

# STANDOX REFINISH PROCESS.

## MAZDA 46G MACHINE GREY.

Colour assessment &  
Product adjustment

Application & blending

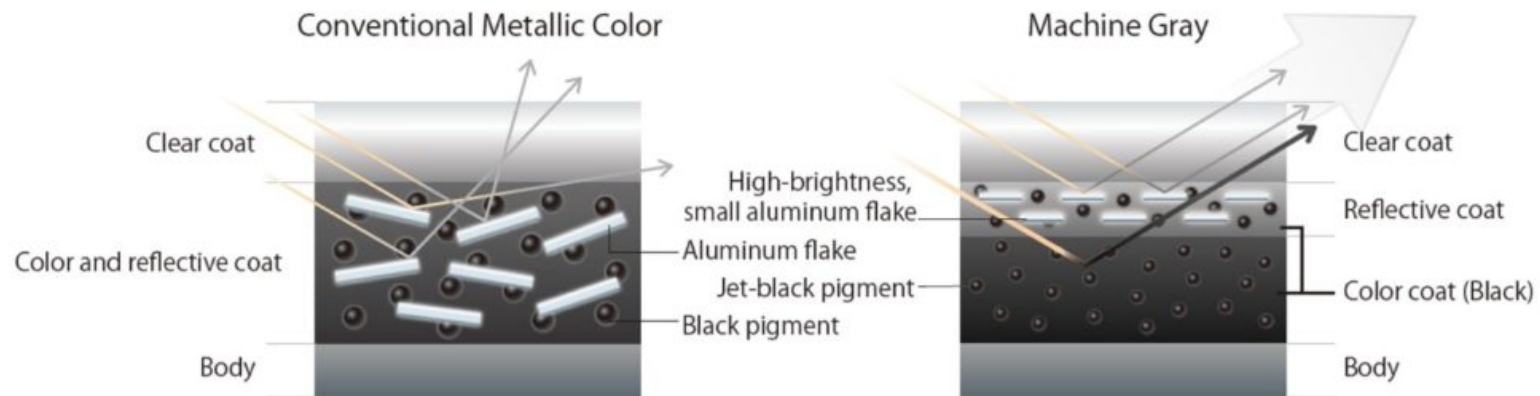
Optional  
blending-in procedure



**STANDOX REFINISH PROCESS.  
MAZDA 46G MACHINE GREY 2023.**

Colour assessment & Product  
Adjustment

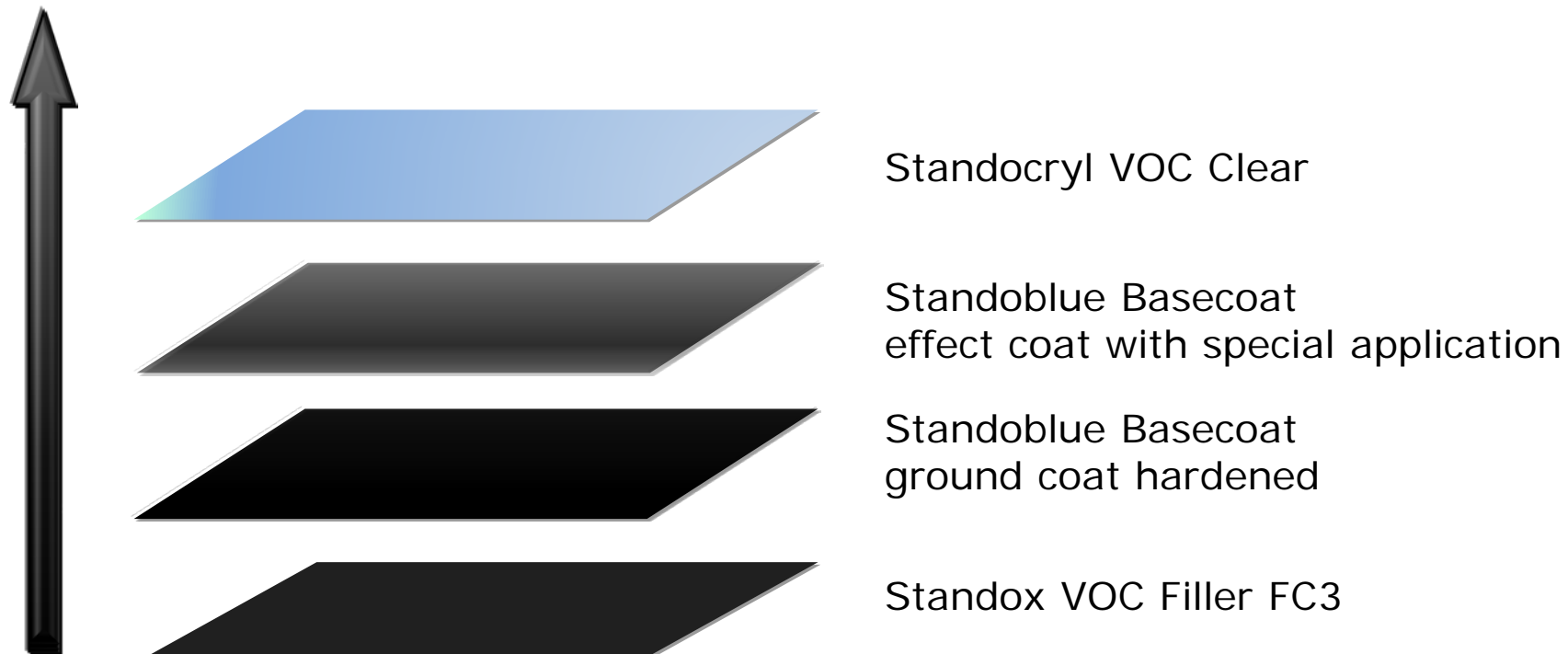
*“Machine Grey was developed to express the beauty of a machine’s strength and precision. With strong contrast between light and shadow and a sleek, high-density finish, it gives the impression that the vehicle’s body has been sculpted from a solid steel ingot.”*



- For Machine Grey 46G, Mazda engineers developed a special OEM painting process, called „Takuminuri“
- A term which is a combination of both „Takumi“ (skilled craftsman) and „Nuri“ (painting).\*

\*Source: Text and images Mazda Germany PR

- Standox developed a special process to repair this unique colour shade. This refinish process requires the usage of special pigments and a particular paint build-up.
- Please check on Standowin IQ available formulas and individual pigments, which are required.



