Autobase Plus training

- Autobase Plus
- Final Preparation before application
- Spot repair 2 coat system
- Spot repair 3 coat system

sikkens

Autobase Plus

AkzoNobel

Product assortment

Autobase Plus MM toners

- 3,75 liter
- 1 liter

Special Effect Colors

- ½ liter

Product assortment

Autobase Plus Reducers

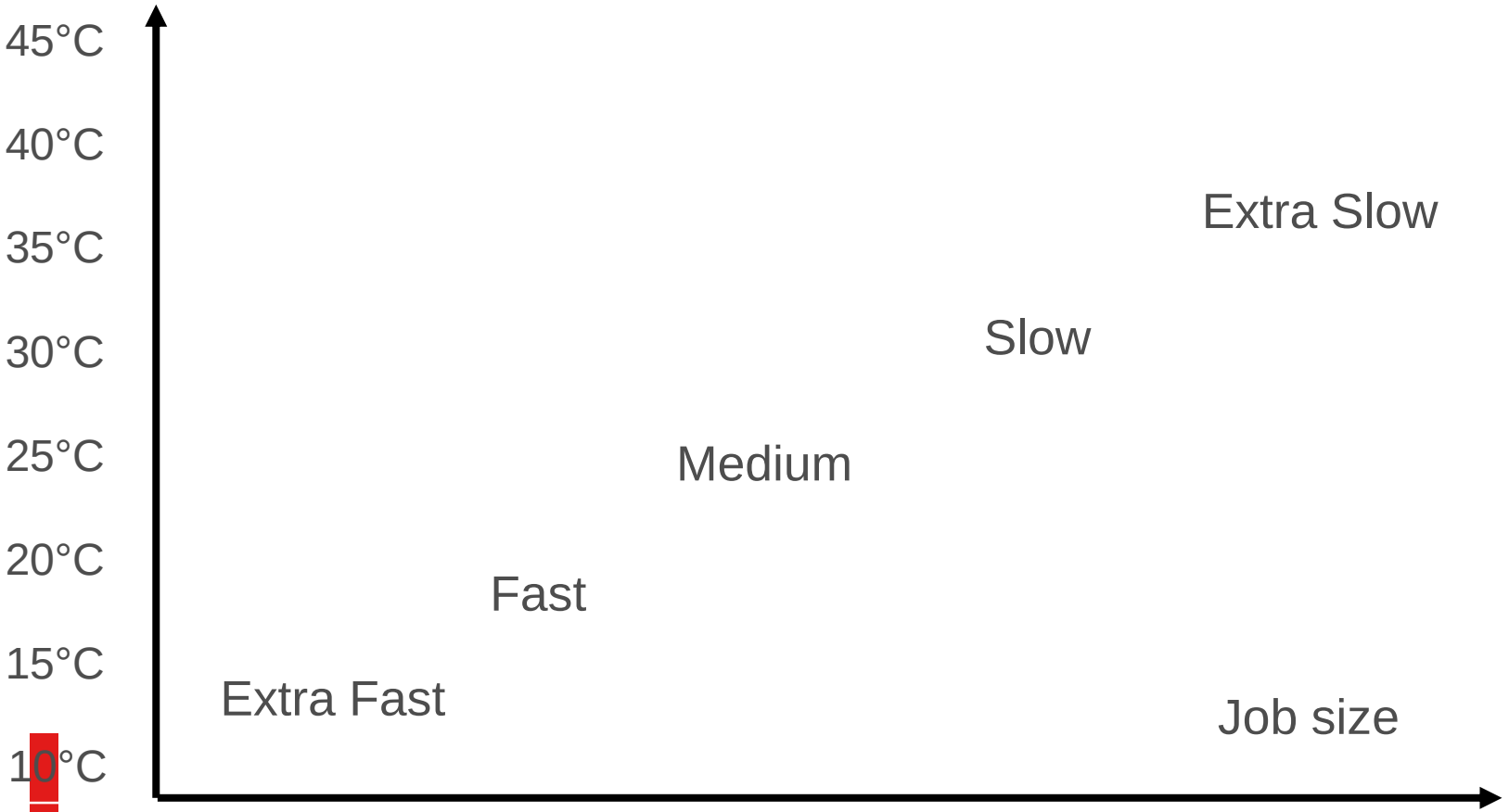
- Extra Fast
- Fast
- Medium
- Slow
- Extra Slow

Autobase Plus Blending Agent

- Pre-coat for easier color fade-out

AkzoNobel

Reducer selection



Suitable substrates

All Existing OEM finishes

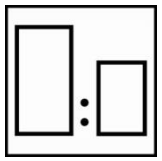
- With the exception of thermoplastic acrylic finishes

All current Sikkens preparatory products.

- With the exception of direct application on:
  - Washprimer CR
  - 1 K Washprimer CF

Mixing sequence

– Stir thoroughly

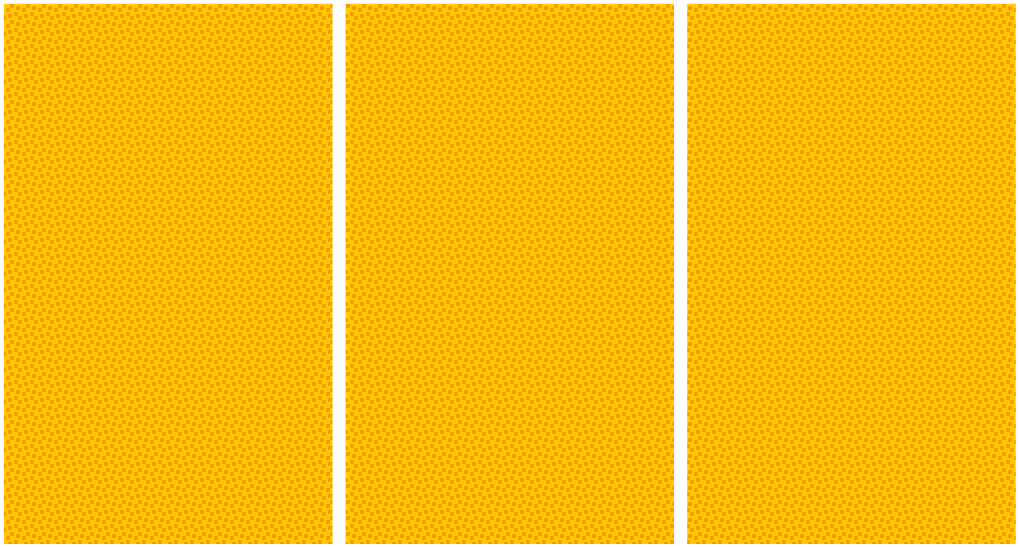


– 100 : 50

– Mixing stick 1

– Stir thoroughly

Mixing without formula



Q 065

Mixing ratio 3:1

– Stick nr. 9

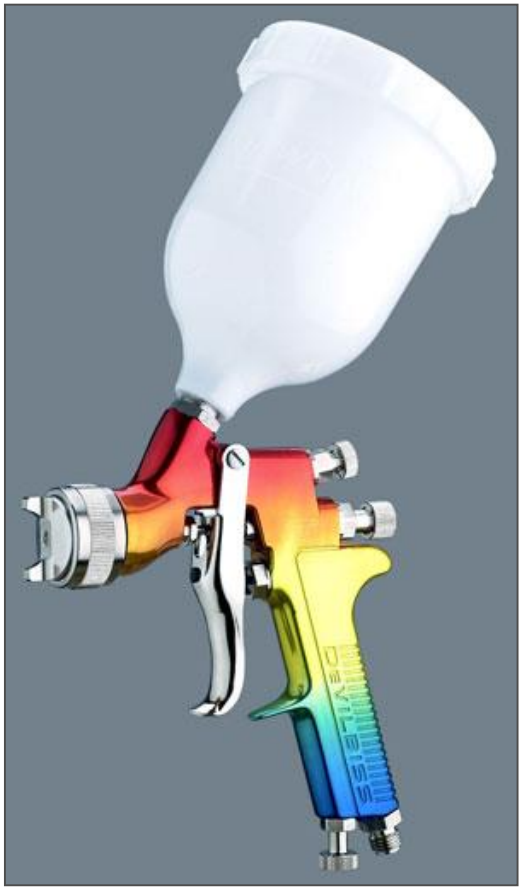
Spray gun set-up

Spray gun set up:

