

Technical Information

“Blend in” Technique - Blending in on the panel being repaired

55- Basecoat

B
18a

General:

In principle, panel repairs with metallic basecoats are possible, and, as a rule, it is not necessary to respray adjacent body parts. Where color variations are to be expected and where there is no limitation to the areas to be sprayed such as seams or trim strips, it is faster to overcome these differences by blending the spray into the surrounding areas or adjacent part.

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 that is to accept the blend with:

Silicone and Tar Remover	541-5 or
Clean fix	541-92

Then sand with:

Sandfix and Scuff Pad	563-808
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After cleaning with water, clean again with:

Silicone and Tar Remover	541-5 or
Clean fix	541-92

2. Blending in

When repairing two coat metallic systems, the entire blend area should be presprayed with:

Blending Clear	55-B500
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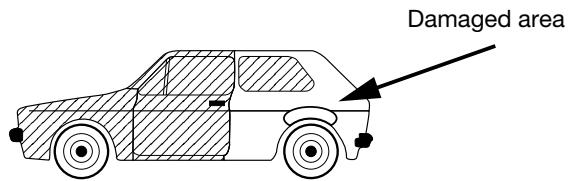
This is necessary in order to have the metallic particles orientated properly within the blending area.

Glasurit 55-B500 is not required when applying solid colors.

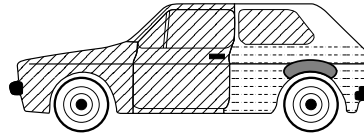


3. Blend in procedure on the same panel:

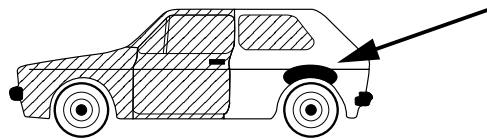
3.1. Pretreatment as described under step 1.
Masking of adjacent areas.



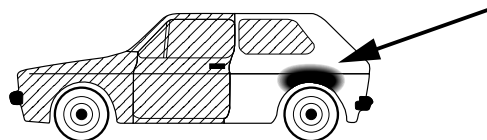
3.2. Spray the entire repair part including the damaged area with Blending Clear 55-B500 (1 spray coat).



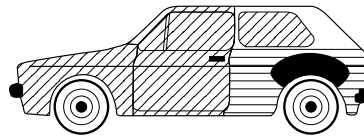
3.3. Spray damaged area with base coat metallic paint (2 coats to hiding)



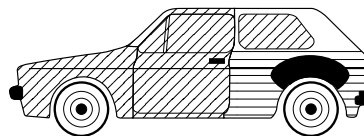
3.4. Reduce air pressure to 15 p.s.i., apply a thin 1/2 coat of metallic basecoat and blend out the edge fading out on the surrounding surface.



3.5. Apply 1 - 2 coats of normally reduced 923- clear* onto the entire part, including repair area.



3.5a. If masking in roof area is not possible, the 923- clear* 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 1 - 2 coats of 352-400 Blend-In Reducer. Prior to this, the whole blend-in area has to be scuffed matte. After drying (additional with IR dryer if req.) the blended area can be carefully polished.



Note: When working with poor hiding colors we recommend the use of a tinted primer.

* Refer to specific clearcoat information in section EC to determine the appropriate clearcoat for each topcoat system and VOC information.