- Before starting the repair, make sure that you have the necessary materials available.

- Standoblue Basecoat Mix 221  
Seidensilber Ultra Fein.

Artikelnr.: 02050321



Standoblue Effect Additive 8540.

Artikelnr.: 02050308



- Follow the instructions in Standown IQ.

COLOUR GENIUS ANCILLARY MIX PERSONAL FORMULA TOOLS JOB LIST JOB HISTORY DOCUMENTS NEWS

MAZDA | 46G | MATRIXGRAU | SIFN+ | 1821903 | EUROPE | STANDBLUE BASECOAT | 06/04/2023

MAZDA | 46G | MATRIXGRAU | SIFN+ | 1821903 | EUROPE | STANDBLUE BASECOAT | 06/04/2023

Ingredients Details Messages (6)

No quick select

ADDITION OF 300% 8540 EFFECT ADDITIVE REQUIRED SPECIAL APPLICATION | APPROXIMATE MATCH ONLY | 3-STAGE COLOR | SP => FORMULA CONTAINS SPECIAL PIGMENT, CHECK AVAILABILITY | USE DEALER LABEL - STBLUE-A | FORMULA CONTAINS NEW TINT - PLEASE CHECK AVAILABILITY

Mix	Description	gram (abs.)	gram (cum.)
STBLUE 221	SILK SILVER ULTRA FINE	330.16	330.16
STBLUE 248	INTENSE BLACK	362.45	692.60
STBLUE 190	SPEZIAL-ZUSATZ	204.07	896.67
STBLUE 191	TRANSPARENT	51.02	947.69
STBLUE 170	VIOLETT	30.92	978.61
STBLUE 271	TURQUOISE BLUE	21.26	999.87
STBLUE 172	BLAU	18.53	1018.40

- Click on Ready to spray mixture to directly add Standox Effect Additive 8540 to the formula.

# STANDOX REPAIR PROCESS MAZDA 46G MACHINE GREY. COLOUR MATCHING.



Navigation bar with icons: COLOUR, GENIUS, ANCILLARY MIX, PERSONAL FORMULA, TOOLS, JOB LIST, JOB HISTORY, DOCUMENTS, NEWS. Includes back, home, and share icons.

Choose a quick select: 20% 8510 [dropdown] [add] [trash] Group: --- [dropdown] STANDOBLUE [dropdown] Product: STANDOBLUE [dropdown]

Type	Style	Hardener	Thinner
<b>SPECIAL COLOR</b> 1. EFFECT (20% VA) ACTIVATED	--- DRY HOT + DRY WARM + HUMID >65%	---	8510 (---)

EFFECT STANDARD  
VOC   
6032

- Click on Special Color.

- Standex Effect Additive 8540 is now included in the mixing formula.

300,00 %  
  
8540  
[X] [checkmark]

# STANDOX REPAIR PROCESS MAZDA 46G MACHINE GREY. COLOUR MATCHING.



- No additional 8510 or 8520 adjustment additive is required.

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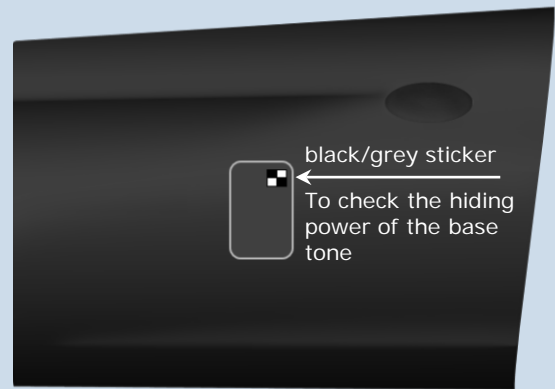
Mix	Description	gram (abs.)	gram (cum.)
TARE CAN + MIXING STICK			
STBLUE 221	SILK SILVER ULTRA FINE	82.72	82.72
STBLUE 248	INTENSE BLACK	90.82	173.54
STBLUE 190	SPEZIAL-ZUSATZ	51.13	224.67
STBLUE 191	TRANSPARENT	12.78	237.45
STBLUE 170	VIOLETT	7.75	245.20
STBLUE 271	TURQUOISE BLUE	5.33	250.53
STBLUE 172	BLAU	4.64	255.17
STIR			
8540	STANDBLUE 8540 EFFECT ADDITIVE	750.00	1005.17
STIR, READY FOR USE			



- Before starting application, the material flow must be set on the spray gun:
  1. Tighten the material screw completely.
  2. Now open the material screw by 0.75-1 turn to obtain the required amount of material, use the marking on the fluid control adjustment screw to guide you.
  3. The gun is now set correctly.

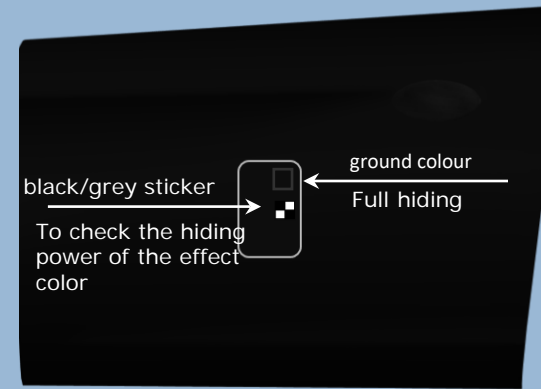


## Step 1



- Standoblue ground colour must be hardened with 5% Standoblue Hardener 8550 before adjusting with 10% Standoblue Viscosity Adjuster 8510/8520.
- Apply a black/grey sticker. This helps to check hiding.

