

# M series Metallic Spot Repair Recommendation using M0007 Metallic Blender

The following Alexseal repair method recommendation is a general repair recommendation that is not based on any specific damage scenario. It is the responsibility of the applicator/user to test and confirm on a case-by-case basis whether the general recommended repair steps are suitable for their particular repair procedure. Mankiewicz makes no representations or warranties with respect to the repair method recommendation stated below.

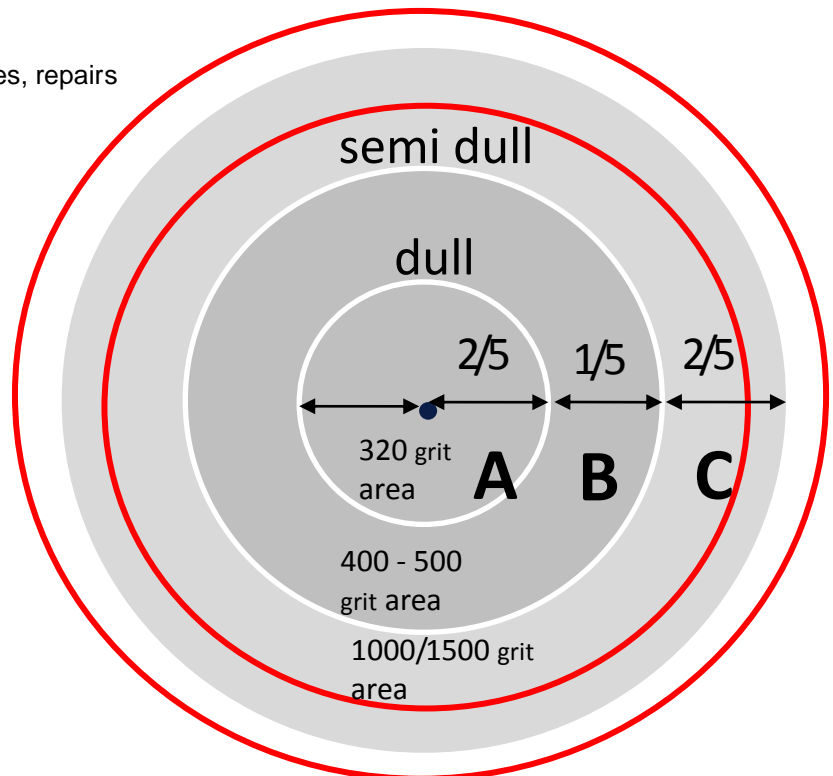
These products and applications are intended for commercial and professional use only. Some metallic colors may be harder to repair than others. The following instructions and application procedures require a high degree of application skill and previous spray application and spot repair blending experience. The applicator/user is responsible for ensuring that he or she has the proper skills and experience with spray applications, paint blending, and repairs. The applicator/use should follow all equipment manufacturer instructions as to the set up and use of any equipment used in this application process.

Each of the following steps should be completed in the order listed below. Any failure to complete the steps in the proper order may result in an unsuccessful repair.

## 1. Preparation

Clean and rinse painted surface with clean fresh water. Make sure that all contamination on the surface is removed completely. The surface must be clean, dry and free from dust, grease, oil and all other contamination prior to sanding.

Depending on depth and size of local damages, repairs might be necessary all the way down to bare substrate. If necessary, use the following ALEXSEAL products: Protective Primer 161, Fairing Compound 202, Super Build 302, Finish Primer 442. The metallic spot repair process described as of Step 2 begins after finish priming or the primer spot (area a) has been sealed with 1 coat T0125 clear and let dry.



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### 2. Sanding

After the preparatory work make sure that the finish primer or the T0125 clear sealer is sanded with 320-400 grit (see area A).

