



## Painting process MAZDA 46V SOUL RED CRYSTAL

### INTRODUCTION

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

The finish of the colour Mazda 46v has a bright deep and spectacular red effect which cannot be reproduced unless the correct method and application process is utilised. The formula Mazda 46V is found on Lechler Map®.



<b>CLEARCOAT</b>
<b>CLEARCOAT + CLEAR TONE</b>
<b>MATT BASECOAT (HY Colour 46V)</b>
<b>BLENDER (HA777)</b> (with fade-out on adjacent parts)
<b>UNDERCOAT (HF187)</b>

### 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 number of spray outs beforehand** with a progressive number of coats of basecoat to verify the final result and comparing it to the original car colour.



2 coats



3 coats



4 coats

### 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 **HF187** reduced with **HR915** (20%) to give a black reflection to the colour, as indicated in the formula Lechler MAP®.

To obtain a perfect blend to the adjacent parts apply a coat of **HA777 HYDROFAN EASY BLENDING ADDITIVE** as per TDS n° 0716.

N.B. Given the special process a wide surface is recommended to perform the fade-out.

---

## BASECOAT PREPARATION AND APPLICATION

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

HYDROFAN (Colour 46V)	1000 parts
HR915 HYDROFAN EXTRAFLOW REDUCER	400 parts

### NOTES

- Air cap **1.1-1.2 mm**
- Pressure 1,9 – 2,1 bar for finesse coat
- **Reduce product flow** (Material usage on gun trigger must be restricted)

1. Apply 2 cross coats each in a uniformed way at a distance of 25 to 35cm from the substrate.
2. Wait until the film has gone thoroughly matt.
3. Repeat until you match the colour previously achieved on spray cards.

---

## CLEARCOAT PREPARATION AND APPLICATION

Prepare the mixture of the “**COLOURED**” clearcoat as follows:

CLEARCOAT (MC404 or MC405 or MC500)	800 parts
CT030 MACROFAN CLEAR TONE RED	200 parts

1. Apply 2 regular coats of the “**COLOURED**” clearcoat as per TDS of the chosen product on all the part painted with the base coat and enlarge gradually.

Allow to dry shortly (f.i. 10 min. at 50 °C) before applying the next coat. If this is a fade-out it is possible to integrate the overspray with MC885.

2. Complete the painting process applying the same **Clearcoat** on all the retouched part as per TDS.

**N.B.** Always use the same combination Clearcoat/Hardener/Thinner for the “**COLOURED**” as well as for the “**CLEAR**” version.

---

## DRYING

Allow to dry as per TDS of the clearcoat used.

---

## NOTE

As it is a multi-layer process, it is very important that thicknesses, application and flash-off times between products/coats are observed according to the relevant TDS.

**PAINTING PROCESS TDS N° CV043-GB**  
**UPDATED 09/2019**

All information contained in this data sheet is the result of carefully controlled tests and is correct to the best of Lechler's knowledge at the time of issue. Since conditions of use are beyond the control of the manufacturer, information contained herein is without warranty, implied or otherwise, and final determination of the suitability of any information or material for the use contemplated and the manner of use is the sole responsibility of the user. FOR PROFESSIONAL USE ONLY.