.  3–5 minutes at 70°F (20°C)

To comply with National Rule VOC levels. Add 10 % hardener.

100 parts by volume Autobase Plus
10 parts by volume Sikkens
Standard or XP Hardener.

After adding hardener,
Stir the mixture and continue to
mix as follows

Mixing Ratio:

100 parts by volume Autobase Plus
50 parts by volume Autobase Plus
Reducer Fast or Medium

Application Method:

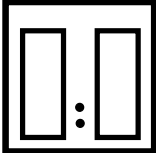
Spray single coats of Autobase Plus
in area "A", extending slightly
beyond previous coats until opacity
is achieved.


Flash 3–5 minutes and tack between
each coat.

SPOT REPAIRS WITH AUTOBASE[®] PLUS — THREE STEP PROCESS

BLENDING THE FOUNDATION COLOR:

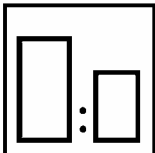
Prior to applying the fade out coats, add to the ready to spray color 100 parts by volume reduced Autobase Plus Pearl Color using the 1 to 1 mixture of Autobase Plus Solid Color with Autobase Plus Pearl Color. This will make the foundation color transparent, facilitating a more uniform blend with the foundation color.


8.  100:100
Autobase Plus foundation color, ready to spray.
Autobase Plus pearl color ready to spray

Add the reduced Autobase Plus Pearl Color to the ready to spray Autobase Plus foundation color, ratio 100:100.
9.  1–2x1
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 transparent foundation color, spray 1 to 2 thin coats. Extending beyond the repair area, gradually fading out into area "C". Allow for flash-off between coats.

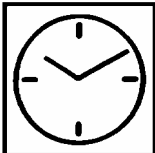
OPTIONAL FADEOUT


- A.  100:50
Autobase Plus Mix
Autobase Plus Blending Additive

For final blending, add to this mix, 50 parts by volume Autobase Plus Blending Additive.
- B.  1x1

Spray a final fade out coat only in area "C".

APPLICATION CONTINUED:

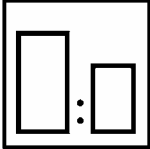
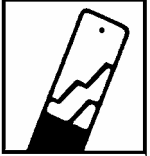


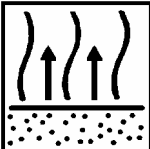


10.  15–20 minutes at 70°F (20°C)

Allow the foundation color to dry for 15–20 minutes before applying the pearl coat color.
11.  Apply Autobase Plus Pearl Color.

Note: It is very important that this foundation color is as invisible as possible before proceeding with the Autobase Plus pearl coat color.

SPOT REPAIRS WITH AUTOBASE[®] PLUS — THREE STEP PROCESS

APPLICATION OF AUTOBASE PLUS (PEARL COLOR):

1.  100:50
Autobase Plus Pearl Color
Autobase Plus Reducer
Medium
2.  Use the Sikkens
Measuring Stick #1 (Black).
3.  3–4x1
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)
4.  **Application Method:**
Spray 3–4 even, thin coats of pearl.
Alternate the spraying area with
each coat.
5.  2–3 minutes at 70°F (20°C)
6.  15–20 minutes at 70°F (20°C)
7.  Apply clear coat

NOTE:

Do not add extra reducer to the Autobase Plus Pearl Color. Fade out as described above. After each application, remove dry overspray with a tack rag.

SPOT REPAIRS WITH AUTOBASE[®] PLUS — THREE STEP PROCESS

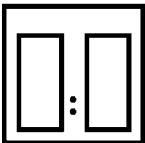
APPLICATION OF AUTOBASE PLUS THREE-STEP

METALLIC COLORS: As the application of 3-step metallic colors is very similar to that of a 3-step pearl color spot repair, we will not repeat every aspect of the process but will highlight the major differences of the process.

After adding hardener, mix the metallic foundation color 100 parts by volume to 50 parts by volume of Autobase Plus Reducer.

BLENDING THE FOUNDATION COLOR:

Apply single coats in area A until opacity is achieved. Extend each coat slightly beyond the previous one. (Do not make any attempt at fade-out yet.)

1.  100:100
Autobase Plus foundation color, Ready to Spray
Autobase Plus mid-coat color, Ready to Spray


Mixing Ratio:

Reduce the mid-coat color 100 parts color to 50 parts Autobase Plus Reducer. Add this ready-to-spray mid-coat color to the ready-to-spray foundation color at a ratio of one to one.

2.  2x1



Application Method:

With this "tinted" transparent foundation color, spray 2 medium coats. Extend beyond the first coats of foundation color, gradually fading out into area C.

3.  15–20 minutes
at 70°F (20°C)

Allow this tinted foundation color to dry to 15-20 minutes before applying the (red) mid-coat color.

APPLICATION OF AUTOBASE PLUS (MID COAT):

1.  3–4x1
2.  Apply Autocoat III or Autoclear III

Mix the mid-coat color 100:50 and apply 3–4 medium wet coats, allowing a flash-off time of 5–10 minutes between coats. Do not overlap in the same areas.

Allow the Autobase Plus mid-coat color to flash/dry for 15-20 minutes before applying clearcoat.

SPOT REPAIRS WITH AUTOBASE[®] PLUS — THREE STEP PROCESS

ALTERNATE PROCESS USING AUTOBASE PLUS BLENDING ADDITIVE AS A CLEAR

FOUNDATION:

It is also possible, prior to repairing Autobase Plus (three-stage process), to spray 1 single coat of Autobase Plus Blending Additive. Flash off for 3–5 minutes, and then follow directions on “Spot Repairs with Autobase Plus—Three Stage Process”.


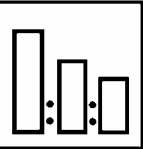


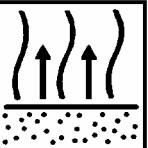

Using Autobase Plus Blending Additive, as a clear foundation coat for fade-out areas will result in an easier blend as far as color, flip tone and effect are concerned.

APPLICATION OF CLEARCOAT:

Autobase Plus is sufficiently dry to clearcoat after 15-20 minutes at 70°F (20°C). Tack the entire repair area and clearcoat with Autoclear III Autoclear HS + or Autoclear Vision HS.

Note: Refer to Autoclear III, Autoclear HS + or Autoclear Vision HS technical data sheets.

Example, Autoclear III:

1.  Contains acrylic resins.
When mixed, Autoclear III
also contains isocyanates.
2.  100:50:30
Autoclear III
Sikkens Standard Hardener
Sikkens Production Activator
3.  Use the Measuring
Stick #1 (Black).
4.  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)
5.  5 minutes at 70°F (20°C)
6.  7 hours at 70°F (20°C)
20 minutes at 140°F (60°C)

Mixing Ratio:

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

Application Method:

Spray 2 to 3 single coats of Autoclear III, the last coat over entire panel. Allow 5 minutes flash time after each coat. Limit the application of coats right next to an adjacent panel.