

Technical Information

“Blend in” Technique - Blending in on the adjacent panel

55- Basecoat

B
18b

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 blend area should be sprayed with:

Blending Clear	55-B500
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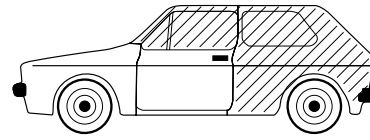
Follow the procedure in Section 3.

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

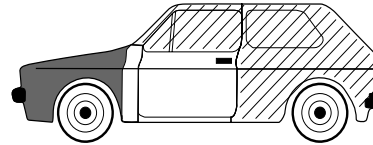


3. Blend in procedure on the same panel:

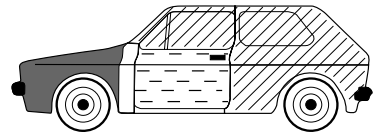
3.1. Pretreatment as described under step 1.



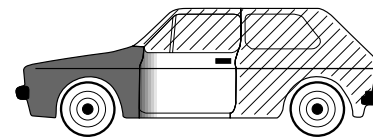
3.2. Spray 1 coat of 55-Line Basecoat on the panel being repaired, finishing just before the edge of this panel.
Flash off until matte.



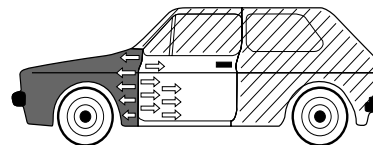
3.3. Spray the entire adjacent part with 1 coat of Blending Clear 55-B500.
Glasurit Blending Clear 55-B500 is not required when applying solid colors.



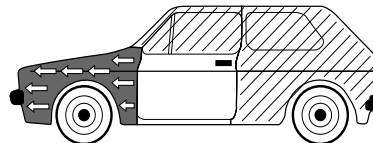
3.4. Spray 1 coat of 55-Line Basecoat (to hiding) on the panel being repaired, fading into the adjacent panel. Use reduced spray pressure (15-30 psi/1.0-2.0 bar).
Flash off until matte.



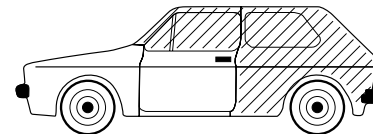
3.5. Feather in the area where the panel being repaired and the adjacent panel border on each other. First pass should be approximately 6 inches wide, then extend that to 10 - 12 inches on the second pass.
Spraying pressure: 15-30 psi/1.0-2.0 bar
Flash off until matte.



3.6. Spray a half-coat on the panel being repaired (to match the effect), and into adjacent panel.
Spraying pressure: 30 - 50 psi/2-3.5 bar
Flash off until matte.



3.7. Apply 2 coats of 923- clear* mixed normally onto the entire repair area.



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.