

SPOT REPAIRS WITH AUTOBASE® PLUS

ALTERNATE PROCESS:

It is also possible, prior to applying Autobase Plus and fading out, 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".






Using this Autobase Plus Blending Additive assists in an invisible blend as far as color, flip tone and effect are concerned.

APPLICATION OF CLEARCOAT:

Autobase Plus is sufficiently dry to clear coat 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: Use clearcoat appropriate to product performance. Refer to Autoclear III, Autoclear HS + or Autoclear Vision HS technical data sheets.

EXAMPLE, AUTOCLEAR III:

1.  Contains xylene and other ingredients. When mixed, also contains isocyanates.
2.  100:50:30
Autoclear III
Standard Hardener
Production Activator
3.  Use the Sikkens
Measuring Stick #1 (Black).
4.  2x1
HVLP Siphon
1.8–2.2 mm
HVLP Gravity
1.3–1.5 mm
Max 10 psi (max 0.8 bar)
5.  5 minutes at 70°F (20°C)

Application Method:

Spray 2 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.

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APPLICATION OF CLEARCOAT (CONTINUED):


6.  7 hours at 70°F (20°C)
20 minutes at 140°F (60°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

Example for Autoclear III **Note:** Procedures listed below should also be used for Autoclear HS +. Refer to your local VOC regulations for "Specialty Coating" compliance.

Application Method: When blending of the clear is inevitable (sail panel). Hard line each coat (do not fade out) and extend the application of the final coat.

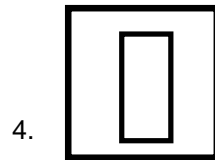
1.  100:50
Autoclear III, ready to spray
Reducer SRA 7.0

After the last coat of clear is sprayed in the sail panel area, add to the ready to spray clear 50 parts by volume Reducer SRA 7.0
2.  Use the Sikkens
Measuring Stick
3.  1 x 1
HVLP Siphon
1.8–2.2 mm
HVLP Gravity
1.3–1.5 mm
Max 10 psi (max 0.8 bar)

Apply one single coat of this reduced clear over the hard line overspray edge. Into the prepared area (sail panel), melting in previous overspray.

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Application Continued



Reducer SRA 7.0
Ready to Spray

Use pure Reducer SRA 7.0 to
dissolve overspray edge.



2 x 1

Spray 1 thin coat. Flash for 15
seconds. Apply a final thin coat.

AFTER TREATMENT:

After the repair is completely dry, the fade out area (if any) may be polished with an ultra-fine polishing compound and waxed. (Please see *Dry-To-Polish* time of the products used.)

NOTE:

Refer to the following Technical Data Sheets for more information:

- Autobase Plus Blending Additive
- Autobase Plus Solid, Metallic and Pearl Colors
- Autoclear III
- Autoclear HS +
- Autoclear Vision HS

SAFETY DATA:

READY TO SPRAY VOC:

Autobase Plus 100:50 with Autobase Plus Reducer:
6.5 lb/gal 780 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.