

Technical Information

Blending-in on the adjacent panel with Glasurit Basecoats – water-based – 90-Line Metallic/Solid Colors , Pearl Metallics, Multi-effect

**B
26a**

General Information:

The method of blending-in is used to overcome color differences. It involves the use of 90-M5 Blending Clear which allows the effect particles to align and lie down in the fade-out area and ensures at the same time that the edge of the overspray area is smooth and homogeneous. 90-M5 Blending Clear guarantees that the fade-out area does not show any dark marks.

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

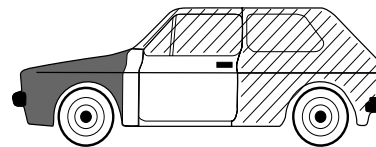
2. Blending-in on the adjacent panel (Example is a fender repair)

2.1 Basecoat 90-Line

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 1 coat on the panel being repaired, finishing just before the edge of this panel.

Flash off until matte. *

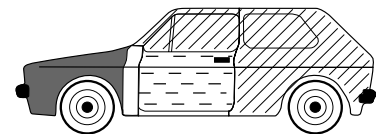


2.2. 90-M5 Blending Clear

Mixing Ratio:	2:1 90-M5:93-E3
Spray viscosity:	18 - 22 sec DIN 4mm
Spray gun:	HVLP, 1.3 mm
Spraying pressure:	2 - 3 bar/30 - 45 p.s.i. intake pressure

Spray 1 wet coat of 90-M5 on the adjacent panel.

No flash-off!

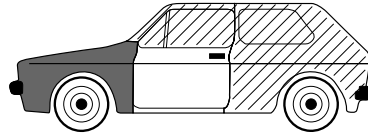


2.3 Basecoat 90-Line

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 1 coat to cover on the panel being repaired, finishing at the adjacent panel.

Flash-off until matte.*



2.4 Basecoat 90-Line

Spray viscosity: 18 - 24 sec DIN 4mm
Spray gun: HVLP, 1.3 mm

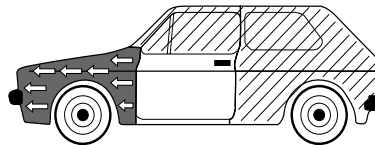
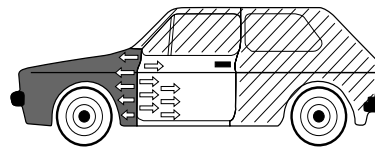
Feather in the area where the panel being repaired and the adjacent panel border on each other. First pass should be approximately 6 inches wide, then extend that to 10-12 inches on the second pass.

Spraying pressure: 1 - 2 bar/15 - 30 p.s.i.

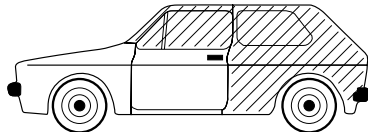
Spray a half-coat on the panel being repaired (to match the effect).

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

Flash-off before application of clear: 2 - 3 mins.



3. 923-Clear



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