- 1.2 - 1.4

Application pressure:

- 2 - 3 bar at the spray-gun air inlet



Points of attention

Open time / re-coatability:

Autobase Plus Solid

- 5 Hours at 20°C

Autobase Plus Metallic / Pearl

- 48 Hours at 20°C

Open-time extension of solid colors up to 48 hours

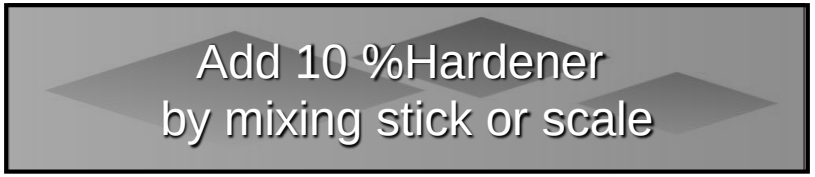
- Add 10% P hardener (by weight or volume)

Points of attention

– Stir MM color thoroughly

– Stir thoroughly

– Stir thoroughly



Points of attention

Do not add Elast-O-Actif

- Autobase Plus holds flexible properties

Exception for extreme soft plastics

- Foam spoilers
- Add 10% P hardener (by weight or volume)

Pot-life

Mixed with Plus Reducer

- ± 6 months at 20°C
- If stored in closed can

Stir thoroughly before use

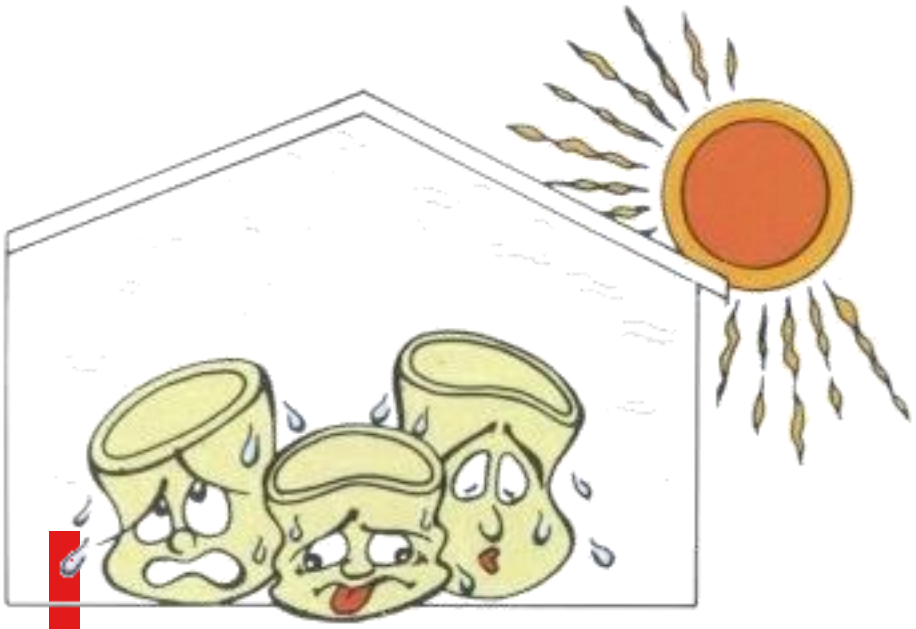
Mixed with hardener

- ± 4 hours at 20°C

Storage and shelf-life

Store between 10°C and 35°C Check T.D.S. for shelf-life

Avoid too much ° fluctuation



Autobase Plus

MM Codification

MM toner assortment

MM mixing colors

- Can differ per customer
- Low users

Solid colors

Effect colors

- 22 Pearls - Q 900 range
- 9 Metallic - Q800

3 Flip-tone controllers

- Q 190
- Q 191
- Q 195

1 Connector

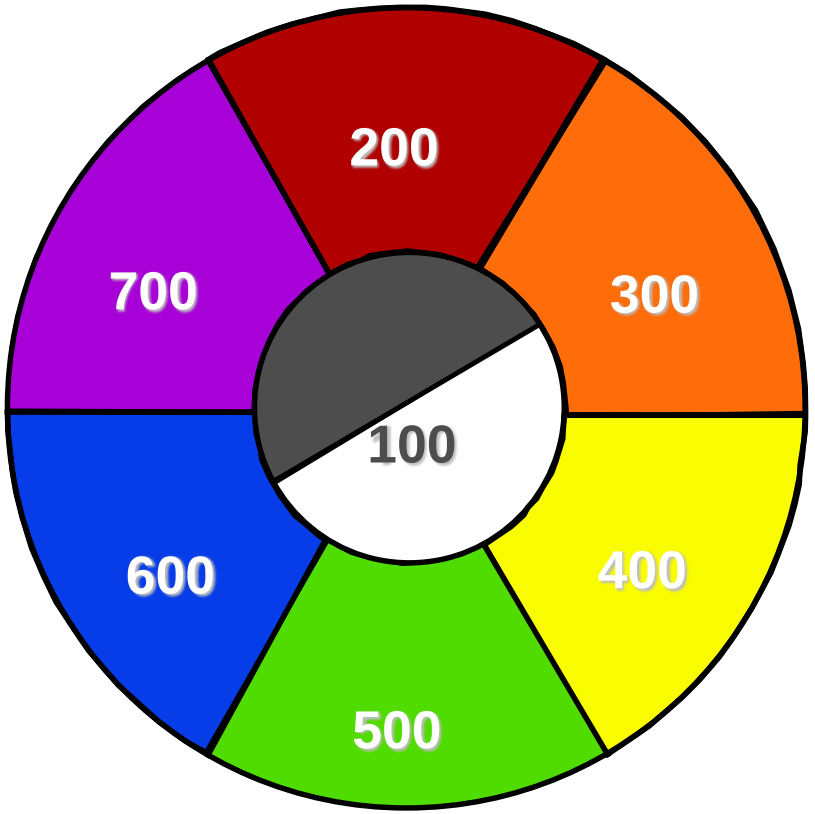
- Q 065

1 Transparency Enhancer

- Q 070

MM codification

0-99	Connectors
100	Black and white
200	Red
300	Orange
400	Yellow
500	Green
600	Blue
700	Violet
800	Metallic toners
900	Pearl toners