## Step 2



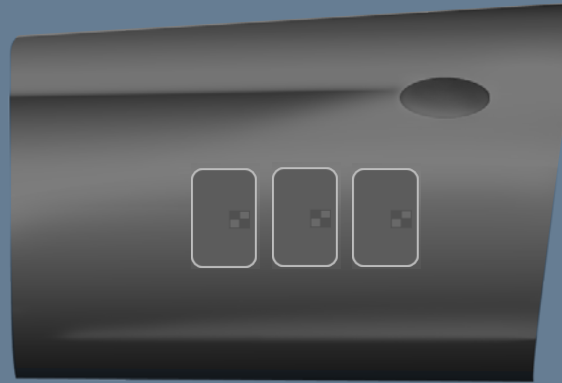
- Apply ground colour to full hiding. Dry ground colour according to TDS.
- Place another black/grey sticker to control the hiding of the effect colour.

### Step 3

- Adjusting the paint spray gun:
- Paint gun: \*Compliant / RP
- Nozzle: 1,2.
- Spray fan: Fully open.
- Material quantity: 0.75-1 turns
- Inlet pressure: 1.8-2 Bar\*2.
- Distance during spraying: 25-30cm.
- Application: 3-5 uniform spray passes.



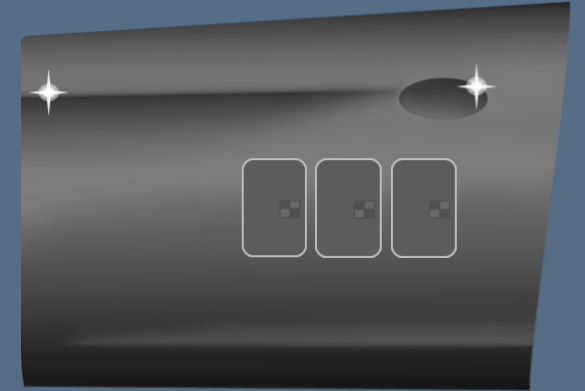
### Step 4



- Paint 3 sample panels with 3,4 and 5 sprays of the effect coat to optimally determine the color position and effect.
- Effect coats should be applied in a closed, uniform thin film to achieve a semi-wet appearance.
- Blow dry the individual layers between coats and wipe with a tack rag.



### Step 5



- Check effect color shade with daylight lamp.
- Apply a Standocryl VOC clearcoat recommended in 2 spray coats.



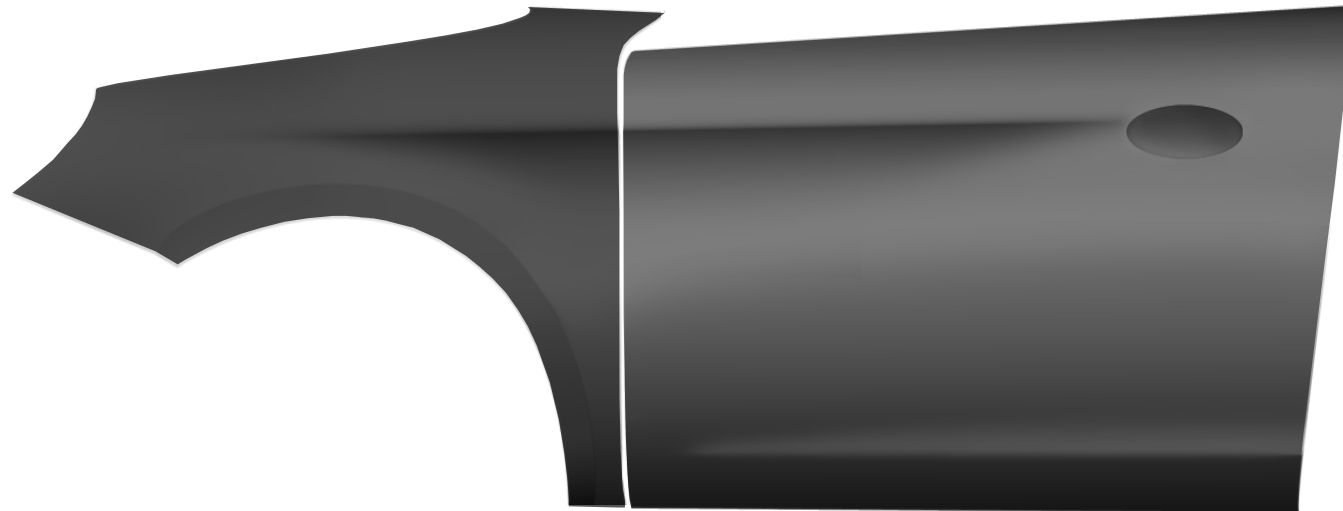
- Compare prepared colour card(s) to the car and determine the best match. (different variants)
- The usage of black & grey sticker for preparing colour cards and later when painting the car is recommended. This will help you to control transparent application of the effect coat colour.
- This special application method is necessary to achieve the required effect.
- **There are major differences in color tone and effect from model series to model series, within a model series and in some cases on one and the same vehicle (panel to panel).**
- **Therefore, blending-in over a larger area should be taken into account for color matching.**