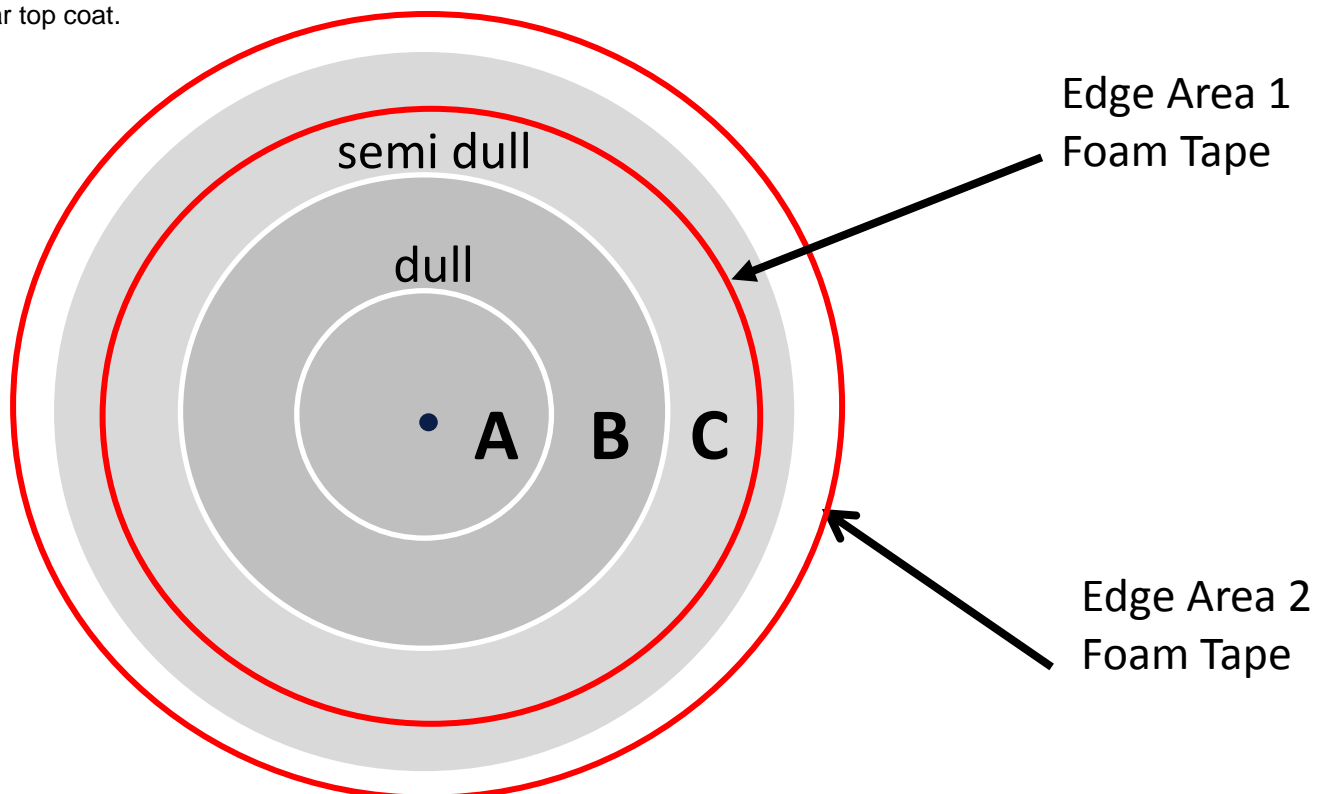
Around the 320-400 grit sanding area sand out at least double the size of area A with 500 grit (see area B).

Around the 500 grit sanding area sand out at least double the size of area B with 1000-1500 grit 3M Trizact sanding paper (see area C).

Clean the surface and cover the parts which will not be painted. Refrain from using hard edge tape lines in the middle of panels.

#### Optional: Masking with foam tape

There are two areas that may be masked: Area 1 is inside at middle of area C using round foam tape. Area 2 is just outside area C also using round foam tape. Area 1 will serve as the masking edge during the application of metallic. Once Step 6 has been completed, Area 2 will serve as the masking edge for the application of T0125 clear top coat.



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### Optional: Interrupting the process

If at any time during the spot repair process it is necessary to stop and complete the repair process later, such as the next day, then apply two medium wet cross coats of M0007 M-Series Metallic Blender to seal the last step completed. The next day perform a light scuff with red scotch brite. Blow off the area with clean compressed air, tack cloth wipe the surface, and apply a coat of M0007 M-series Metallic Blender to start next step.

### 3. Mixing M0007 M-Series Metallic Blender and M Series Metallic Base Coat

We recommend premixing all components needed in this process and labelling them prior to starting your spot repair. This will not only save time, but will save any confusion on what's needed and when during the process. Be sure to mix enough M0007 M Series Metallic Blender to use separately and to mix into M-Series Metallic Base in ratios described below.