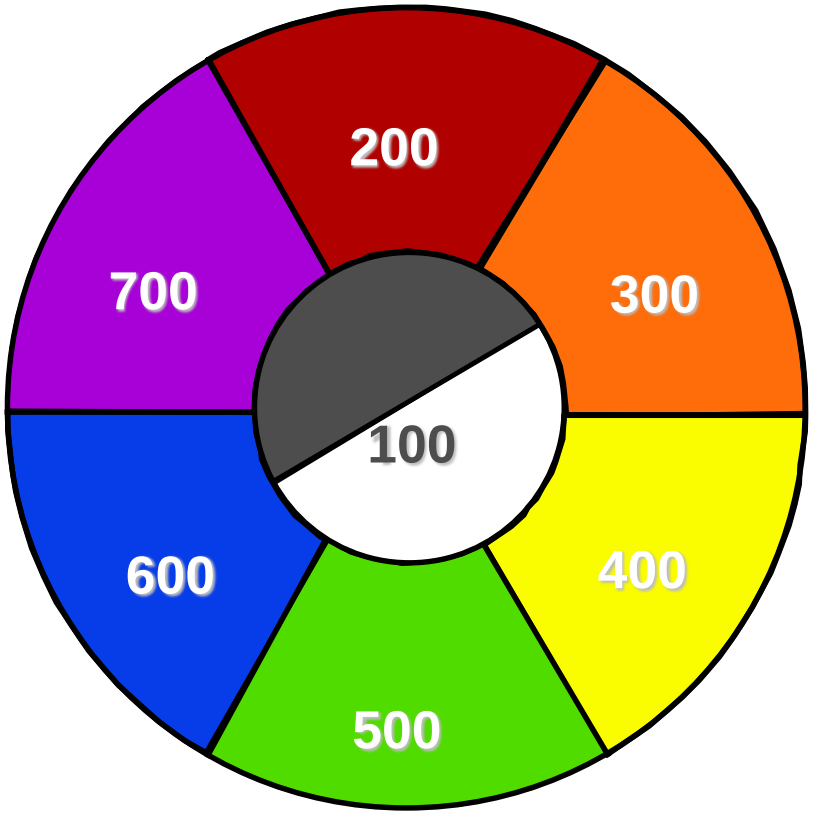
MM Metallic toners

Q = Autobase Plus

8 = Color group

1 = Color direction

1 = Color Flip



E = Coarseness fine

A-B-C-D-E-F-G-H-I-J-K-L-M-N-O-P-Q-R-S-T-U-V-W-X-Y-Z

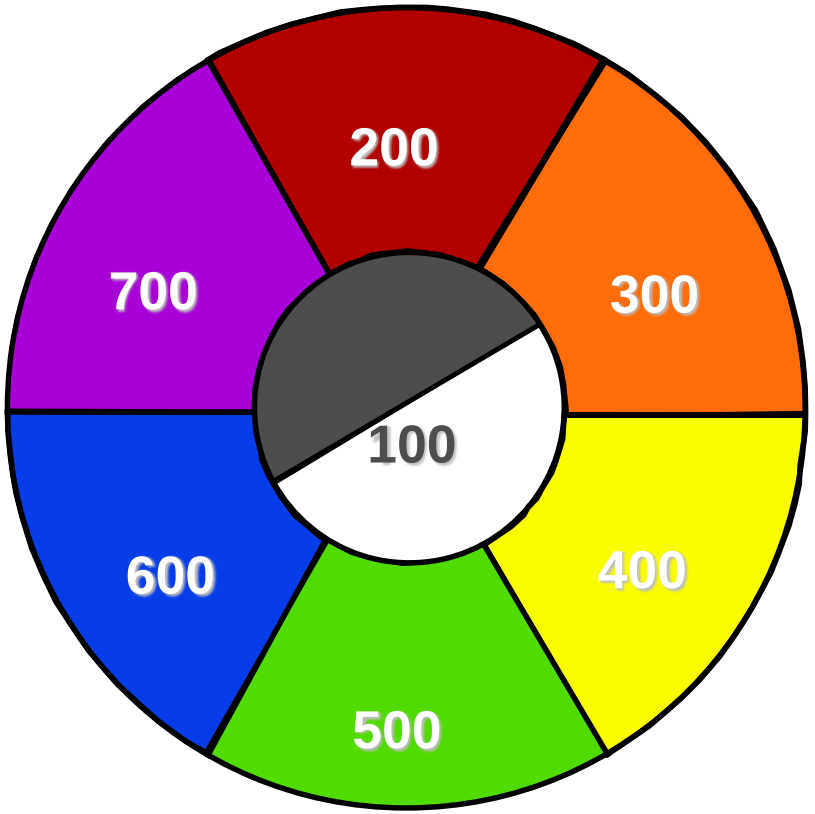
MM Pearl toners

Q = Autobase Plus

9 = Color group

6 = Color direction

4 = Color Flip

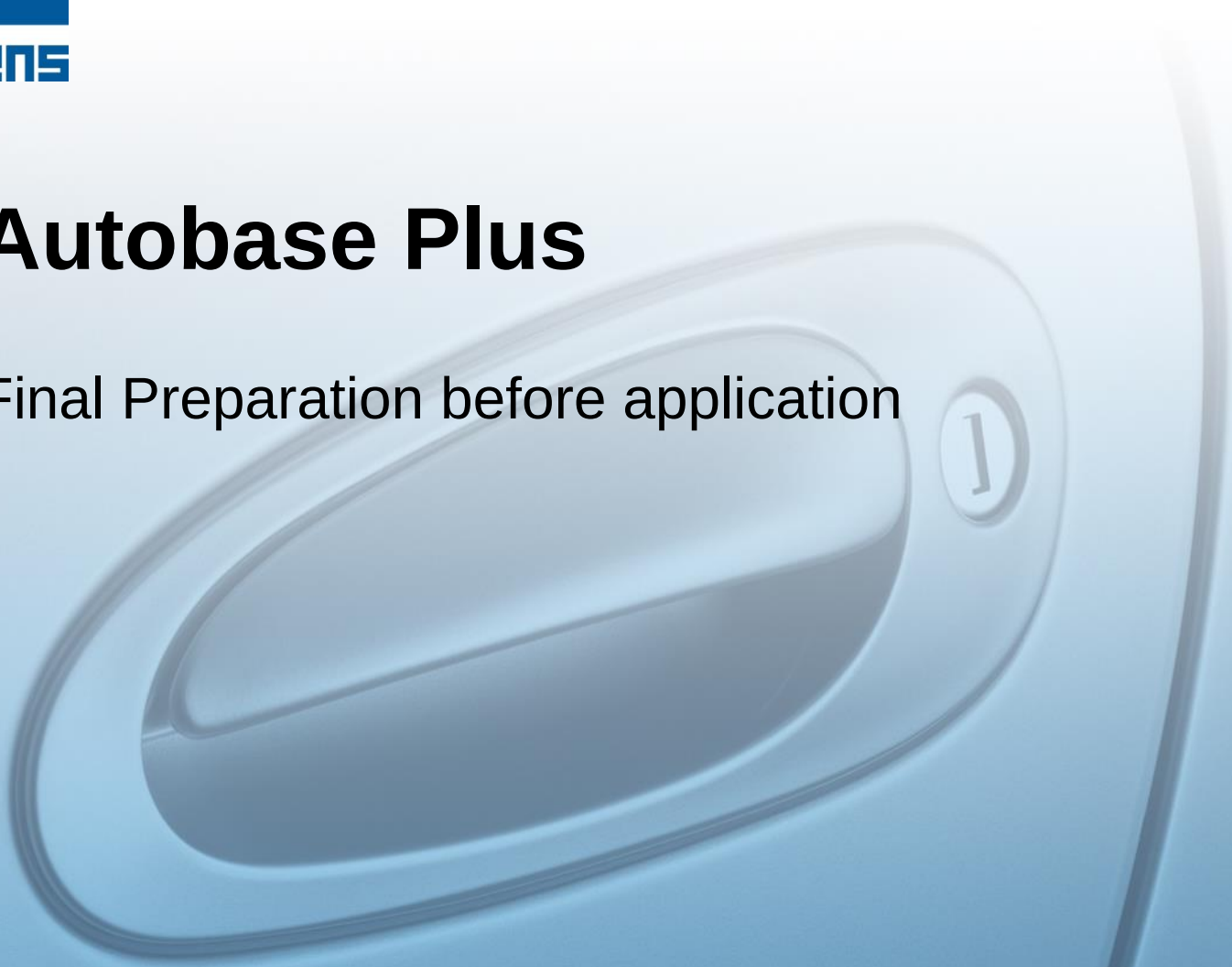


S = Coarseness very coarse

A-B-C-D-E-F-G-H-I-J-K-L-M-N-O-P-Q-R-S-T-U-V-W-X-Y-Z

Autobase Plus