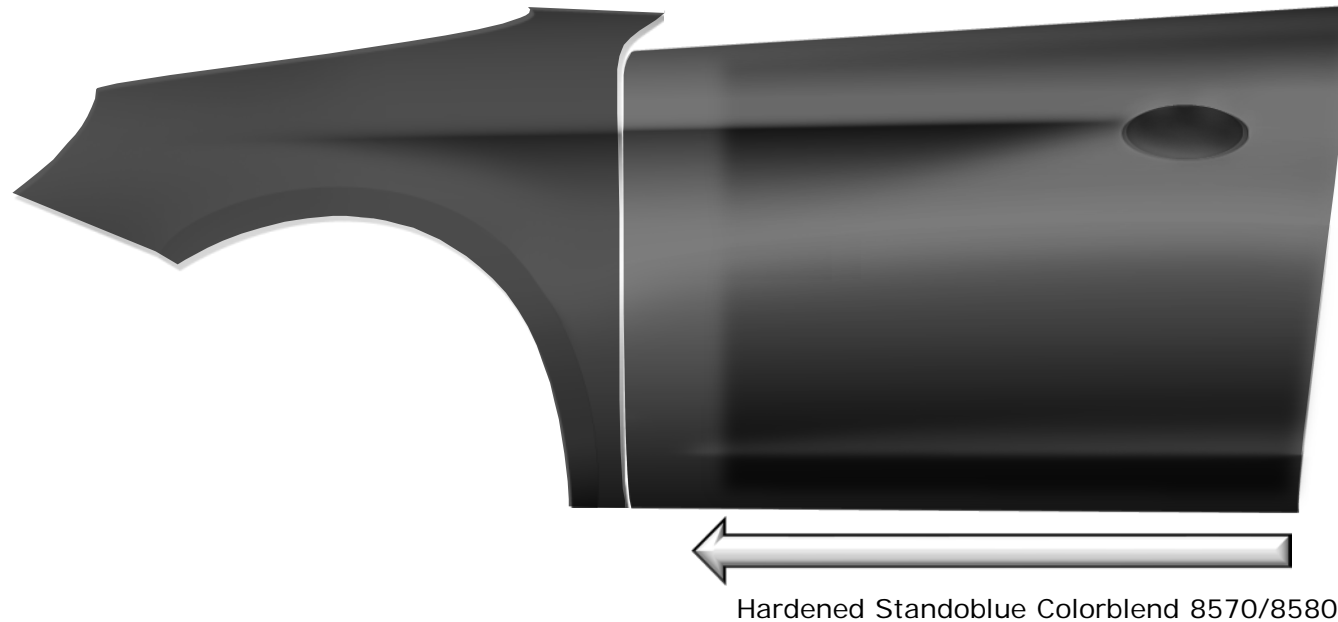
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Application & Blending

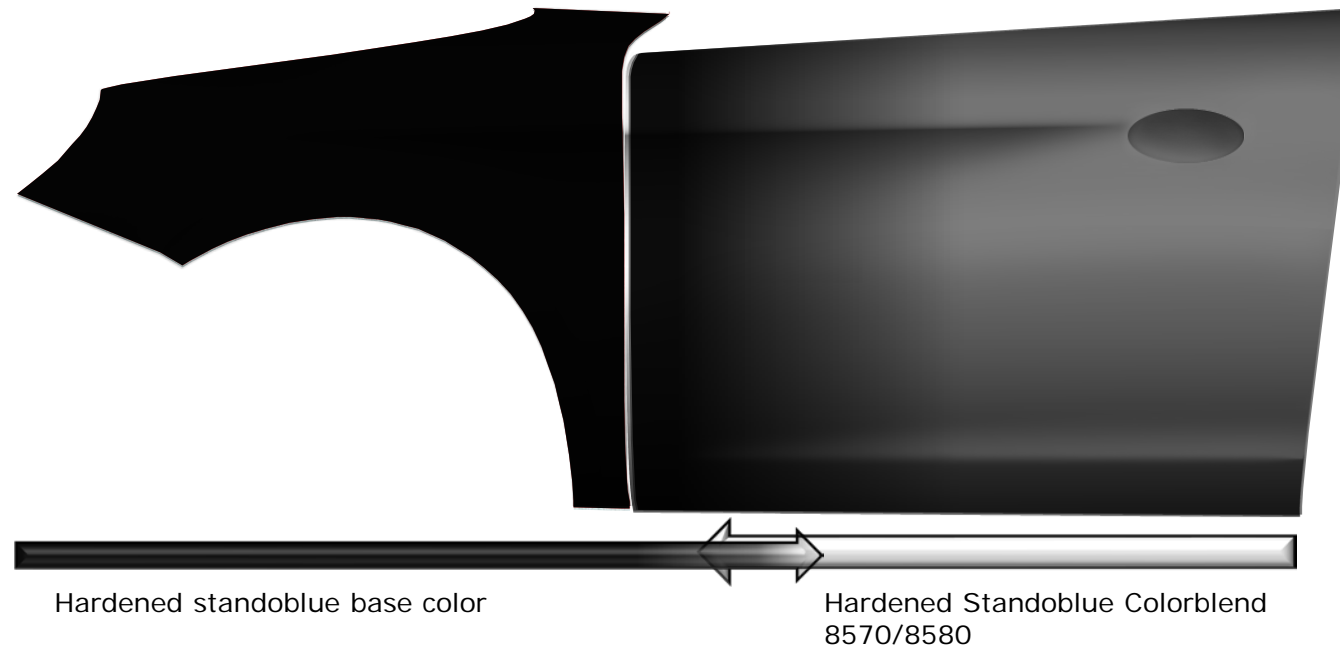
- Use of Standox VOC filler, preferably in filler color FC3.
- Filler sanding of the repair area with P600 – blending area P1000-P1200.
- Clean thoroughly.
- Prepare Activated Color Blend & groundcoat colour according to Standowin IQ.



- Apply Standoblue Color Blend 8570/8580 with 5% Standoblue Hardener 8550 to blend-in area, do not allow to flash off.
- Depending on local climatic conditions, a slower product adjustment using Standoblue Color Blend 8580 with 5% Standoblue Hardener 8550 may result in easier wetting, lower film thickness and better control.

