



## FINISH WITH COLOURED CLEARCOAT (f.i. Colours Mazda 41V– Renault NNP – Ford DSTE)

### 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 on some car models, listed above and usually red, have a bright, deep and clean depth and are hard to reproduce by the usual classic 3 stage painting processes.



CLEARCOAT

CLEARCOAT + CLEAR TONE

MATT BASECOAT (HY Colour L0X01)

### 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 (minimum 2 coats) of the coloured clearcoat to verify the final result and comparing it to the original car colour.

2 coats

3 coats

4 coats

### SUBSTRATE PREPARATION

Prepare the car to be painted with the adjacent blend area being as large as possible.

Sand in a uniform way with P400/500 grit paper with random orbital sanding machine and sand edges with P600/800 grit paper by hand.

### BASECOAT PREPARATION AND APPLICATION

Prepare the formula as shown on Lechler Map® and apply the HYDROFAN basecoat as per TDS.

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## CLEARCOAT PREPARATION AND APPLICATION

Prepare the mixture of the "COLOURED" clearcoat according to the **SYSTEM formulation in Lechler MAP® and mix as follows:**

CLEARCOAT (MC404 or MC405 or MC500)	800 parts
<b>CT ... MACROFAN CLEAR TONE</b>	<b>MAX. 200 parts</b>

1. Apply the "**COLOURED**" **clearcoat** according to the spray out cards applied beforehand and as per TDS of the selected 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.

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## DRYING

Allow to dry as per TDS of the clearcoat used.

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## 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° CV044-GB  
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