Technical Information

"Blend in" Technique

One coat system
22-solid colors

B 18

General:

In general, panel repairs - which consist of refinishing the entire damaged body part - do not cause any problems with solid colors. Where color variations are to be expected or where there is no limitation to the areas to be sprayed such as seams or trim strips, it is better to use the "blend technique" of spraying into the surrounding area. Blending in can be more economical and efficient than time consuming color tinting.

Processing:

1. Pretreatment

Pretreat damaged part as usual until top coat painting step. Clean the undamaged paintwork with:

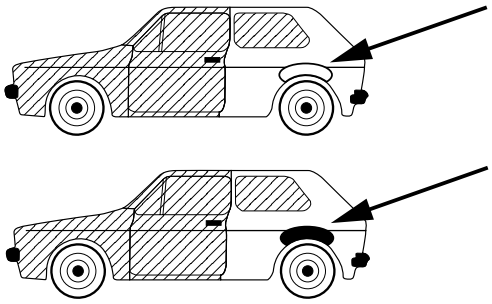
Silicone and Tar Remover **541-5**

Then sand with

Sandfix Paste
and Sanding Pad **563-808**

Clean blend-in area with water; clean again with

Silicone and Tar Remover **541-5**



2. Blending in

1. Pretreatment as described under 1.) Masking of adjacent areas.

2. Spray damaged area with 22- as usual but with reduced pressure (approx. 45 p.s.i.)

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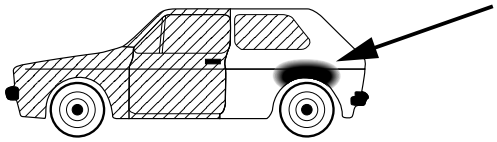
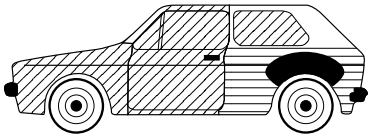
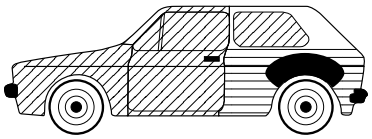
3. Spray 22- line in a very thin coat (mist coat) and blend out the edge on to surrounding surface..
   Use reduced pressure (30 p.s.i.).



4. After a flash off of approx. 5 min. the entire part is sprayed with 1–2 thin coats of 923-355 clear (2:1:1).



4a. If masking in roof area is not possible, the 923- has to be sprayed out into the roof pillar. For this purpose 923- must be overreduced 50% with 352-400 Blend-In Reducer. The melt in area will then be levelled with 352-400 blend in reducer. Prior to this the blend-in surface has to be prepared with Sandfix paste. After drying (additional with IR dryer if req.) the blended area can be carefully polished



Note: A tinted filler should be used when working with poor hiding colors.