

WaterBase 900+ Series: Repair/Fade-out of Tesla R108E Crimson Red Tesla with tinted clear



Colour check

Always determine the right colour and/or colour variant. This should be done at the earliest stage possible, preferably when estimation of the repair is done. Creating a spray-out at this stage is best practice.



Protection

Use suitable respiratory protection (fresh air supply respirator is strongly recommended).



Cleaning

Clean with 1-951 Silicone Remover and/or 9-851 WaterBase 900+ Series Degreaser.



Surface preparation

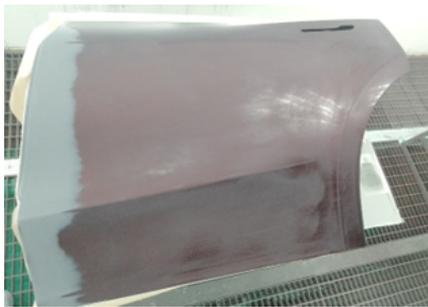
For final sanding Use sanding paper grit P1000, on repair area, while observing the proper sanding steps. and P1500 on blending area.

STEP 1



Application sanding primer in Grey shade GS908

Apply 8-867/8-145/8-347 as a sanding surfacer according TDS. Sand primer Up till P1000



STEP 2



Application Blending agent M977

Apply M977+ 10-20% 9-151 WaterBase 900+ Series Thinner over the entire repair area, including the blending area.



Do not apply M977 on the entire panel

	NOZZLE (MM)	AIR PRESSURE (BAR / PSI)
HVLP/HE	1,3	2/29



Flash-off/Blow dry

Until a uniform matt surface.

STEP 3



Application Tesla R103E 900+ Series +10-20% 9-151 Apply one mist coat followed by two normal layers until uniform and covered.



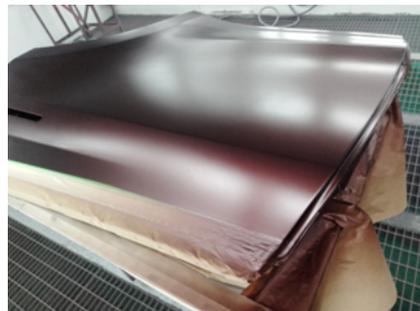
Tesla R103E 900+ Series fade-out



Application Drop-coat

In order to ensure that the effect particles remain properly oriented on the surface a drop-coat is recommended.

	NOZZLE (MM)	AIR PRESSURE (BAR / PSI)
HVLP/HE	1,3	1.0-1.2/15-17



Flash-off 20 minutes

Until a uniform matt surface.



WaterBase 900+ Series: Colours containing PVD pigment

PREPARATION



Colour check

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Cleaning

Clean with 1-951 Silicone Remover and/or 9-851 WaterBase 900+ Series Degreaser.



Protection

Use suitable respiratory protection (fresh air supply respirator is strongly recommended).



Surface preparation

For final sanding Use sanding paper grit P1000, on repair area, while observing the proper sanding steps. and P1500 on blending area.

STEP 4



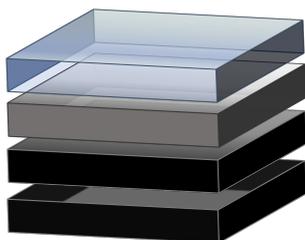
Application

Apply a recommended clearcoat suitable for the Waterbase 900+ Series.



Note

Tack between each layer and before clear coat, the repair and blend area.
Do not apply the clear coat too wet to avoid strike-in.
Apply a mist (tack) coat first when applying clear.
5 minute flash off before next coat



- ← 4. Clearcoat
- ← 3. PVD Base-coat
- ← 2. Special UC
- ← 1. Primer Surfacer (if needed)