



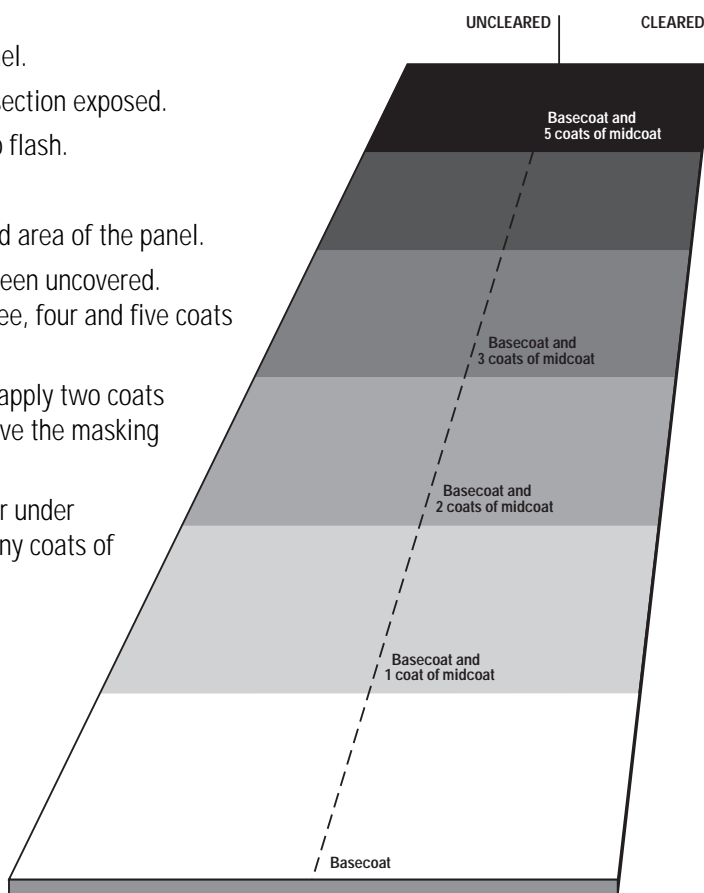
## DuPont Automotive Finishes

### Tri-coat Repairs

The first step in the DuPont system for repairing OEM tri-coat finishes is to prepare a let-down panel. The let-down panel shows how many coats of midcoat it will take to match the original finish.

#### Step 1: Make A Let-Down Panel

1. Apply basecoat color to hiding over the entire panel.
2. Mask the panel in five sections, leaving the first section exposed.
3. Apply a medium-wet coat of midcoat and allow to flash.
4. Remove masking from next section.
5. Apply a medium-wet coat of midcoat over exposed area of the panel.
6. Repeat steps 4 and 5 until all five sections have been uncovered. Your panel will illustrate the effects of one, two, three, four and five coats of midcoat, as shown here.
7. Once the panel is dry, mask it off lengthwise and apply two coats of the appropriate clear to the unmasked half. Remove the masking paper and let the panel dry.
8. Compare the panel to the car in natural daylight or under color-corrected indoor lighting to determine how many coats of midcoat you will need to apply.



#### Step 2: Prepare the Surface

1. Clean and degrease the repair area with an appropriate VOC cleaner (DuPont First Klean 3900S™, DuPont Kwik Clean 3949S™, or Prep-Sol® 3919S™.)
2. Pretreat and prime where needed.
3. Sand the primed area with P400 DA grit or P500 - P600 dry or wet sandpaper.
4. Sand all panels to be blended with 1500 grit sandpaper. Tri-coat colors require more area for extended blends than conventional base/clear colors.
5. Clean the area with an appropriate VOC cleaner (DuPont Final Klean 3901S™, DuPont 3939S™ Lacquer & Enamel Cleaner or DuPont Low VOC Final Klean 3909S™).
6. Seal the primed area.
7. Apply one coat of DuPont 222S™ Mid-Coat Adhesion Promoter over all sealed panels involved in the repair. This should be applied beyond the areas where the last coat of clear will go in order to help with adhesion.

## Tri-coat Repairs

### Step 3: Apply the Color, Midcoat and Clear

1. Apply the basecoat to full hiding, extending each coat slightly beyond the previous one. Allow adequate flash time between coats.
2. Apply the number of midcoats indicated by the let-down panel. Be sure to fully cover the base color before tapering the blend edge of each coat of midcoat. Blend each coat beyond the next, and allow sufficient flash time between coats.
3. Clear all the panels with ChromaPremier® 72500S™ Clearcoat.

#### **Tips for Success**

##### **For let-down panels, remember:**

- Use the panel as a guide to determine the number of midcoats needed to match the OEM tri-coat color.
- A separate let-down panel must be made for each OEM tri-coat color.
- Store the let-down panel for future use.

##### **When applying the midcoat during both the let-down panel preparation and the repair:**

- When using ValueShade®, apply under the base color only. Do not use ValueShade® under the midcoat.
- Agitate often to keep heavy mica flakes in suspension and properly oriented.
- Use the same reduction, air pressure and application equipment/setup for both the preparation of the let-down panel and the repair.
- Build up the midcoat gradually by applying thin, light coats.
- Because of individual variations in technique and equipment, each refinisher should make his or her own let-down panel.

##### **When doing the actual repair:**

- Clean the spray area well. Dirt is a major enemy of a successful tri-coat repair.
- Plan on making light blends of the midcoat into adjacent panels.
- Never rush a tri-coat repair. Always allow sufficient time.
- Refer to Special Basecoat Blending Procedures, Technique II, for additional blending options.

## VOC Regulated Areas

These directions refer to the use of products which may be restricted or require special mixing instructions in VOC regulated areas. Follow mixing and usage recommendations in the VOC Compliant Products Chart for your area.

## Safety and Handling

WEAR A POSITIVE-PRESSURE, SUPPLIED-AIR RESPIRATOR (NIOSH APPROVED TC-19C), EYE PROTECTION, GLOVES AND PROTECTIVE CLOTHING WHILE MIXING ACTIVATOR WITH PAINT, DURING APPLICATION AND UNTIL ALL VAPORS AND SPRAY MIST ARE EXHAUSTED. Follow respirator manufacturer's directions for respirator use. INDIVIDUALS WITH HISTORY OF LUNG OR BREATHING PROBLEMS OR PRIOR REACTION TO ISOCYANATES SHOULD NOT USE OR BE EXPOSED TO VAPOR OR SPRAY MIST. Do not permit anyone without protection in the painting area.