



CROMAX[®] PRO BASECOAT
MAZDA 46G
MACHINE GREY EFFECT
REPAIR METHOD

AN AXALTA COATING SYSTEMS BRAND



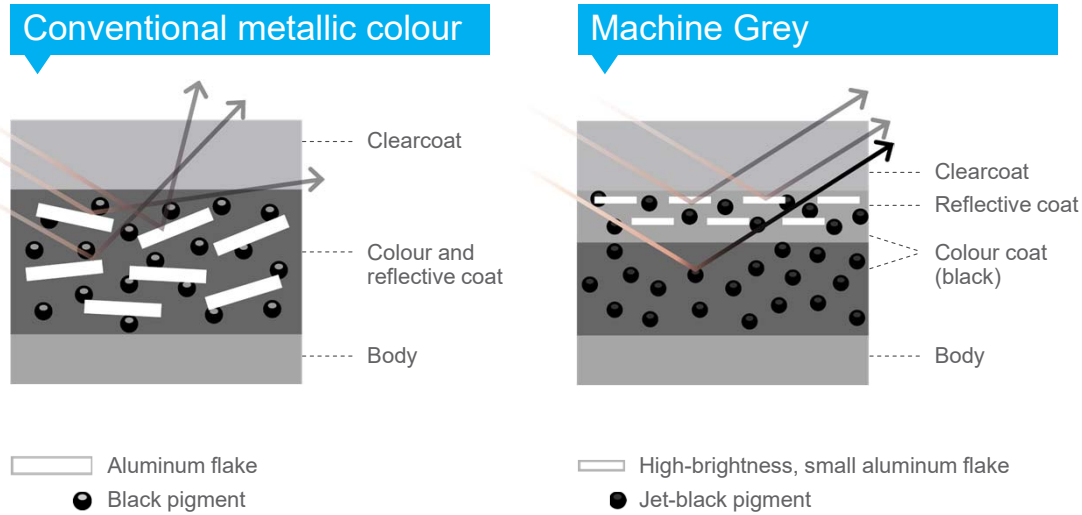
CROMAX® PRO BASECOAT



EFFECT

AN AXALTA COATING SYSTEMS BRAND

PURPOSE OF THE ADVANCED METHOD



Machine Grey effect colour
Mazda 46G
is a special Tri-Stage colour
and needs a dedicated method

MAZDA 46G MACHINE GREY. COLOUR ASSESSMENT.



Ground Color Formula (g)	
WB2010	62.3
WB05	37.7

46G Mid-coat formula (g)	
WB1735	48.38
WB05	33.80
WB27	4.56
WB20	3.88
WB69	0.40
WB2020	8.98

Ground Color	Cromax Pro Controller
100	10%

46G Mid-coat	46G Special Additive
100	300

MAZDA 46G MACHINE GREY. COLOUR ASSESSMENT.



Spray gun: Compliant 1.2 - 1.3
Paint delivery: 1 turn open
Pattern: Full open
Air pressure: 1.5 – 1.7Bar
Distance: 20cm-25cm
Overlap: 80%

Depending on the level of humidity you may adjust the fluid delivery in or out by a quarter or half a turn.

These spraygun settings are for the mid-coat only.

For the Groundcoat & 1:1 application, use 2 bar air pressure and normal fluid delivery.

BEFORE REPAIRING THE CAR

- 1 Carry out a colour check by spraying colour panels
 - Respecting the recommended ValueShade® for the selected surfacer (VS7)
 - Spraying the activated black ground coat colour till hiding

- 2 Overcoat with the effect midcoat in various numbers of light coats to confirm the colour match
 - The right amount of coats will provide the final effect and brightness of this colour



2 double coats +
a single coat



3 double coats

MAZDA 46G MACHINE GREY. COLOUR ASSESSMENT.



- Please conduct colour assessment cards using Option A and B to determine a suitable level of effect required for the vehicle to be refinished.