Final Preparation before application



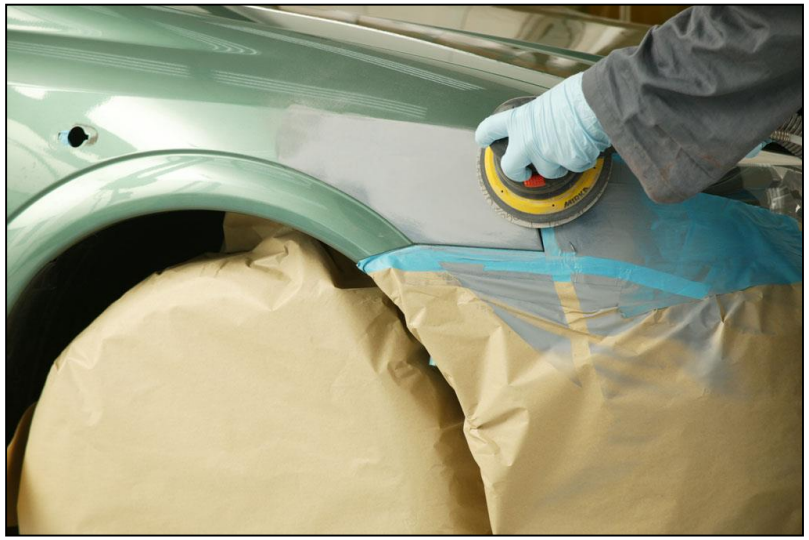
Final sanding

Advised dry sanding steps

- P400
- P500

Advised wet sanding steps

- P800
- P1000



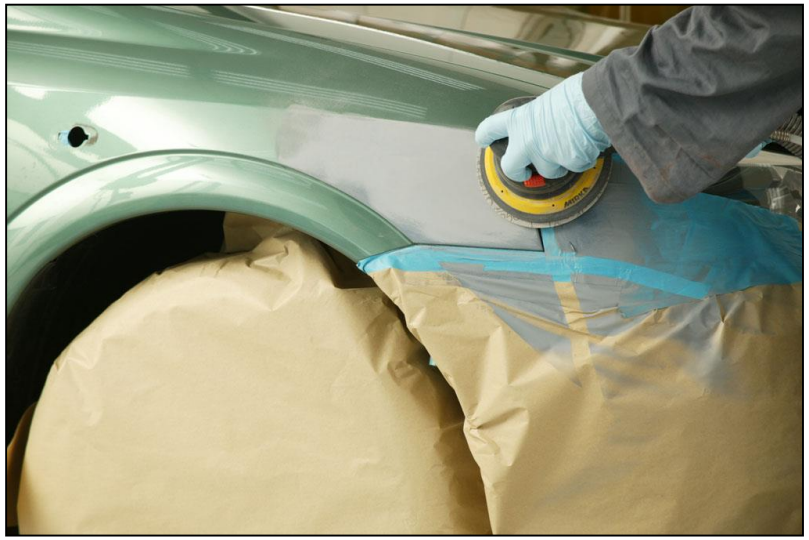
Panel preparation

Panel sanding, i.e. P1000 260L

- Removing surface texture
- Using a soft back pad

Scuffing pad, i.e. Scotch Brite

- Water
- Blend Prep



Masking

Mask tide to the object

- Loosely paper or plastic can generate dust