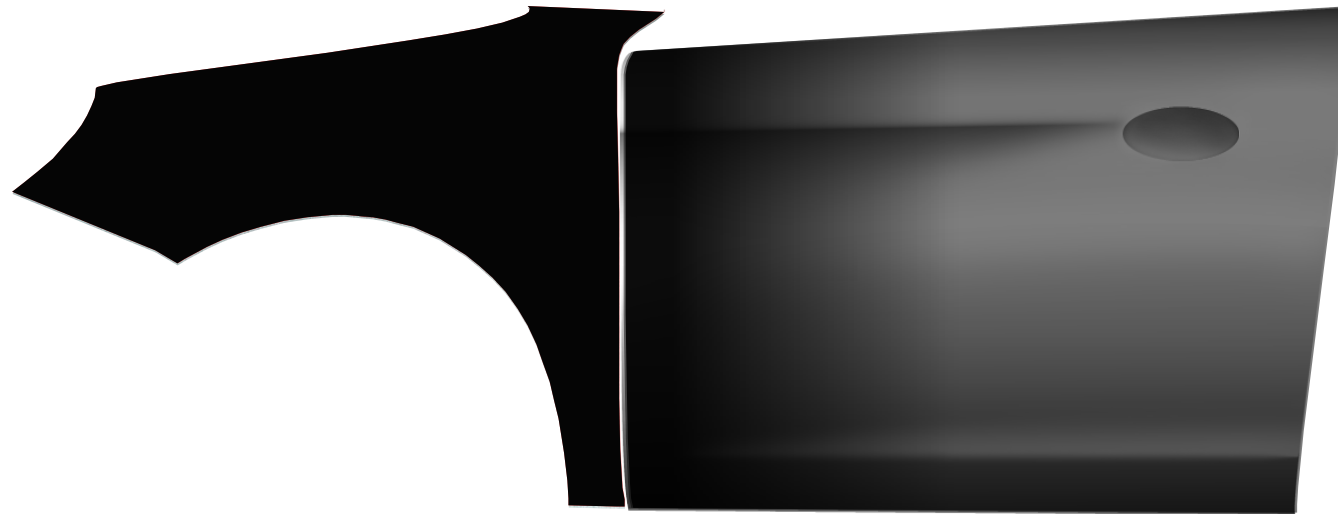


- Spray 1.5 coats of ground colour to repair panel and blend into the still wet Standoblue Color Blend.
- Use reduced fluid flow with groundcoat colour to prevent coarse overspray formation in blending area.
- Work towards repair area if possible, to reduce droplet formation and create a "soft" blend.
- Force dry for 10mins@60C. Allow to cool.

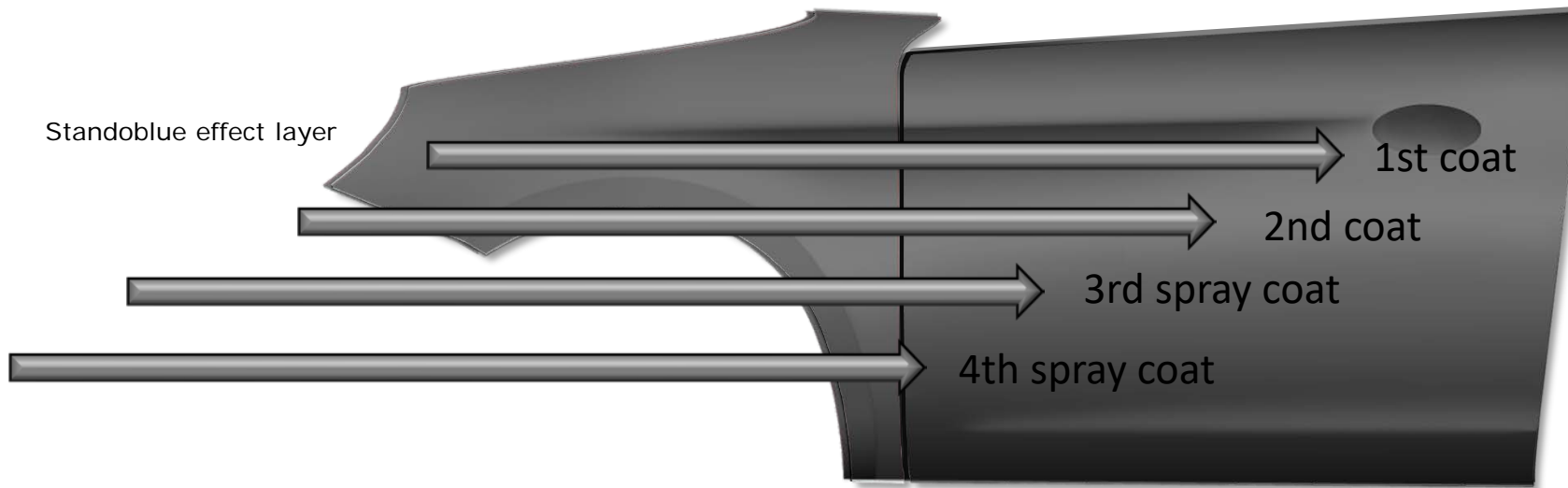




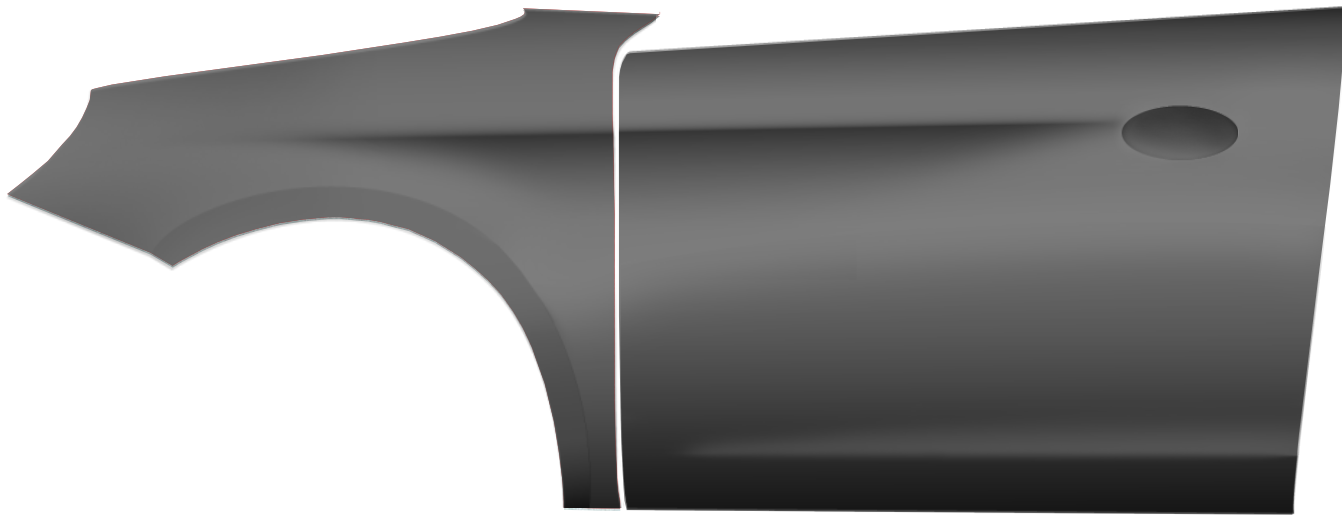
- Mix Standoblue effect colour according to Standowin IQ.
- Please observe the instructions regarding application in advance.