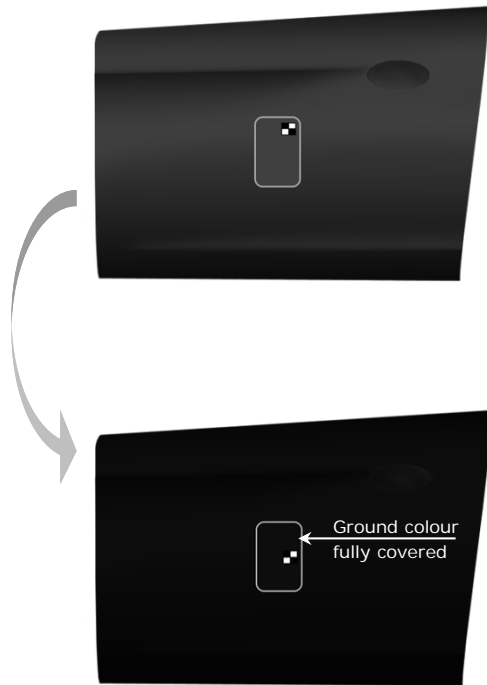
*(do not apply wet)



1. Apply 2 even coats of RFU black ground colour. Flash off.
2. Apply the RFU midcoat thinly and evenly in *2 light double coats +1 single coat with intermediate flash off between coats. Flash off.
3. Apply RFU Clear.

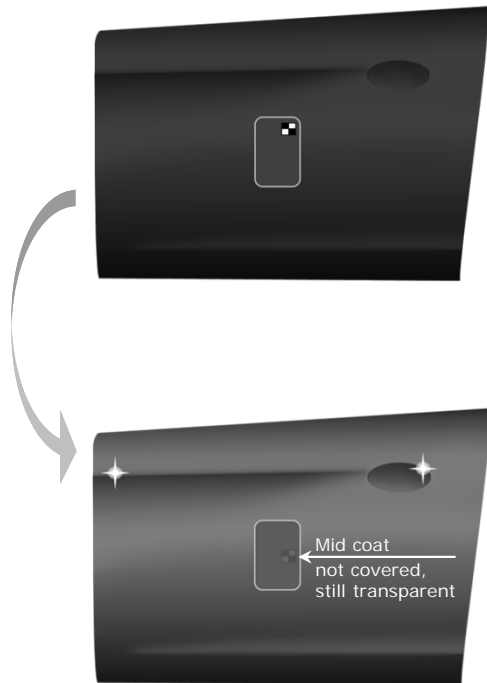
1. Apply 2 even coats of black ground colour. Flash off.
2. Apply the RFU midcoat thinly and evenly in *3 light double coats with intermediate flash off between coats. Flash off.
3. Apply RFU Clear.

MAZDA 46G MACHINE GREY. COLOUR ASSESSMENT.



- Mix the Cromax[®]Pro black ground colour with 10% of WB204X Controller.
- Apply 2 even coats of black ground colour.

MAZDA 46G MACHINE GREY. COLOUR ASSESSMENT.



- Flash Off until matt
- Apply the RFU mid-coat as per the number of coats determined during the colour assessment process i.e Option A or B. Intermediate flash off and tack ragging between each double coat is required. Allow sufficient final flash off.
- Allow sufficient final flash off
- Overcoat with any Cromax VOC Clear.

MAZDA 46G MACHINE GREY. BLENDING-IN PROCEDURE.