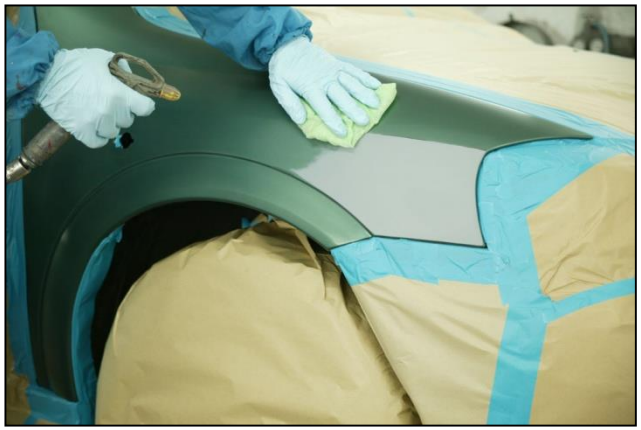
Final surface cleaning

Use high quality absorbent cloths

- One wet cloth
- Wipe with one dry cloth

Wipe dry before evaporation

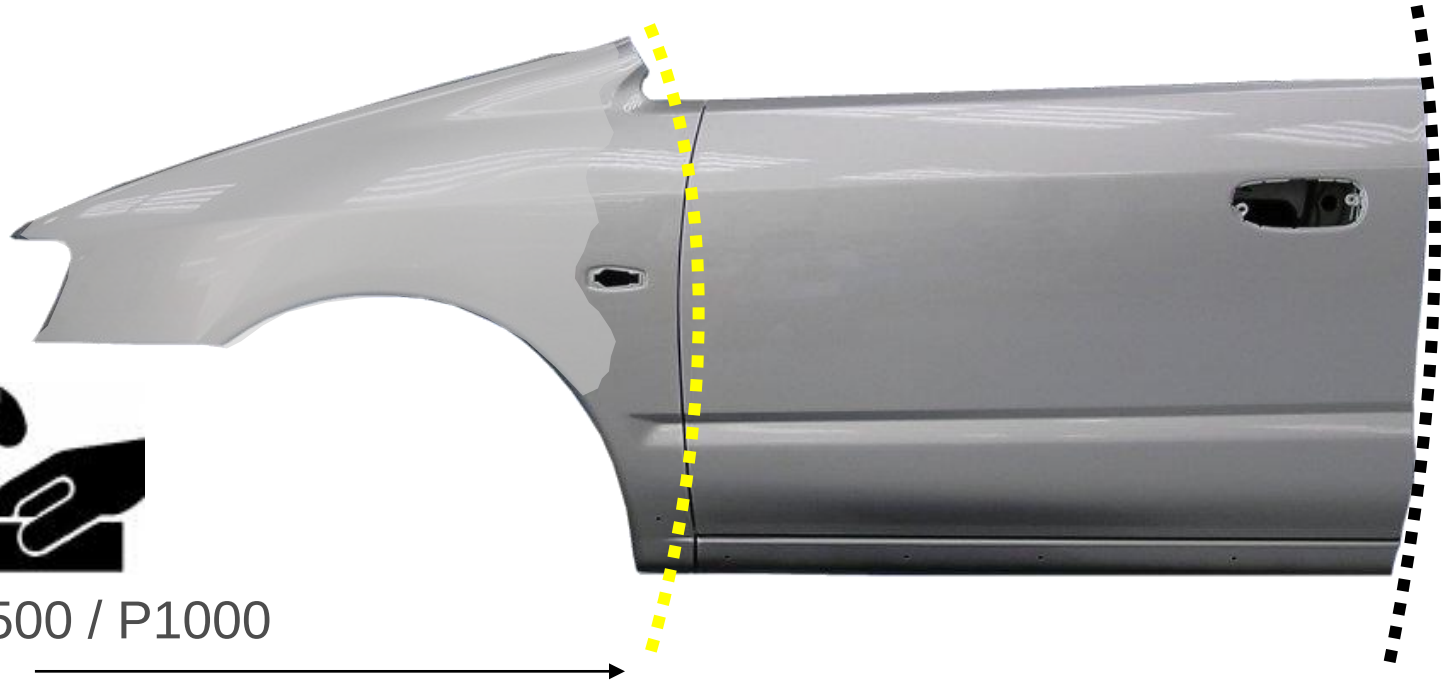
Dust prevention



2 coat system

Blending

Panel-repair



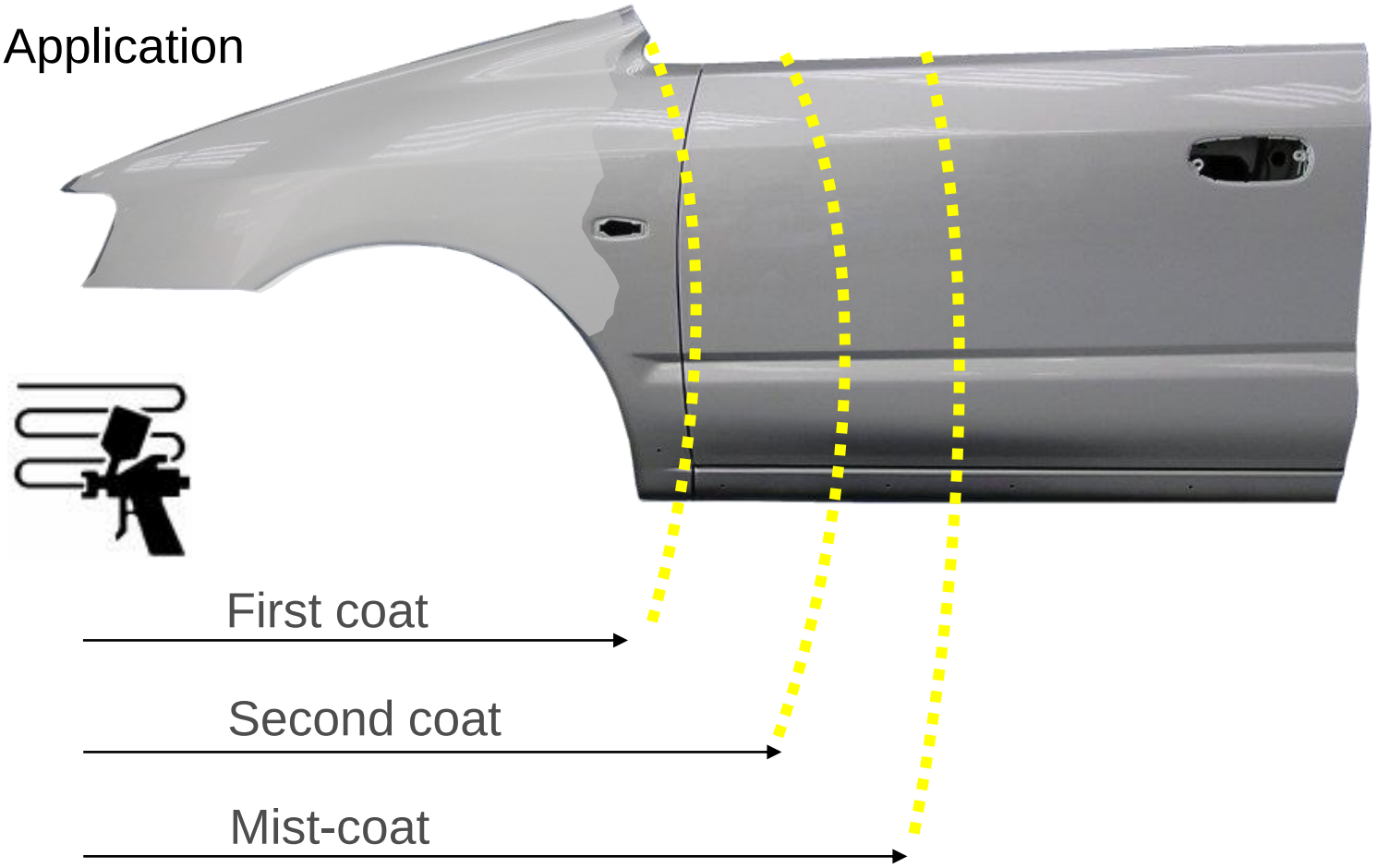
P500 / P1000

Scotch Brite

Degreaser

Panel-repair

Application



Panel-repair

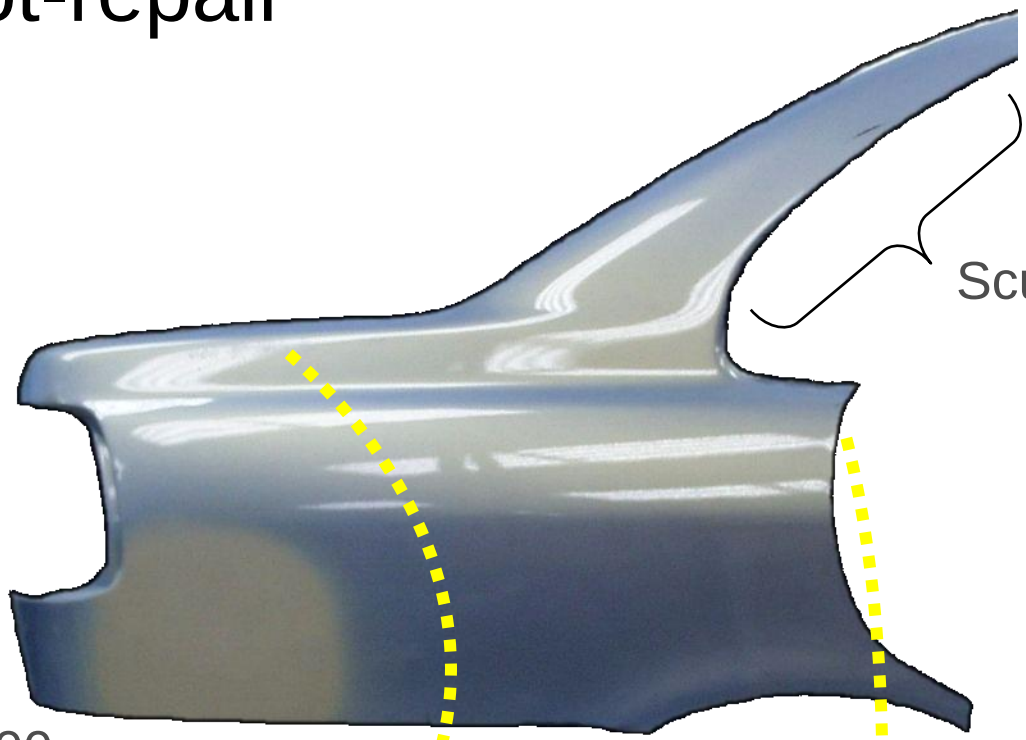
Clearcoat

First coat

Second coat

