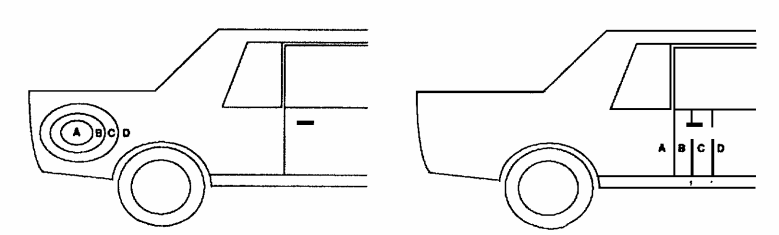
SPOT REPAIRS WITH AUTOBASE® PLUS SINGLE STAGE CONVERTER

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

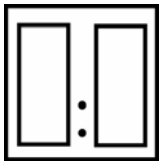
In the above drawings, area “A” is the area under repair. Shape it and build up the area using the appropriate products. After the products have dried, sand the area under repair “A” as well as the adjacent area “B”. When spot repairs are made, wet sanding by hand is preferred.

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 SPOT REPAIR, AUTOBASE PLUS SINGLE STAGE CONVERTER:

1. 

   Contains acrylic resins
   And other ingredients.
   When mixed, also
   contains isocyanates.

2. 

   Mix 100:100
   Autobase Plus mixed color.
   Autobase Plus Single Stage
   Converter

Mixing ratio:
100 parts by volume of mixed color, add;
100 parts by volume of Autobase Plus Single Stage Converter

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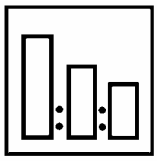
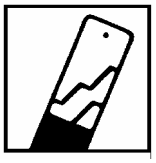
APPLICATION CONTINUED:

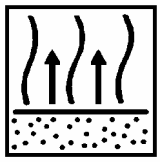
3.  Stir thoroughly

4. 
Then Mix
100:25:35
–Mixed color and Single Stage Converter.
–Sikkens XP Hardener.
–Autocryl Reducer.

To the converted Autobase Plus color;
Add the hardener and reducer.
100 parts by volume, color.
25 parts by volume Sikkens XP Hardener.
35 parts by volume Autocryl Reducer.

5.  Use the Sikkens measuring Stick # 5 (Orange)

6. 
2 – 3x1
HVLP Siphon, 1.8–2.2 mm
HVLP Gravity, 1.3–1.5 mm
Max 10 psi (max 0.8 bar

7.  5 – 10 minutes at 70°F (20°C

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.

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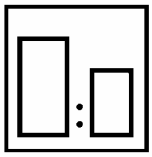
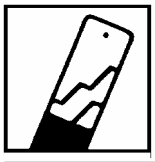
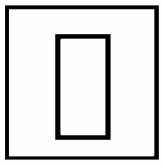
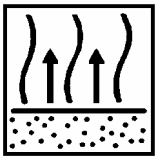
BLENDING:

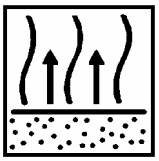
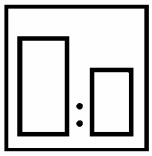
1.		100:50 –Single Stage color, ready to spray. –Reducer SRA 7.0	Add to the ready to spray paint, 50 parts by volume Reducer SRA 7.0.
2.		Use the Sikkens Measuring Stick # 1 (black)	
3.		1x1 HVLP Siphon (1.8–2.2 mm) HVLP Gravity (1.3–1.5 mm) Max 10 psi (max 0.8 bar	**Application Method:** With this over-reduced material, extend the application, fading out into area D.
4.		–Sikkens Reducer SRA 7.0 ready to spray	
5.		2 X 1 20 – 30 psi	Use pure Reducer SRA 7.0 to dissolve overspray edge. –Spray 1 medium coat. Flash for 15 seconds. –Apply final thin coat.
6.		15 seconds at 70°F (20°C) between coats of Reducer SRA 7.0	

ALTERNATE PROCESS:

(USING AUTOCLEAR III OR AUTOCLEAR HS+ AS A BLENDING CLEAR):

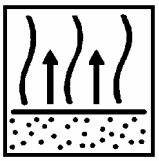
1.			**Preparation:** Sand areas A and B with waterproof #P600 to #P800 grit paper wet. Scuff areas C and D (whole panel) with a white scuff pad, Blend-Prep and water. Rinse with clean water.
2.		M600 Surface Cleaner	Thoroughly clean all areas with M600 Surface Cleaner.

SPOT REPAIRS WITH AUTOBASE® PLUS SINGLE STAGE CONVERTER

3.			**Application method:** Refer to the above data for application and fade out to Autobase Plus Single Stage solid color and fade out.
4.		10 minutes at 70°F (20°C)	After the spot repair application. Allow 10 minutes drying, then mix and apply the clear as follows:
5.		100:50 –Clearcoat, ready to spray –Reducer SRA 7.0	**Clear coat:** **Prepare clear coat per TDS;** Add to the ready to spray clear 50 parts by volume Reducer SRA.
6.		Use the Sikkens Measuring Stick # 1 (black)	Use the first two columns on the measuring stick
7.		2 – 3X1 HVLP Siphon, 1.8–2.2 mm HVLP Gravity, 1.3–1.5 mm Max 10 psi (max 0.8 bar)	With this over reduced clear, first spray a thin coat only on the fade out area D. flash for 3 – 5 minutes. Apply one or two single coats over the whole panel∗. If this is not possible, dissolve the overspray edge with pure Reducer SRA.

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.

BLENDING OF THE CLEAR:

1.		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.
2.		15 seconds at 70°F (20°C) between coats of Reducer SRA 7.0	

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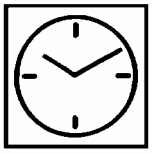
3. 

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.)

Refer to the following Technical Data Sheets for more information:

– Autobase Plus Single Stage Converter
– Autoclear III
– Autoclear HS +

SAFETY ASPECTS:

READY TO SPRAY VOC:

(100:25:35)
When mixed ready to spray,
Autobase Plus and Autobase Plus Single Stage Converter yield a VOC content of:
5.0 lb/gal, 600 g/liter.

Autoclear HS + (100 ready to spray + 50% Reducer SRA 7.0)	5.1 lb/gal	612 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.