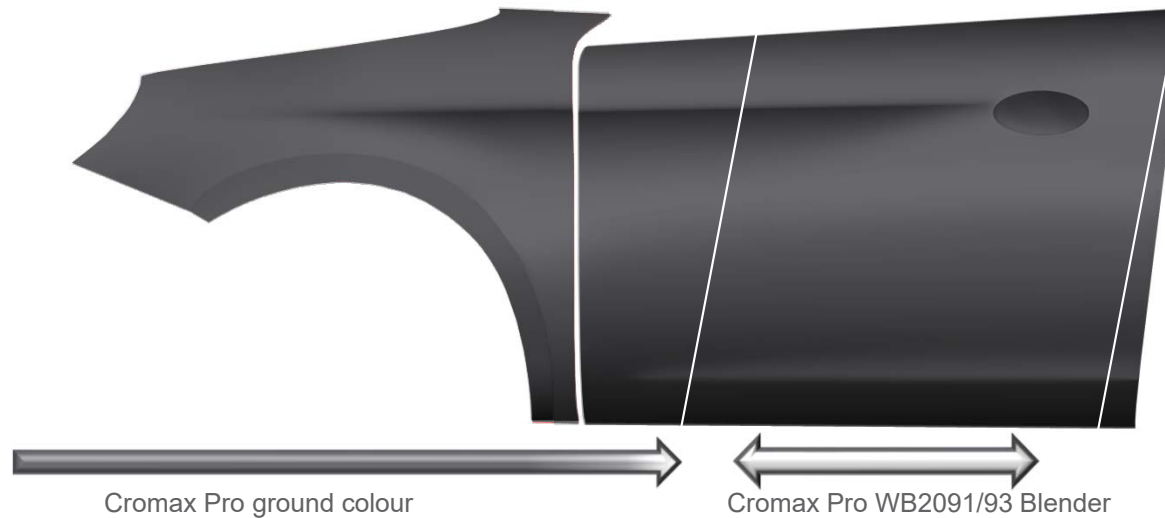
- Use a black Cromax Primer Surfacer.



MAZDA 46G MACHINE GREY. BLENDING-IN PROCEDURE.



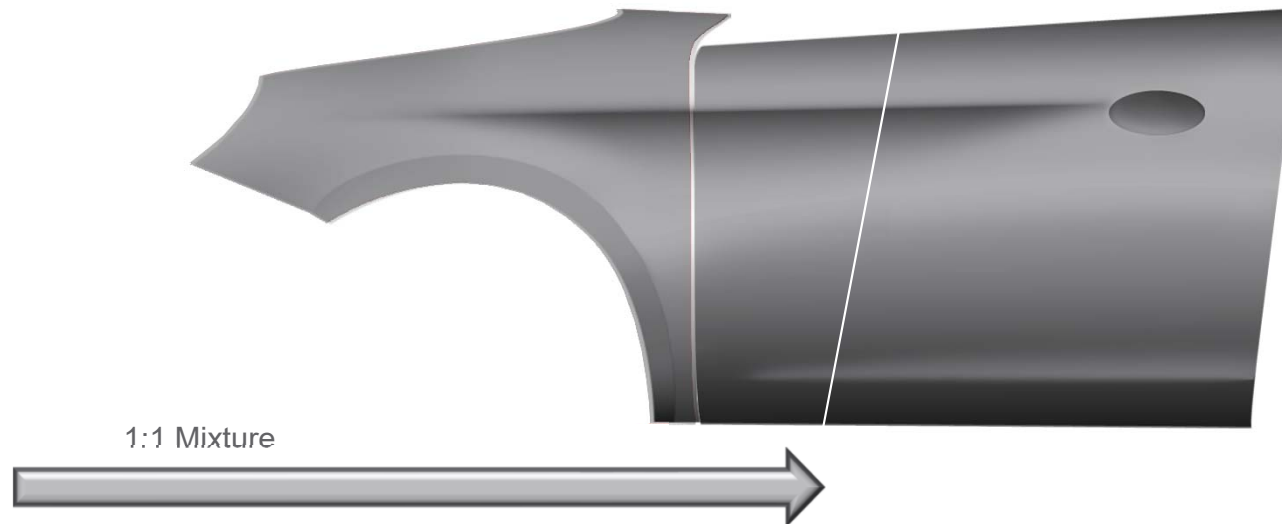
- Mix the Cromax Pro ground colour with 10% WB204X Controller.
- Apply WB2091/93 Blender to the adjacent panel. Take the blender to the edge of the panel.
- Spray 1 coat of ground colour to repair panel and blend into the still wet WB2091/93 Blender.