2-C Spot-repair

Preparation



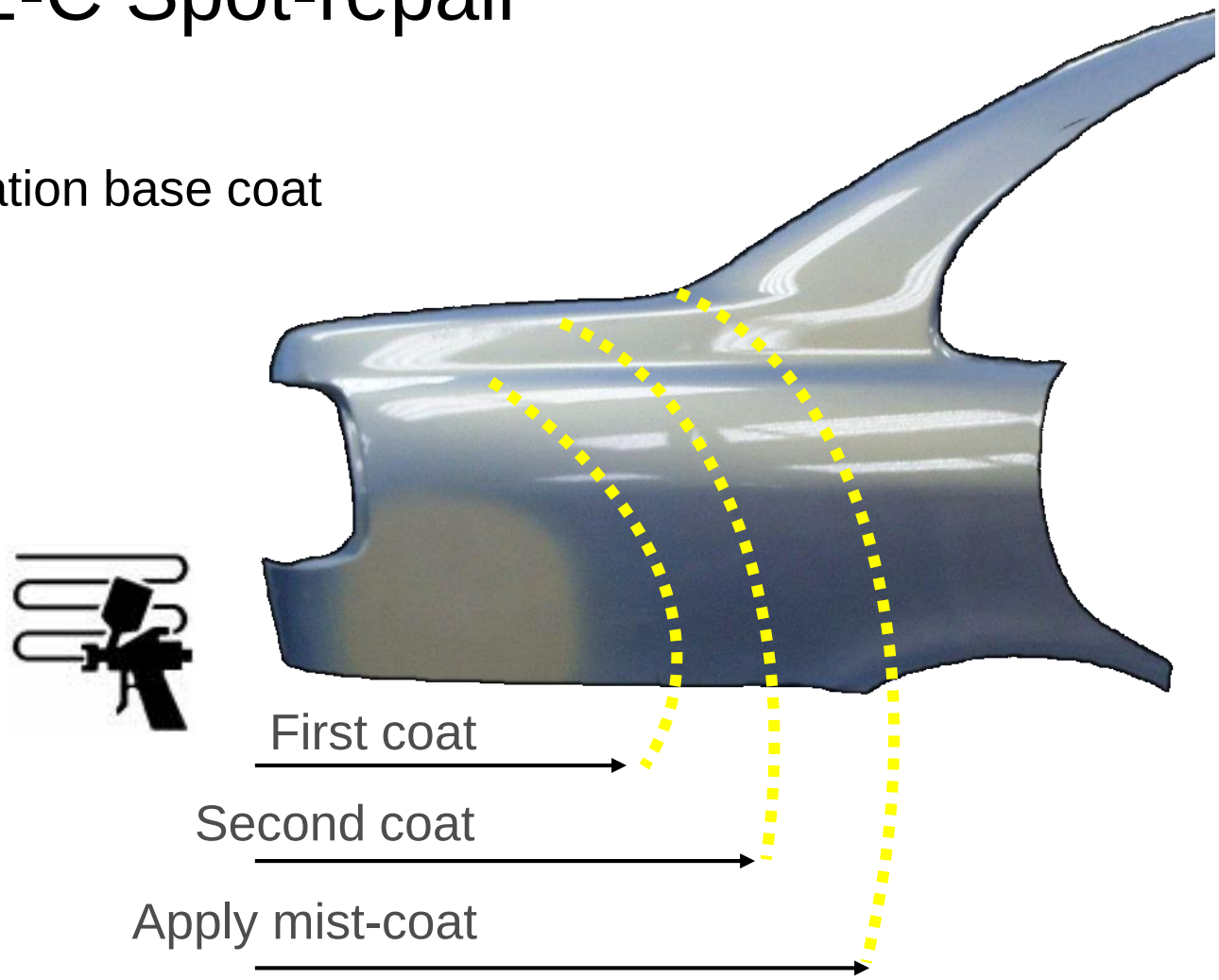
P500 / P1000

Scotch Brite

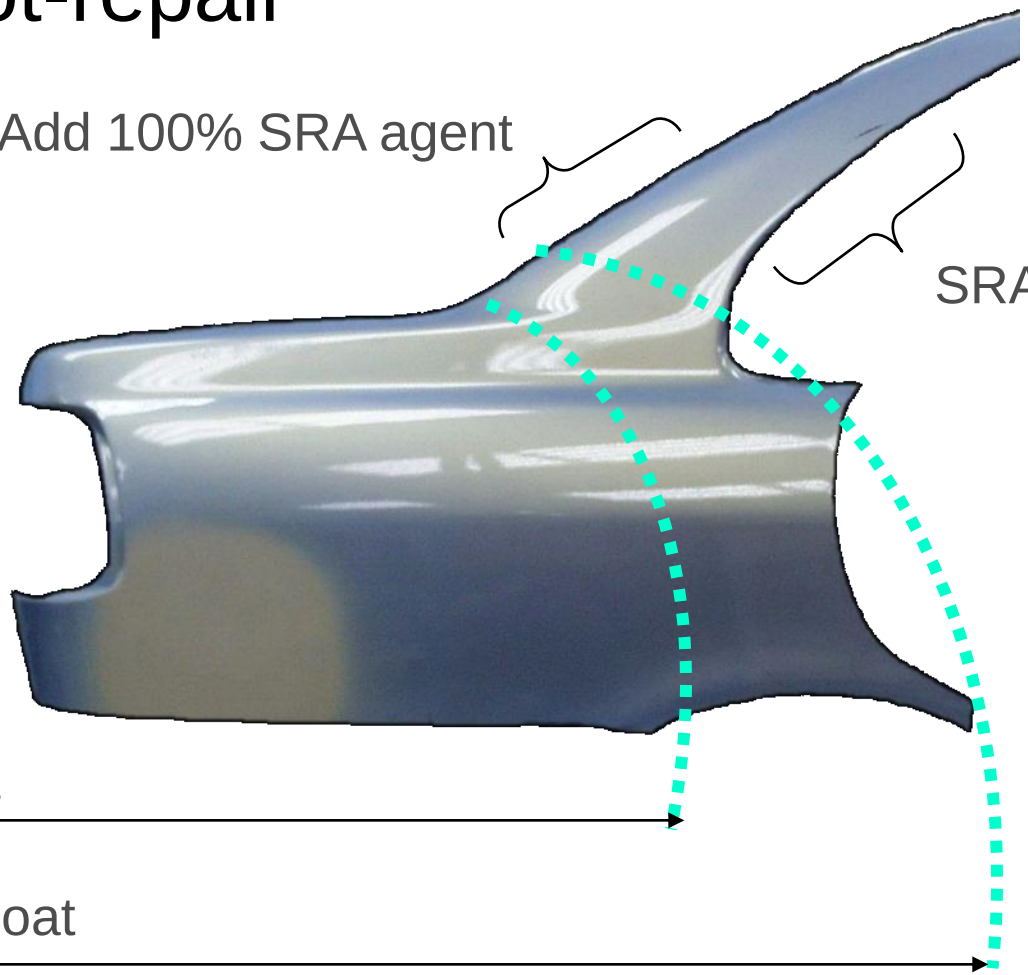
Degreaser

2-C Spot-repair

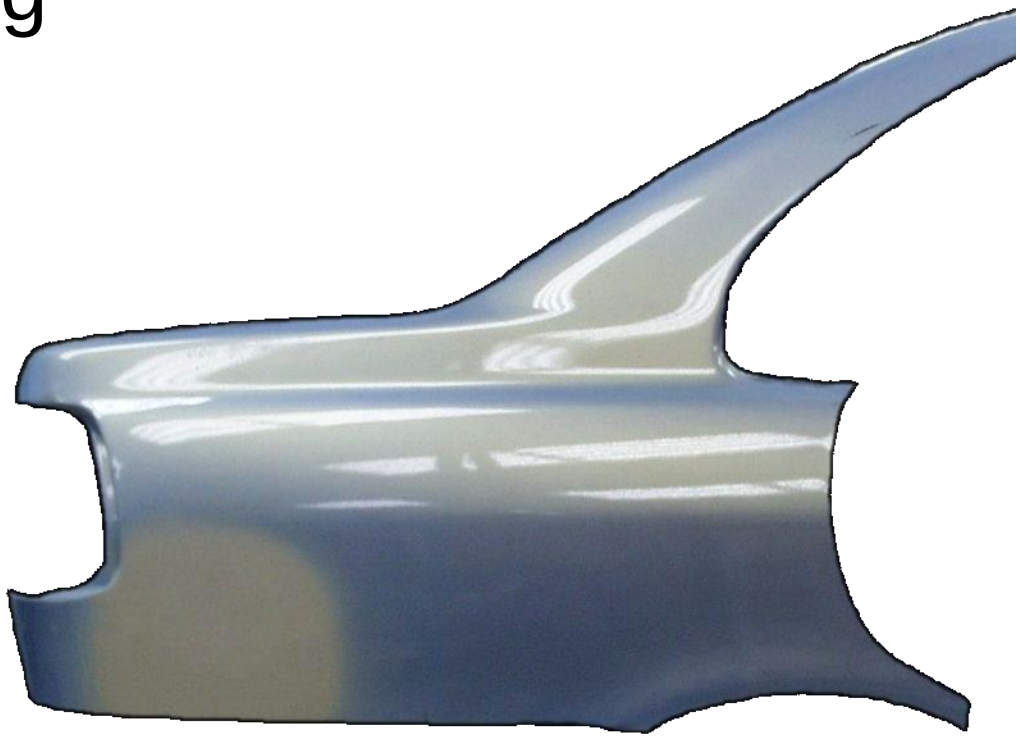
Application base coat

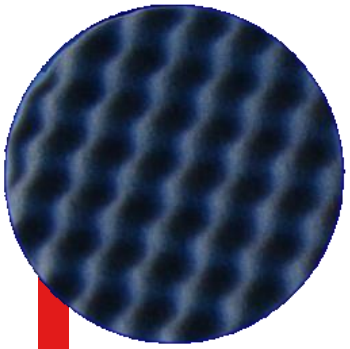


2-C Spot-repair



Polishing





Soft pad with fine polish

3 coat system

1. Foundation coat
2. Effect coat
3. Clearcoat

Program

Introduction

Theory – TDS explanation

3 coat system application

