

Special Paint Repair System



Designo Magno Colors: Warranty repair system and process for matt finish,
VOC compliant (US National Rule)

VOC compliant	Substrates				
	Bare Steel	Galvanized Steel	Aluminium	E-coat (Spare Parts)	OE Finish
Cleaning / Sanding	ONECHOICE® SX330	OneChoice SX330	OneChoice SX330	OneChoice SX330	OneChoice SX330
Stopper / Filler	N/A	N/A	N/A		
Primer	OneChoice SX1071	OneChoice SX1071	OneChoice SX1071		
Surfacer	GLOBAL REFINISH SYSTEM® D800x 1-White 5- Gray 7-Black	Global Refinish System D800x 1-White 5- Gray 7-Black	Global Refinish System D800x 1-White 5- Gray 7-Black	Global Refinish System D800x 1-White 5- Gray 7-Black	
Basecoat(s)	Global Refinish System BC	Global Refinish System BC	Global Refinish System BC	Global Refinish System BC	Global Refinish System BC
Waterborne Basecoat(s)	ENVIROBASE® High Performance	Envirobase High Performance	Envirobase High Performance	Envirobase High Performance	Envirobase High Performance
Clearcoat(s)	Blend of Global Refinish System D8115 and D8126	Blend of Global Refinish System D8115 and D8126	Blend of Global Refinish System D8115 and D8126	Blend of Global Refinish System D8115 and D8126	Blend of Global Refinish System D8115 and D8126

Preliminary Notes

	<ul style="list-style-type: none"> Matt finishes present a number of obstacles in the repair process, including: <ul style="list-style-type: none"> Variation in gloss across the vehicle body means more than one gloss level for repairing. True even though this is not visually easy to see before the repair is made. The gloss level can change in service over time depending on cleaning / maintenance.
	<ul style="list-style-type: none"> Matt clears contain raw materials to reduce and contribute to the color match. <ul style="list-style-type: none"> This means the color match involves a basecoat + clearcoat combination. Clearcoat film can also cause a color shift when applied over OE clearcoat. Color panels are essential to check gloss level and color achieved in specific bodyshop environment, prior to repairing the vehicle.
	<ul style="list-style-type: none"> No possibilities exist to polish out dirt or imperfections in the finished clear, as this will increase the gloss level. <ul style="list-style-type: none"> Repair and finish work must be kept extremely clean.
	<ul style="list-style-type: none"> Longer processes are needed to ensure a very even finish on larger areas. <ul style="list-style-type: none"> Ordinary matt clears may not work well on large areas. Recommended full flash off times must be followed to ensure an even matt finish.

OneChoice ACRYLI-CLEAN® SX330 Wax & Grease Remover				
See “Sanding and Cleaning”	Ready for use	Apply with clean lint free cloth	Wipe off with clean lint free cloth	OC-42

OneChoice SX1071 Etch Prime							
1:1	with SX1072	24 hours 11-14” DIN4 70°F (21°C)	1.3 – 1.5 mm	2 Medium coats. Should not exceed 1.0 mils	2-3 min. between coats	15 min. 24hrs max. 70°F (21°C)	OC-6

Global Refinish System D800x (1-White 5-Gray 7-Black) 2K Chromatic Surfer								
4:1:1	with D8291 / and D87x thinners	60 min. 68°F (20°C)	1.6 – 1.8 mm	2 – 3 Wet coats	5-10 min. between coats, 10 min. before baking	90 min. Air Dry to Sand 68°F (20°C)	90 min. or after sanding 68°F (20°C)	EU-137

Global Refinish System GRS BC							
Use tack rag. Check color to adjacent parts	5% D888 to RTS for optimum performance	1:1 with D87x thinners	1.3 -1.5 mm	2-3 coats	5-10 min. between coats, 15min. before clearcoat	EU-02	

Or

Envirobase High Performance						
Use tack rag. Check color to adjacent parts	10 – 30% Thinner T494/T5 95	23 – 28” DIN4 68°F (20°C)	1.2 – 1.4 mm	2 – 3 coats + control coat (if necessary)	Dry till evenly matt	EB-143

Normal Matt Clearcoat System

Gloss Level Mix Ratio D8115 / D8126					
D8115:D8126 85:15 by weight	If slightly higher gloss level is required	D8115:8126 80:20 by weight	1 Hour 15" DIN4 68°F (20°C)	1.2 – 1.4 mm	EU-150

This process can be used for full side repairs or full resprays.

NOTE: Test panels MUST be produced using the intended hardener/thinner/ratio/spraygun combination to check for color and gloss level against the vehicle to repair.

NOTE: Filter in sprayguns must be avoided for gravity guns. Use a pre filtering process with a 190µm filter.

Global Refinish System D8115 / D8126 Blend								
Use tack rag	3:1:1½ D8239 and D8XX thinners	1 hr. DIN4 68°F (20°C)	1.2 – 1.4 mm	1 medium and 1 full coat	30 min. between cts., 30 min. before baking	5 min. Between cts., 5 min. Before baking	Do not polish matt finish!	EU-150

Notes	
	<ul style="list-style-type: none"> Clearcoat must be flashed off until completely matt between coats and before bake. <ul style="list-style-type: none"> Clearcoat flash off times can be 30 minutes to 1 hour depending on repair type and size. This is especially important on larger horizontal areas.
	<ul style="list-style-type: none"> Jobs must be kept extremely clean. <ul style="list-style-type: none"> Any dirt inclusions must be removed before the final coat of clearcoat. This can be during the basecoat stage OR after the first coat of clearcoat has flashed off well. Dirt nibs cannot be polished out of the final coat. In these cases the job must be re-prepared and the full repair area carefully re-applied with clearcoat.