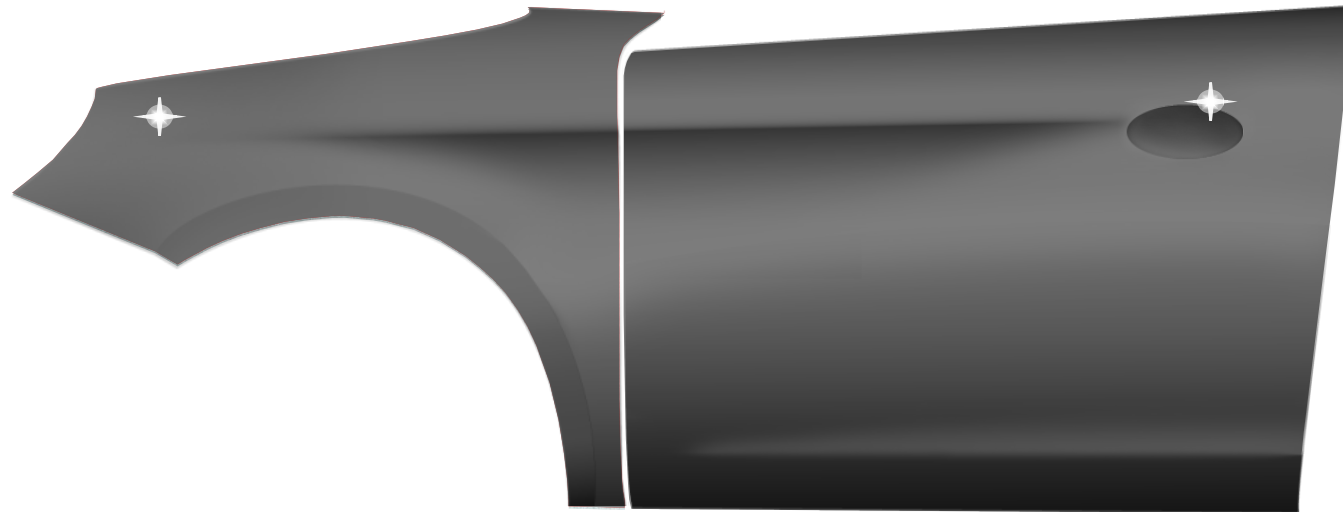
- Apply Effect Colour in 3-5 even coats to the part to be painted and the repair part. Allow to flash off.
- Start with the widest spray coat, spraying distance 25-30cm.
- Increase the spraying distance on the last coat to approx. 35 cm to correct possible mottling if required.



- Before applying the clearcoat, check the application of the effect layer with a daylight lamp, making sure that the groundcoat is completely covered in the transition area.



- Apply a Standocryl VOC clearcoat to the entire repair area.
- Dry according to the technical data sheet.