Theory – TDS explanation

Repair 3 coat system

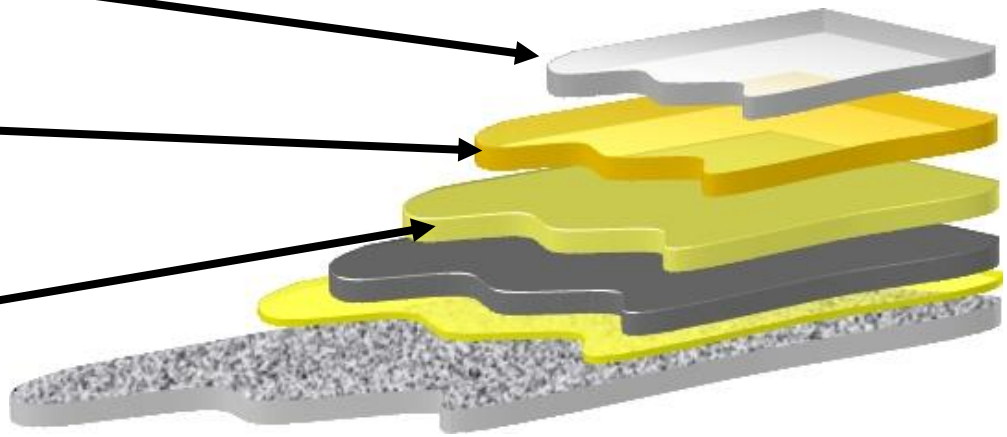
Evaluation 3 coat system

Most common 3 coat system

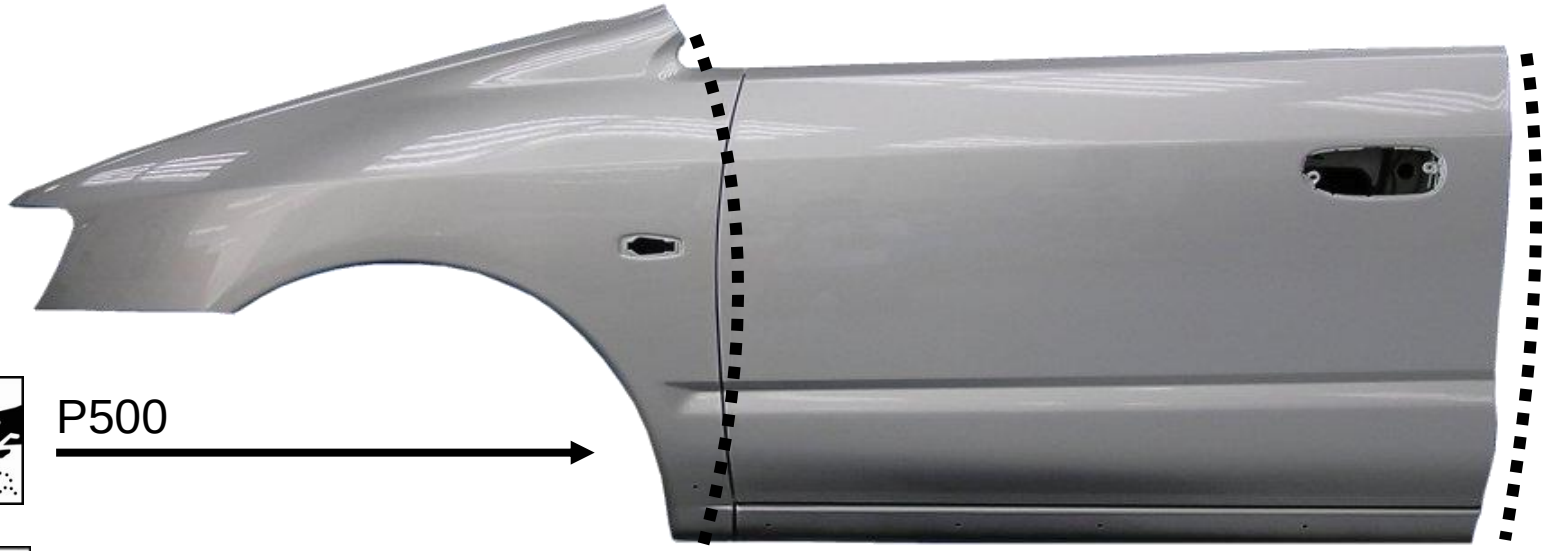
Clearcoat

Pearl effect coat

Solid Foundation coat



3 coat system preparation



P500

P1000 or Scotch brite Grey

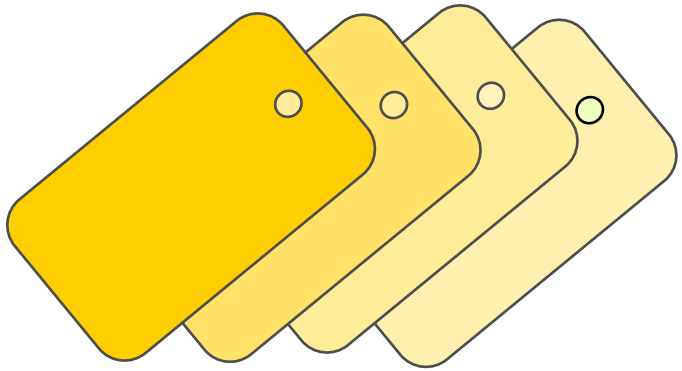
Surface Cleaning

Color check (video)

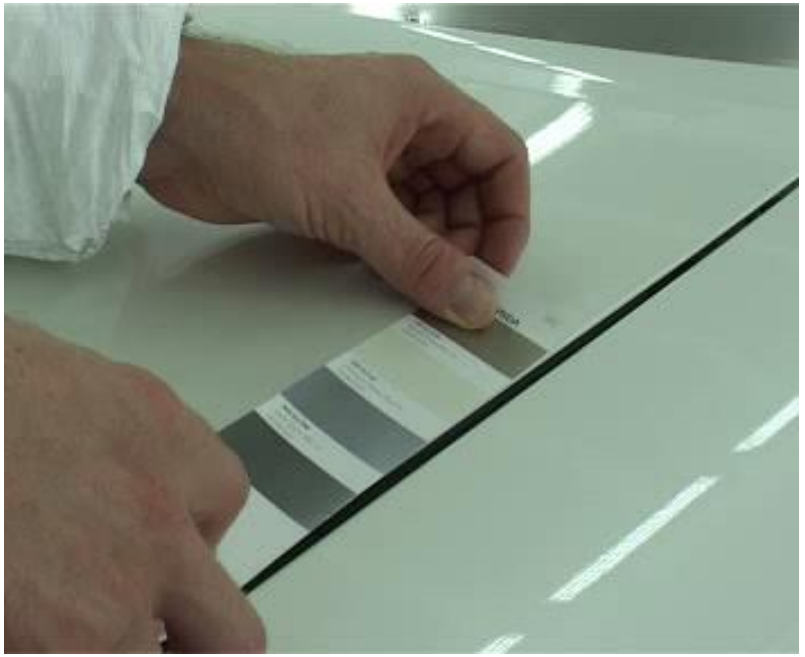
Multiple number of layers creating the color effect