Mixing Instructions:

A. M0007 M Series Metallic Blender Mix Ratio:

- 5 Parts by volume M0007 ALEXSEAL M-Series Metallic Blender
- 1 Part by volume C5051 ALEXSEAL Topcoat Converter Spray
- 3 Parts by volume R5070 ALEXSEAL Topcoat Reducer Spray

B. M Series Metallic Base Coat Mix Ratio:

- 5 Parts by volume M..... ALEXSEAL M-Series Metallic Base Coat (Base Color)
- 1 Part by volume C5051 ALEXSEAL Topcoat Converter Spray
- 3 Parts by volume R5070 ALEXSEAL Topcoat Reducer Spray

Mix Pot 1 = A (M0007 Blender)

Mix Pot 2 = B (M...Metallic Base Coat)

Mix Pot 3 = 25% A + 75% B

Mix Pot 4 = 50% A + 50% B

Mix Pot 5 = 75% A + 25% B

### 4. Application of M0007 M-Series Metallic Blender Mix 5:1:3 with R5070 Topcoat Reducer Fast

Apply a light to medium sealer coat of M0007 M Series Metallic Blender (from Mix Pot 1) to areas A and B feathering out lightly to outer edge of area B outlined in the illustration.

**Note:** On all steps and coats during this process try to keep the outside edge of area B very light with no build-up of coatings.

Recoat time: 10 minutes

### 5. Application of M-Series Metallic Base Mix 5:1:3 using R5070 Spray Reducer Fast

Apply light cross coats of M Series Metallic Base Coat (from Mix Pot 2) to area A until full hide is achieved. Make sure to keep within area A.

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### 6. Application of M0007 M-Series Metallic Blender

Apply 1 light to medium coat of M0007 M-Series Metallic Blender (Mix Pot 1) over your previously applied metallic base to seal areas A, and feathering out lightly to inner edge of area B.

Recoat time: 10 minutes

### 7. Application of M-Series Metallic Base 75% and M0007 M-Series Metallic Blender mixed 25% (Mix Pot 3)

Apply a light to medium cross coat of 25%:75% mix (mix pot 3) to areas A and B feathering out lightly to slightly beyond previous coat while staying within area B.

### 8. Application of M0007 M-Series Metallic Blender

Seal same areas worked on in Step 7 with a light to medium wet coat of M0007 M-Series Metallic Blender (Mix Pot 1)

Recoat time: 10 mins

### 9. Application of M-Series Metallic Base 50% and M0007 M-Series Metallic Blender mixed 50% (Mix Pot 4)

Apply a light to medium cross coat of 50%:50% mix (Mix Pot 4) to areas A and B feathering out lightly to slightly beyond previous coat while staying within area B.

### 10. Application of M0007 M-Series Metallic Blender

Seal same areas worked on in Step 9 with a light to medium wet coat of M0007 M-Series Metallic Blender (Mix Pot 1)

Recoat time: 10 mins

### 11. Application of M-Series Metallic Base 25% and M0007 M-Series Metallic Blender 75% mixed (Mix Pot 5).

Carefully remove masking and tape and paper off Area 1 (if used).

Apply a light to medium cross coat of 25:75 mix to areas A and B feathering out lightly to slightly beyond previous coat while staying within area B.

### 12. Application of M0007 M-Series Metallic Blender

Seal same areas worked on in Step 11 with a light to medium wet coat of M0007 M-Series Metallic Blender (Mix Pot 1)

Overcoat time: 2 hours

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### 13. Application of 1<sup>st</sup> Clear Topcoat T0125 Mix: 1:1:1/2 25% using R5070 Topcoat Reducer Fast

Apply 1 medium wet flow coat of T0125 Clear Topcoat to areas A and B, and feather out slightly beyond area C.

Drying time: As per Technical Data Sheet.

### 14. Application of 2<sup>nd</sup> T0125 Clear Topcoat

Apply 1 medium wet flow coat of T0125 Clear Topcoat to areas A and B, and feather out slightly beyond area C. Carefully pull area 2 tape and paper off.

Pour T0125 Clear Topcoat out of spray gun and put in A5033 Blending Solvent, or use a separate spray gun with A5033 Blending Solvent. Adjust gun to dry spray straight solvent lightly.

Apply A5033 Blending Solvent to overspray of 2<sup>nd</sup> coat of Clear T0125 Topcoat, apply in multiple light passes until you see overspray melt in to surface slightly.

Let dry overnight.

### 15. Polishing

Only the outer blending area from the old clear to the new clear coat has to be polished to achieve a smooth surface.

If needed, sand any overspray first with 1000-1500 3M Trizact grit wet and second with 2000 and 3000 3M Trizact grit wet respectively.

**Optional:** To reduce sanding marks, sand third with 6000 3M Trizact grit wet.

Use a compound and polish system designed for Polyurethane paints such as the 3M™ Perfect-It™ Paint Finishing System to complete the repair.

Protect the buffed area with A5010 Alexseal Premium Polymer Sealer every 4-6 weeks.

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