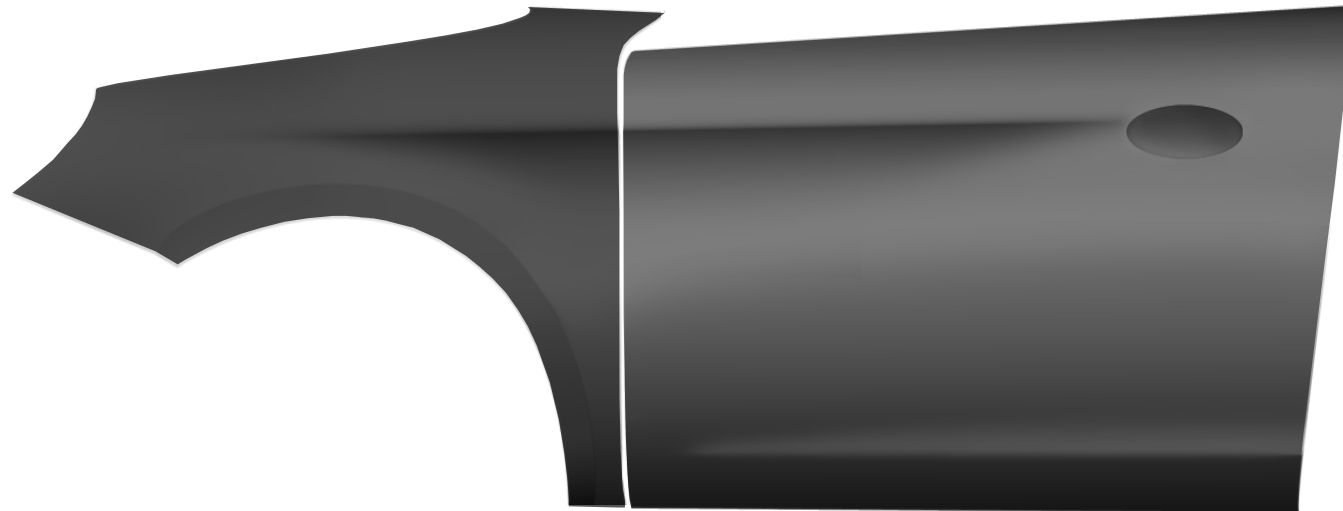




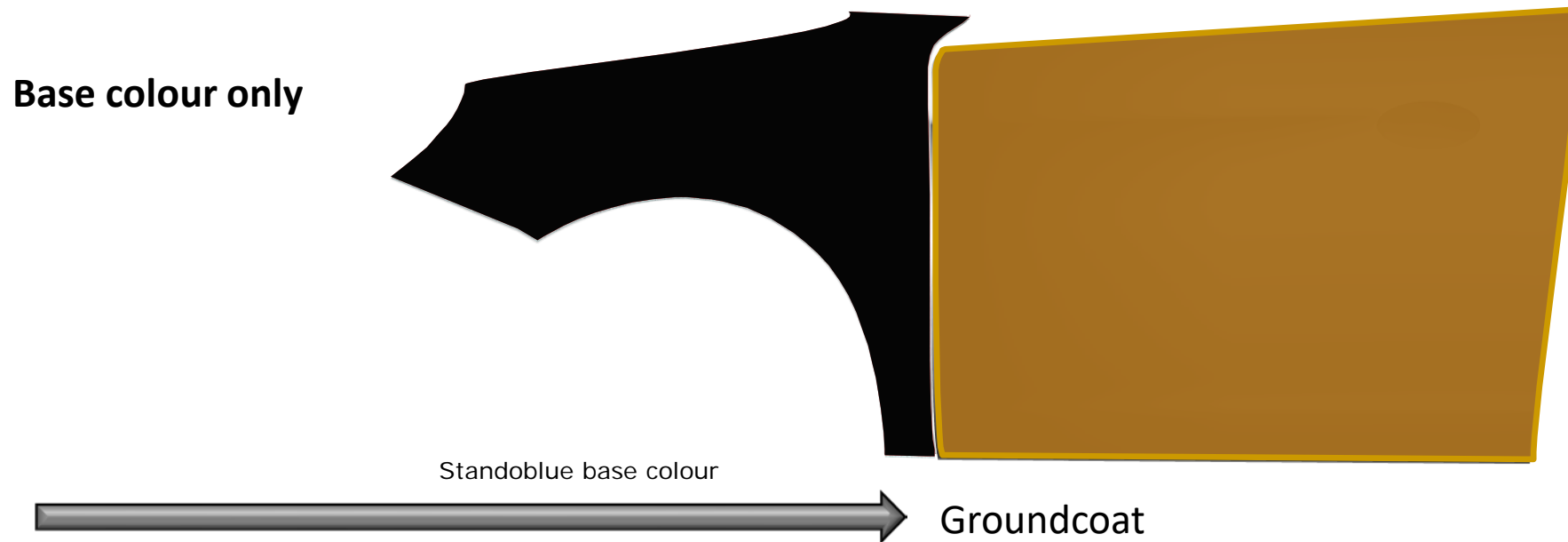
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Optional blending-in procedure

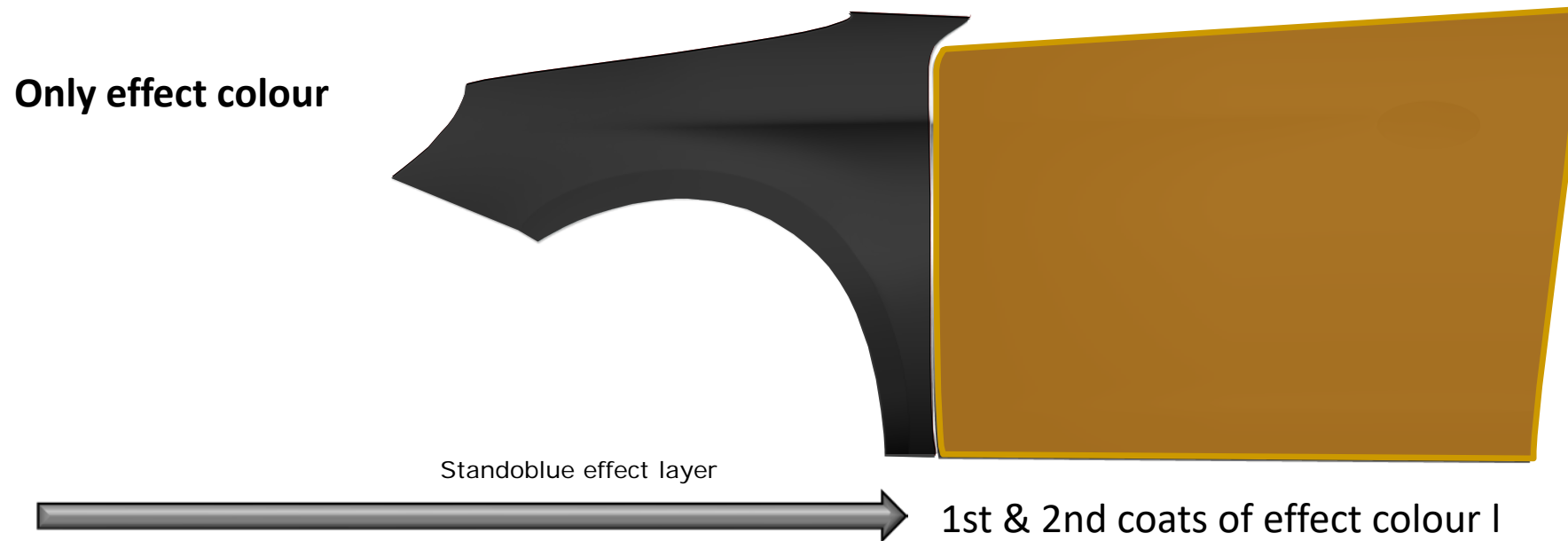
- Use of Standox VOC filler, preferably in filler colour FC3.
- Dry sanding of filler and old paint with P500-P600. Blending-in area P1500-P2000.
- Clean thoroughly.



- Mask Blending-in panel.
- Mix Standoblue base color according to Standowin IQ. Adjust the Standoblue base color with 5% Standoblue Hardener 8550 and 10% Standoblue Viscosity Adjuster 8510/8520.
- Apply the ground colour to the repair part in 1.5 coats in one operation.
- Flash off and force dry for 10mins@60C. Allow to cool.

