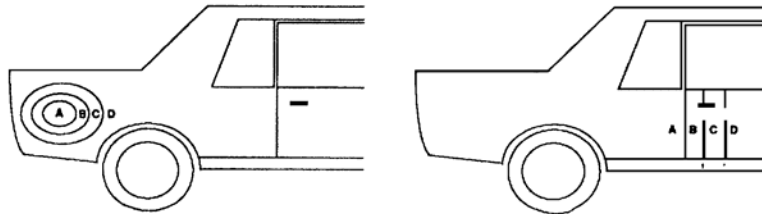


SPOT REPAIRS WITH POLYBASE & POLYBASE PLUS

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 refinish to be made invisible.

PREPARATION:



Clean all areas: first degrease with R859 Wax and Grease Remover. Where VOC emission regulations apply, use recommended compliant 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 scuff areas "C" and "D" (whole panel) with a *grey* scuff pad, 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.



If blending of the clearcoat is inevitable (sail panels), prepare (sail panels) by lightly scuffing with a 3M Clear Blend Prep Pad #07745 (gold). Thoroughly clean areas with R859 Wax and Grease Remover.

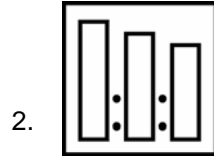
APPLICATION OF Polybase & Polybase Plus SPOT REPAIRS:

1.

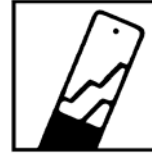


Contains acrylic resins and other ingredients.

SPOT REPAIRS WITH POLYBASE & POLYBASE PLUS



4:1:1
Polybase & Polybase Plus
Solid/Metallic colors
A-Base Activator
R200 Reducer

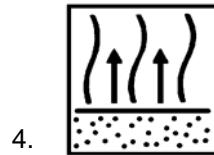


Use the U-Tech
Measuring Stick.



(Polybase & Polybase Plus
Solid)
2-3x1
Spray 2-3 single wet coats

Application Method:
Spray single coats of Polybase or
Polybase Plus in areas A & B until
opacity is achieved. Extend each coat
slightly beyond the previous one. Flash
between coats



5-7 minutes at 70°F (20°C)

It is acceptable to accelerate flash by
blowing air on the spot repair with the
spray gun. Tack off between coats.

SOLID COLOR FADEOUT:



(Polybase & Polybase Plus
Solid)
1x1
Spray 1 single fade out coat

With the Polybase or Polybase Plus
color, spray 1 thin coat, extending
beyond the repair area. Fading out into
area "C".



15-20 minutes at 70°F (20°C)

Allow 20-30 minutes at 70°F (20°C)
before final tack and applying the
clearcoat.





Apply U-Tech Clearcoat

SPOT REPAIRS WITH POLYBASE & POLYBASE PLUS


APPLICATION:

For Polybase Plus Metallic Colors:

4.  (Polybase & Polybase Plus Solid)
2-3x1
Spray 2-3 single wet coats

5.  5-7 minutes at 70°F (20°C)

6.  1-2x1

7.  20-30 minutes at 70°F (20°C)

8.  Apply U-Tech Clearcoat

Application Method: Spray 1 medium coat of Polybase or Polybase Plus metallic in areas "A" and "B". After 5-7 minutes flash off, spray the same area under repair until opacity is achieved, extending each coat. Flash between coats.

It is acceptable to accelerate flash by blowing air on the spot repair with the spray gun. Tack off between coats.

Lower air pressure, apply in areas A and B, extend distance and fade out into areas "C" and "D", extending well into these areas. Lowering the air pressure is not necessary with HVLP. However, it may be done for color control.

Allow 20-30 minutes at 70°F (20°C) before final tack and applying the clearcoat.

NOTES:

The best color control is usually achieved by adjusting the air pressure and gun distance. Tack off between coats.

Fade out by extending application into areas "C" and "D". Do not trigger off while pointing the gun at the repair panel. After each application, remove dry overspray with a Tack Cloth.

SPOT REPAIRS WITH POLYBASE & POLYBASE PLUS






APPLICATION OF CLEARCOAT:

Polybase & Polybase Plus are sufficiently dry to clear coat after 20-30 minutes at 70°F (20°C).

Tack the entire repair area and clearcoat with U-Tech clearcoat.

Note: Use clearcoat appropriate to your VOC regulations. Refer to MS clearcoat, 4.0 Select clear and HS21 clearcoat technical data sheets.

EXAMPLE, 4.0 SELECT CLEAR:


1.  Contains xylene and other ingredients. When mixed, also contains isocyanates.
2.  4:1
4.0 Select Clear
4.0 Select Activator Medium
3.  Use the U-Tech Measuring Stick
4.  2-3x1
Apply two to three flowing coats.
5.  5 minutes at 70°F (20°C)

Application Method:

Spray 2-3 flowing coats of 4.0 Select Clear, 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.

SPOT REPAIRS WITH POLYBASE & POLYBASE PLUS

APPLICATION OF CLEARCOAT (CONTINUED):

6.  4.0 Select Activator Medium
12 hours at 70°F (20°C)
30 minutes at 140°F (60°C)

BLENDING OF CLEARCOAT:

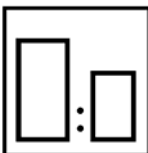
Akzo Nobel Coatings/U-Tech strongly recommends the application of clear coat over the whole panel.
There are, however, instances where this is not practical. Such as repairs on older vehicles where economics would dictate that a warranty is not required. In these instances, it may be acceptable to blend 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 4.0 Select Clear

Note: Procedures listed below should also be used for MS clear and HS21 clear. 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.

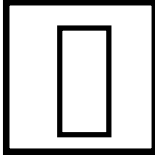

1.  100:100
4.0 Select Clear, ready to spray
R200 Reducer

After the last coat of clear is sprayed in the sail panel area, add to the ready to spray clear 100 parts by volume R200 Reducer
2.  Use the U-Tech Measuring Stick
3.  1x1
Apply one single coat.

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

SPOT REPAIRS WITH POLYBASE & POLYBASE PLUS

Application Continued

4.  U-Tech Blending Reducer Ready to spray Use pure U-Tech Blending Reducer to dissolve overspray edge.
5.  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:

- Polybase
- Polybase Plus
- MS Clear
- 4.0 Select Clear
- HS21 Clear
- U-Tech Blending Reducer

SAFETY DATA:

READY TO SPRAY VOC:

Polybase Plus mixed 4:1:1 with A-Base activator and R200 Reducer:
6.1-lb/gal 732 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.