

Technical Information

Blending-in on the adjacent panel with Glasurit Basecoats – water-based – 90-Line Pearl effect

B
26c

General Information:

The method of blending-in is used to overcome color differences. To ensure that the edge of the overspray area is smooth and homogeneous, undercoat and Pearl effect basecoat must be blended-in on the adjacent panel.

1. Pre-treatment:

Prepare the substrate for topcoat application as usual.

Clean with:	Glasurit Cleaner	700-1 or
	Glasurit Clean Fix	541-92
Sand surrounding area with	Sanding pad (e.g. white from 3M) and	
	Glasurit Sand Fix	563-808
Clean again with	Glasurit Cleaner	700-1 or
	Glasurit Clean Fix	541-92

2. Blending-in on the adjacent panel

2.1 Undercoat: 90-Line, solid color

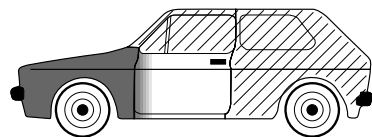
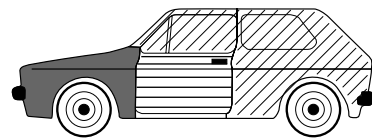
Spray viscosity:	18 - 24 sec DIN 4mm
Spray gun:	HVLP, 1.3 mm
Spraying pressure:	2 - 3 bar/30 - 45 p.s.i. intake pressure
Spray coats:	2
Flash-off between coats:	until matte after each spray coat *

Mask adjacent surfaces.

Spray 2 coats to cover on the panel being repaired.

Remove masking from adjacent surfaces.

Blend the undercoat into the adjacent panels (gun intake pressure 1 - 2 bar/15 - 30 p.s.i., move gun vertically).



* Use of the SATA DryJet (or equivalent) will significantly reduce the dry times.



2.2 Basecoat: 90-Line, pearl effect

Spray viscosity: 18 - 24 sec DIN 4mm

Spray gun: HVLP, 1.3 mm

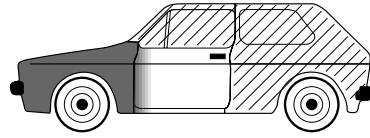
Spraying pressure: 2 - 3 bar/30 - 45 p.s.i.
intake pressure

Spray coats: 2 plus a half coat to match
the effect

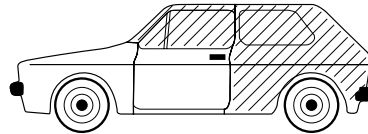
Flash-off between
coats: until matte after each
spray coat *

Spray 2 1/2 coats on the panel being repaired,
overlapping into the adjacent panel.

Flash-off before application of clear: 2 - 3 minutes



3. 923-Clear



* Use of the SATA DryJet (or equivalent) will significantly reduce the dry times.