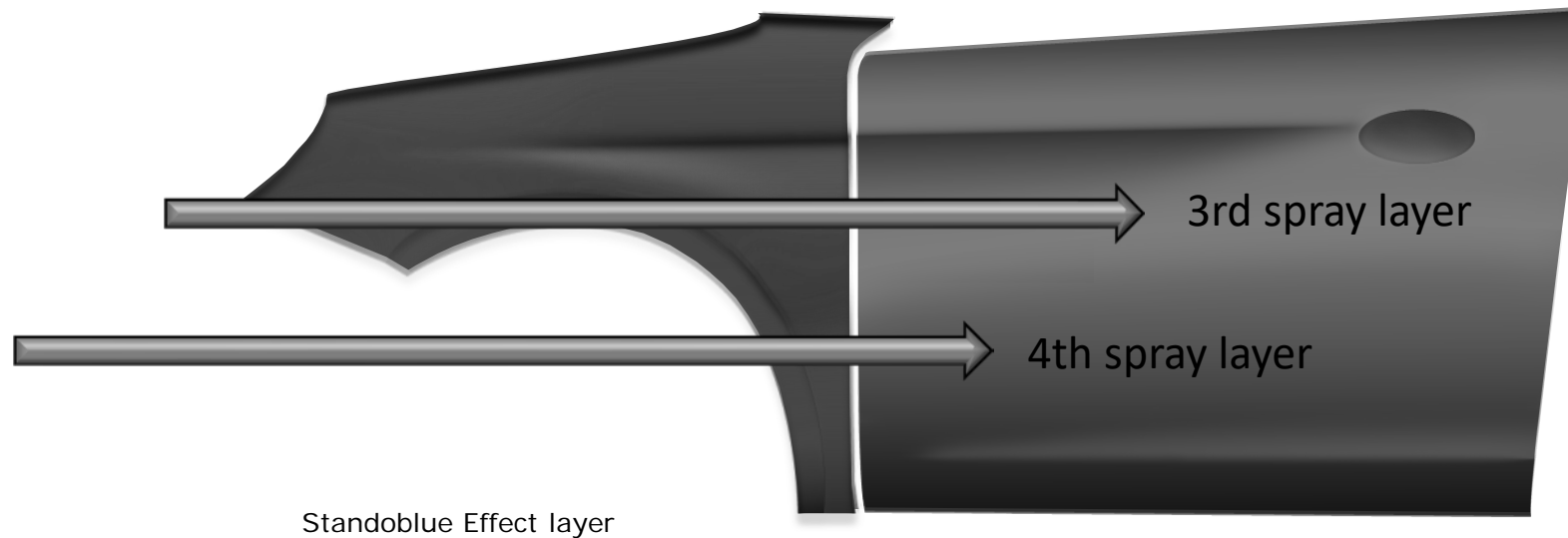


- Apply 2 single coats even coats of the effect layer to the repair part.
- Flash off between the individual coats.

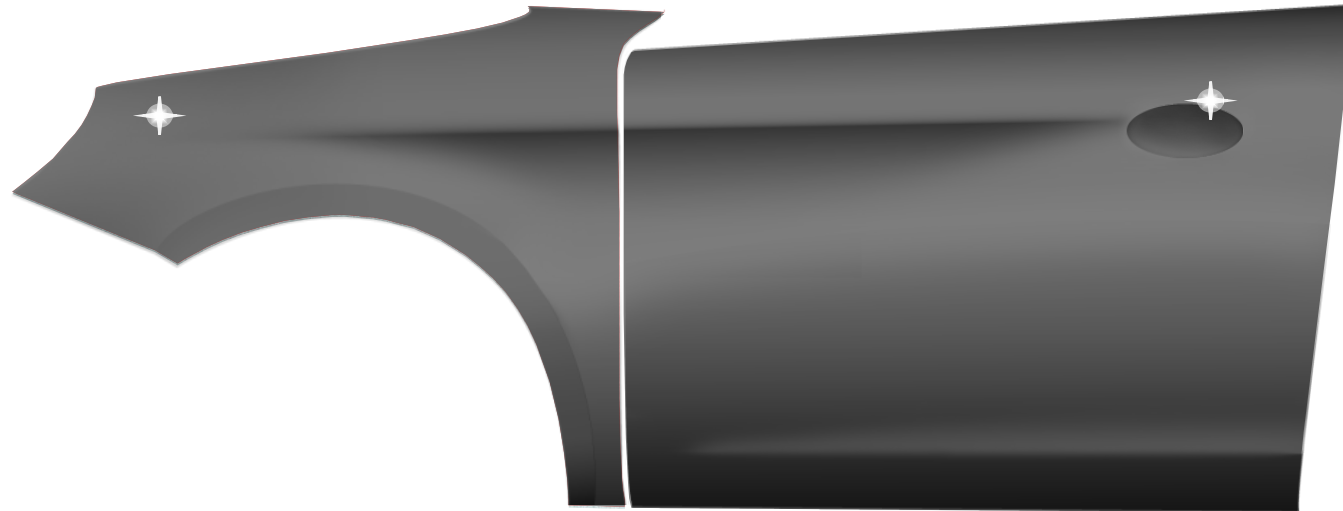




- Carefully remove the masking paper after the initial coats dried.
- Apply the effect colour evenly to the part to be blended and over the repair part in 2 single coats.
- Flash off between coats.
- Apply to the widest area first, spraying distance 25-30cm.
- Allow to flash off between the individual spray layers
- Increase the spraying distance in the last pass to approx. 35cm to correct possible cloud formation.



- Apply a Standocryl VOC clearcoat to the entire repair area.
- Dry according to the technical data sheet.



**Application of the groundcoat:**

Apply the groundcoat to create a soft transition into the adjacent part, keep as small as possible.

**Application of the effect layer :**

Adjust the spraygun correctly prior to application.

It may be beneficial to use an anti-static gun before and between effect coats.

Adhere to the spray distance and recommended procedure.

Paint with tight overlaps to produce an even result.

Dry the individual effect layers between coats e.g. with a hand blower.

Use a tack rag between coats.

Increase the distance to 35cm during the last spraying pass to correct cloud formation, if necessary.

- The effect layer should have this structure:





**The Art of Refinishing.**