MAZDA 46G MACHINE GREY. BLENDING-IN PROCEDURE.



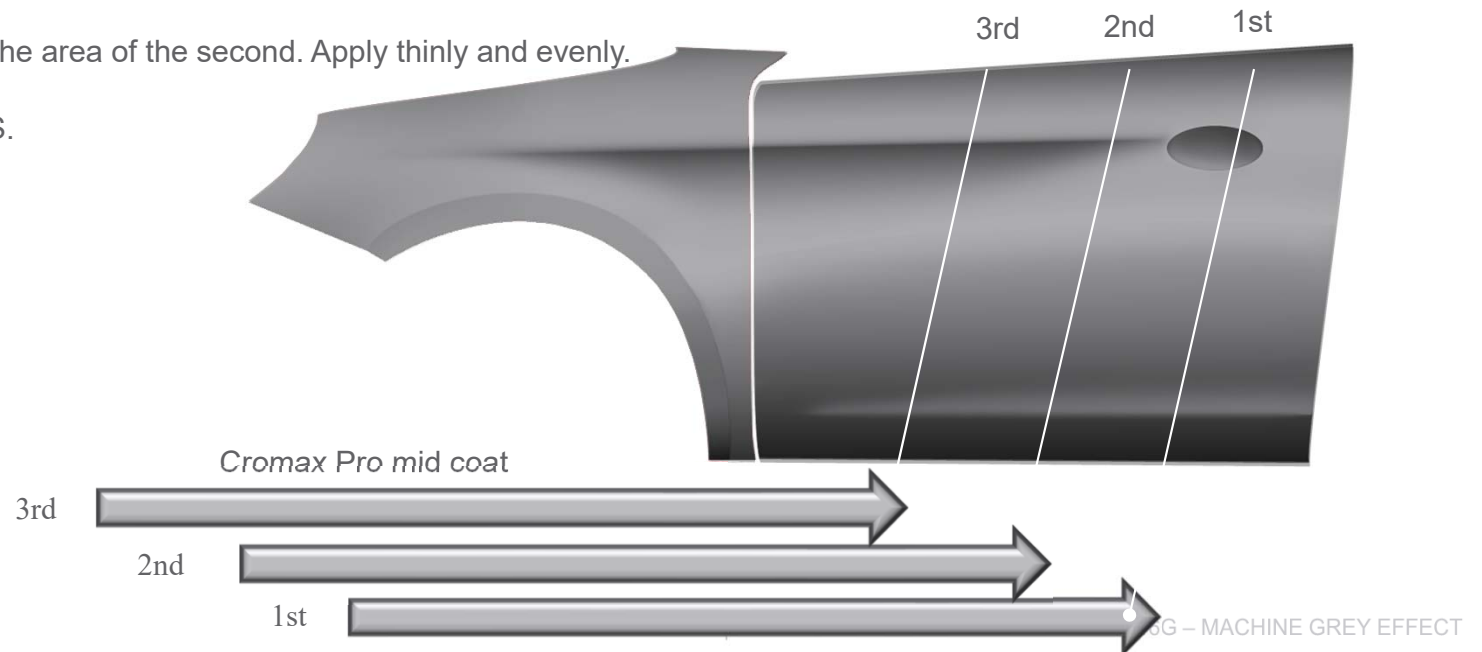
- Without flash off immediately apply 1 coat of RFU Groundcoat colour mixed 1:1 with RFU mid coat colour into the still wet black groundcoat. Extend this mix slightly past the edge of the black groundcoat blend .
- Flash off until matt.



MAZDA 46G MACHINE GREY. BLENDING-IN PROCEDURE.



