

# Nissan KAB Super Silver

## VM4370 Solventborne Repair Process

**TCB101** Technical Bulletin  
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The following process outlining the repair of Nissan KAB Super Silver paint scheme has been approved by PPG.

When repairing Nissan vehicles finished in this paint scheme you should contact your PPG representative for full documentation on the approved product systems and processes. This repair process can be used with any of PPG's Premium Solvent Basecoat Systems (DELTRON® DBC, GLOBAL REFINISH SYSTEM® BC, and NEXA AUTOCOLOR® 2K® paint systems).

**This Specific repair process is necessary to meet appearance, performance, and VOC regulatory requirements.**



### DESCRIPTION:

- Nissan KAB Super Silver is a special effect silver color which gives the paint a “Liquid Metal” appearance. Unlike a traditional metallic or pearlescence this finish appears more like a “Molten Metal” that wraps the entire vehicle. Because of the minute particle size of this special pigmentation, light is reflected differently thus making this a very unique finish.
- The OEM process utilizes a unique 4 coat system made up of a bright metallic base, followed by a sanded clearcoat, to which the Bluish Silver layer is applied and then overcoated by another clearcoat layer. See the following illustration:

<b>Final Scratch Resistant Clearcoat Layer</b>
<b>Bluish Silver Layer</b>
<b>Sanded Clearcoat</b>
<b>Bright Metallic Basecoat</b>
<b>OEM Substrate / Primer</b>

- The repair outlined in this document duplicates the OEM process as closely as possible utilizing products similar to those used at the factory.

## PREPARATION OF THE SUBSTRATE:

- The damaged body work of the vehicle should be repaired using the Nissan approved PPG repair and undercoating system for the substrate of the body panels being repaired (Aluminum, Steel, Plastic, etc.).
- Finish the repair in a G1 shaded sealer.

## PREPARATION OF THE COLOR CHECK PANEL:

**NOTE:** Due to the possible variation in color on a particular vehicle as well as application technique, it is essential that a color check panel be prepared to align the color before applying any basecoat color to the vehicle. The G1 color check panel (PPG Part# ARMC464G1) should be prepared as follows:

- Mix and apply Nissan color code K23 (PPG Code 907322, *Nexa Autocolor* paint system code P422-4KTMB) basecoat to the entire color check panel insuring full coverage. Allow suitable flash times between coats. Allow the basecoat to dry the correct amount based on spray facilities before applying the sandable clearcoat layer.
- Mix and apply clearcoat to the entire color check panel. 2 coats should be applied so that enough film build is present to allow for sanding. The use of the following premium clearcoats are recommended.
  - *Deltron* DCU2021 Urethane Clear
  - *Global Refinish System* D894 High Solids Clear
  - *Nexa Autocolor* P190-6690 High Solids Clearcoat
- Once the clearcoat has fully dried, remove any orange peel or texture with P1200 dry then further refine the surface with P1000 Trizact™ wet to minimize any final scratches.

**NOTE: This sanding of the clearcoat step is critical due to the leafing nature of the Bluish Silver layer. Any imperfection (dirt or sand scratches) will telegraph through to the final finish.**

- Mix the Nissan KAB (PPG Code 918873, *Nexa Autocolor* paint system Code P422-7KAFB) basecoat color. The formulas can be found on PAINTMANAGER® software or on On-Line Color. Once mixed, the basecoat color is ready to spray. **No additional reducer is required.**
  - Apply 2 to 3 coats of the mixed Bluish Silver basecoat to the color check panel allowing appropriate flash times between coats. Apply this basecoat layer as you normally would.
  - Allow a minimum of 20 minutes dry time at 70°F (21°C) before the final clearcoat is applied.
  - Mix and apply clearcoat to the entire panel. The use of the following PPG premium clearcoats are recommended:
    - *Deltron* DC4125 CERAMICLEAR® Clearcoat
    - *Global Refinish System* D8126 *CeramiClear* Mar and Scratch Resistance Clearcoat
    - *Nexa Autocolor* P190-6490 Scratch Resistance Clearcoat
  - Apply the first coat of clear as a light coat. Avoid overwetting as movement of the Bluish Silver basecoat may occur resulting in blotchiness.
    - Allow the first coat of clear to flash 10 - 15 minutes
    - Apply a second full coat of clear.

## CHECK THE COLOR:

- Use the completed color check panel to evaluate the color on the car.
- If the color achieved on the color check panel is considered to be “blendable” to the car proceed to the section “GROUNDCOAT COLOR AND CLEAR APPLICATION”.
- If tinting of the color is necessary, tint utilizing toners within the original formula and prepare an additional color check panel and re-check. Continue in this fashion until a blendable match is achieved.

## GROUNDCOAT COLOR AND CLEAR APPLICATION:

- Mix and apply Nissan color code K23 (PPG Code 907322, *Nexa Autocolor* paint system Code P422-4KTMB) over the G1 sealed area. Blend out additional coats as needed to eliminate any “hard edge” of color.
- Mix and apply clearcoat to the entire repaired panel. Blending of this clearcoat layer is not recommended. Apply clear “edge to edge”.
  - Two to three coats should be applied so that enough film build is present to allow for sanding. The use of the following premium clearcoats is recommended:
    - *Deltron* DCU2021 Urethane Clear
    - *Global Refinish System* D894 High Solids Clear
    - *Nexa Autocolor* P190-6690 High Solids Clearcoat
  - Once the clearcoat has fully dried:
    - Remove any orange peel or texture with P1200 dry.
    - Then further refine the surface with P1000 Trizact wet to minimize any final scratches.
    - In areas that extend beyond the K23 groundcoat color, where the topcoat color will be applied and blended, sand those areas with P3000 grit Trizact.

**NOTE: This sanding of the clearcoat step is critical due to the leafing nature of the Bluish Silver layer. Any imperfection (dirt or sand scratches) will telegraph through to the final finish.**

## BASECOAT KAB COLOR APPLICATION:

- Mix the Nissan KAB (PPG Code 918873, *Nexa Autocolor* paint system Code P422-7KAFB) basecoat color. Choose the “4CT” formulas in *Deltron* DBC, *Global Refinish System* BC, and *Nexa Autocolor* 2K paint systems available on *PaintManager* program software. Once mixed, the basecoat color is ready to spray. **No additional reducer is required.**
  - Apply 2 to 3 coats of the mixed Bluish Silver basecoat to the repair following normal blending recommendations.
  - Allow a minimum of 20 minutes dry time at 70°F before the final clearcoat is applied.

## FINAL CLEARCOAT APPLICATION:

- Mix and apply clearcoat to the entire repair area. The use of the following premium clearcoats are recommended:
  - *Deltron* DC4125 *CeramiClear* Clearcoat
  - *Global Refinish System* D8126 *CeramiClear* Mar and Scratch Resistance Clearcoat
  - *Nexa Autocolor* P190-6490 Scratch Resistance Clearcoat

- Apply the first coat of clear as a light coat. Avoid over wetting as movement of the Bluish Silver basecoat material may occur resulting in blotchiness.
  - Allow the first coat of clear to flash 10 -15 minutes.
- Apply a second full coat.
- A third full coat may be applied if necessary.
- Bake at 140°F (metal temperature) for 20 minutes.
- If necessary and to achieve the smoothest possible final finish, sand with P1200 or finer (dry) and then re-apply the Scratch Resistant Clearcoat.



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