



Painting process MAZDA 46G MACHINE GREY

INTRODUCTION

Special effect colours are becoming more common in the car sector. There are some issues raised in comparison to the usual painting application. A different approach is required when using these new paint processes and products to obtain a good final result.

The finish of the colour Mazda 46G can appear the same as a traditional grey metallic but in direct sunlight there is a bright sparkling reflection that cannot be produced unless the correct method and application is used as well as the formula found in Lechler Map®.

**CLEARCOAT****BASECOAT (HY Colour 46G)****BLENDER (HA777)**

COLOUR CHECK

This repair must be seen as complex because the number of coats and film thickness will significantly affect the final colour/effect. **Because of this it is always necessary to apply a spray out beforehand** to verify the final result and comparing it to the original car colour.

SUBSTRATE PREPARATION

It is recommended to always apply a dry-on-dry primer filler: **MF610/MF310**, allowed to dry and sanded with P500/600 fine grit paper, is recommended.

Apply one coat of **HA777 HYDROFAN EASY BLENDING ADDITIVE** on all parts to be painted as stated on the TDS before the next application.

BASECOAT PREPARATION

Prepare the formula as shown on Lechler Map® and reduce as follows:

HYDROFAN (Colour 46G)	1000 parts
HR915 HYDROFAN EXTRAFLOW REDUCER	200 parts

For control coat

HYDROFAN (Colour 46G)	1000 parts
HR915 HYDROFAN EXTRAFLOW REDUCER	500 parts

NOTES

- Air cap 1.1-1.2 mm
- Pressure as indicated by the producer

APPLICATION PROCESS

1. Apply one thin coat and after the film has gone matt apply one uniform coat (see TDS n° 0400 Standard Process).
2. Wait until the film has gone thoroughly matt.
3. Apply one control coat with the above-mentioned mixture.

Check that the surface is thoroughly and uniform dehydrated, then apply a clearcoat within the MACROFAN UHS CLEARCOAT or HYDROFAN CLEARCOAT range.

NOTE

A too high film thickness and other different application methods from our suggestions compromise the colour match and laydown of the basecoat.

**PAINTING PROCESS TDS N° CV042-GB
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