- Apply the 1st double coat of Cromax Pro mid coat to the widest point first. Apply this thinly and evenly (do not apply wet) with 80% overlap.
- Flash off and tack rag.
- Apply the second double coat within the area of the first. Apply thinly and evenly with 80% overlap.
- Flash off and tack rag.
- Apply the third double coat within the area of the second. Apply thinly and evenly.
- Flash-off and dry according to TDS.



MAZDA 46G MACHINE GREY. BLENDING-IN PROCEDURE.



- Apply Cromax® HS Clear Coat to the entire repair area.
- Dry according to the respective TDS.

MAZDA 46G MACHINE GREY. HELPFUL HINTS.



- Have your groundcoat colour and 1:1 mixture ready to go at the same time.
 - Use PPS or 2 sprayguns for this process.
 - When applying the 1:1 mixture directly over the black groundcoat, try not to over apply as this will wet up alot by itself.
- Adapt the fluid delivery on the spraygun to suit the climatic conditions you are working in. Remember do not spray the mid coat wet. If you do, it will get mottle and it's near impossible to correct.
 - Each double coat should only take around a minute to dry before you can apply the next double coat. If it takes alot longer than this you are applying the mid coat to wet.
 - Tack rag between each double coat to remove any spray mist that may be present on the surface.
 - Allow sufficient room for blending. Don't restrict yourself..!!

MAZDA 46G MACHINE GREY. OPTIONAL BLENDING-IN PROCEDURE FOR THE GROUNDCOAT



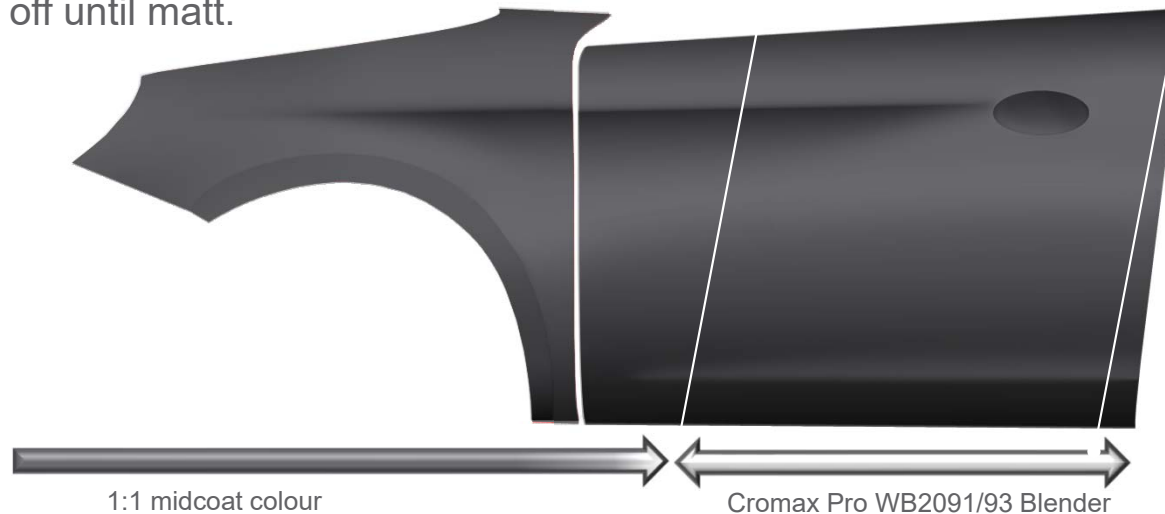
- Mask off blend panel.
- Apply 1 coat of groundcoat black and unmask straight away.



MAZDA 46G MACHINE GREY. OPTIONAL BLENDING-IN PROCEDURE FOR THE GROUNDCOAT



- Without letting the groundcoat black flash off, apply WB2091/93 Blender to the adjacent panel. Take the blender to the edge of the panel.
- Then apply 1 coat of 1:1 midcoat colour to the repair panel and blend into the still wet WB2091/93 Blender.
- Flash off until matt.



CROMAX IS AN AXALTA COATING SYSTEMS BRAND