- 5 panels in the foundation coat
- Cover with 1-5 coats of the effect color

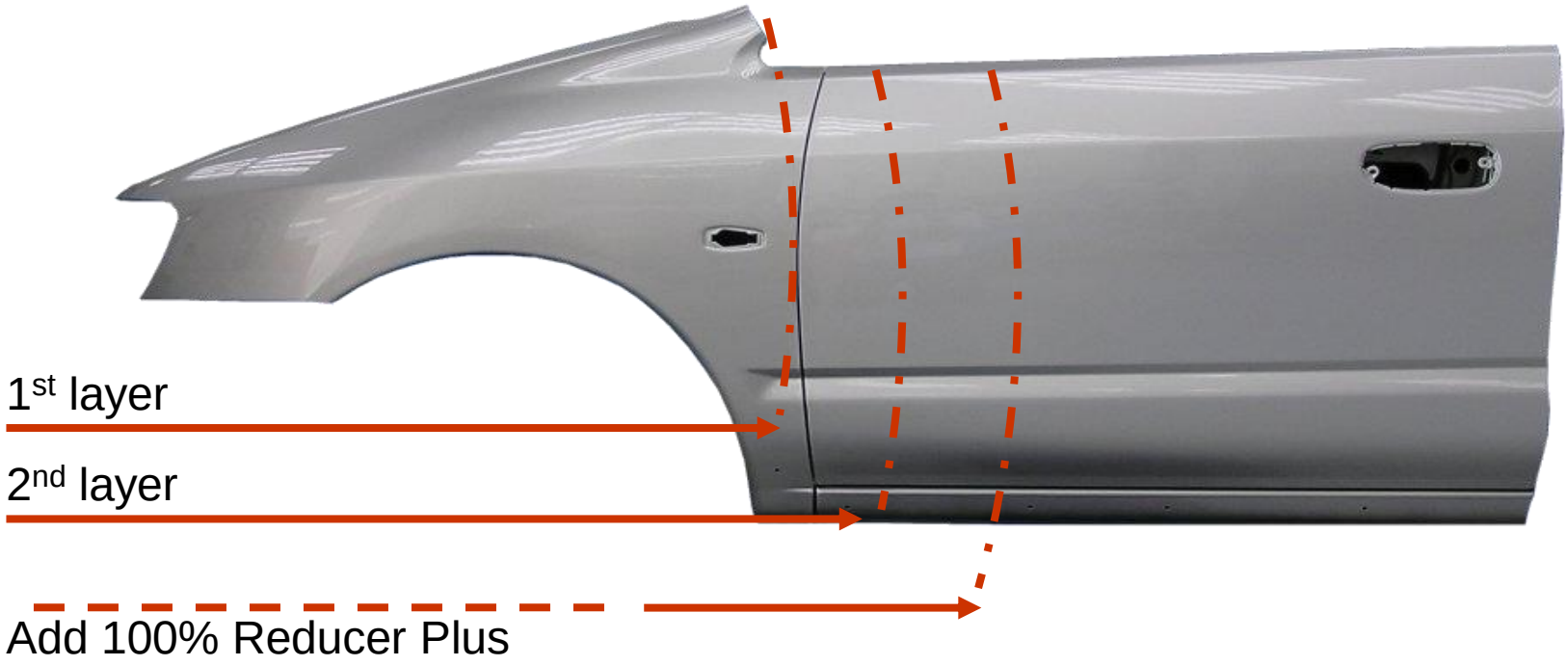
Always cover with a clearcoat



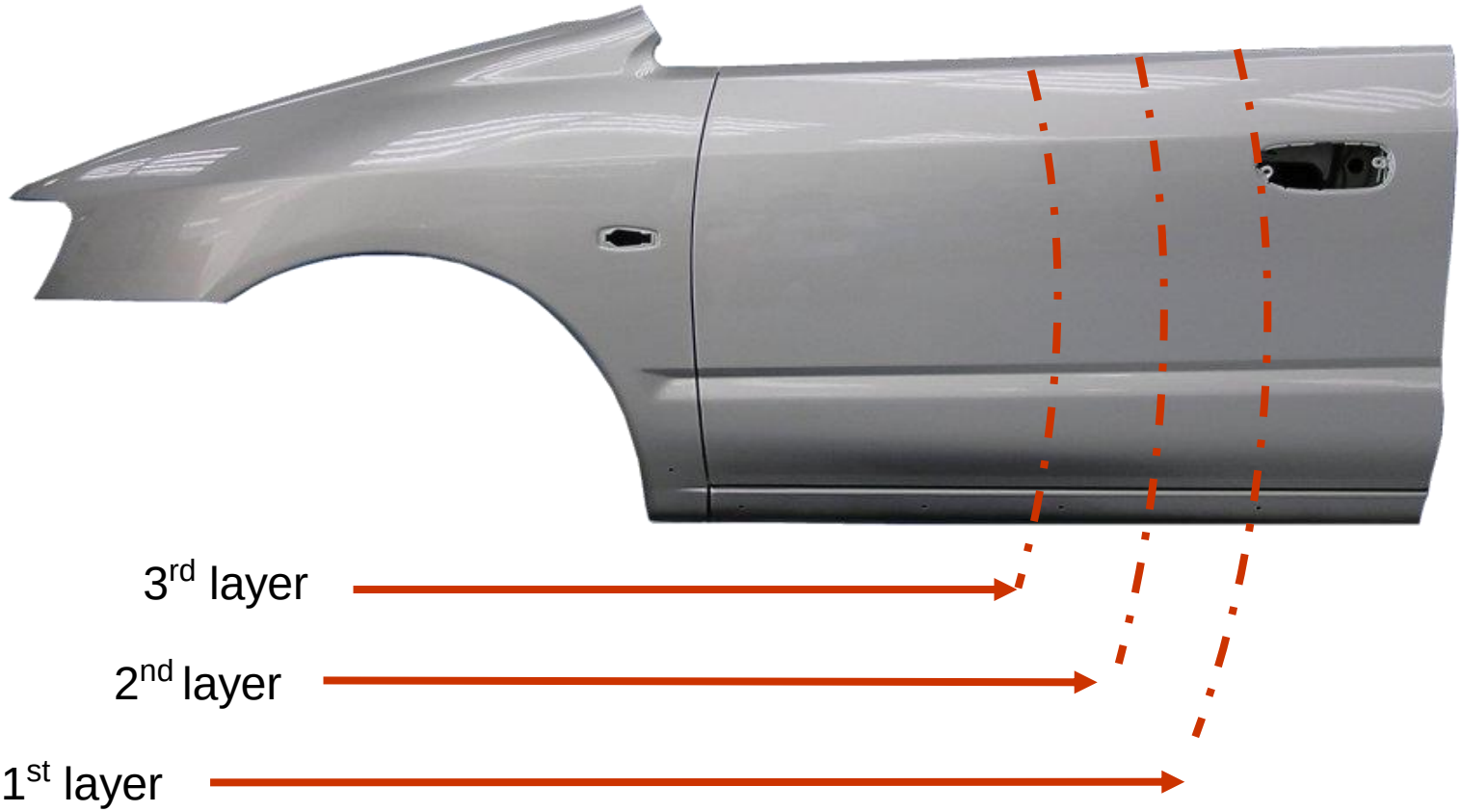
Select the closest matching panel



Application foundation coat

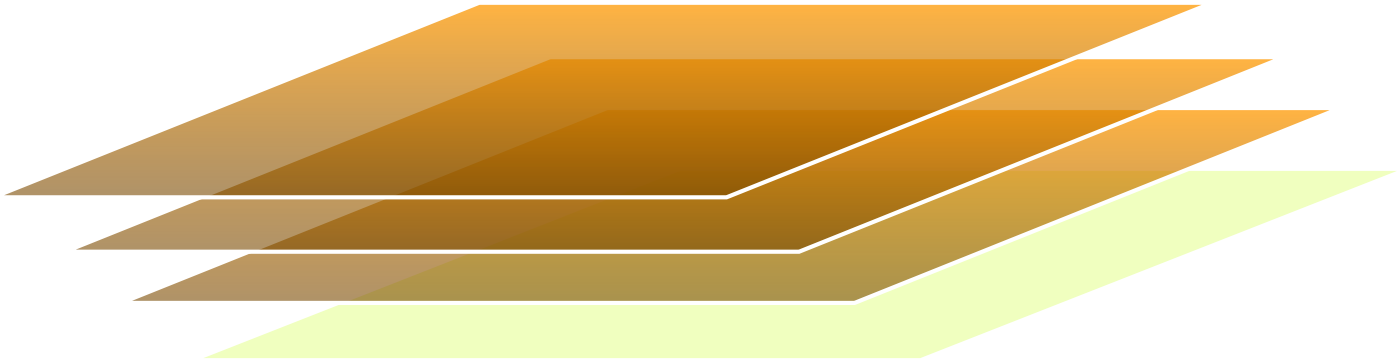


Application effect coat



Clearcoat application

Multiple layers & system properties



Higher layer thickness requires:

- Longer flash-off times between the layers
- Temperature increase between foundation & effect color
- Extra temperature and longer flash-off time before clearcoat application

To secure optimum system properties

1. ± 10 minutes temperature rise to 60ºC after foundation coat

2. ± 15 minutes temperature rise to 60ºC after effect coat

3. Sufficient cool down before clearcoat application