

Blending in on the adjacent panel with Glasurit® 90 Line tri-coat colors (translucent step 2)

Remarks:

This system describes the Blending in on the adjacent panel with 90 Line tri-coat colors with translucent Step 2 (like e. g. Mazda 41V / 46V or Renault NNP Rouge Flamme).

With all translucent colors there is the need to verify the number of spray coats required for each color match and for each vehicle. Therefore, and due to differences in application techniques we recommend to apply different numbers of spray coats of Step 2 (translucent coat) on test panels coated with Step 1.

This process provides paint material and time saving advantages:

- Easier and safer blending process
- Do not use Glasurit® Blending Clear 90-M50.

Recommendation: Please check color and application first on test panels before applying to the vehicle.

Please refer to the following Blending Process:

Properties:






In principle, panel repairs with translucent 90 Line tri-coat colors are possible. But when color differences beyond allowable limits are to be expected, the more appropriate method to balance color differences may be to blend into the damaged area and / or the adjacent panel, depending on the damage. This procedure can be considerably more efficient and economical than time-consuming color matching.

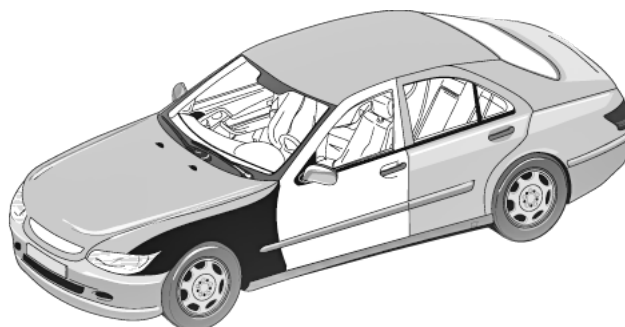
Remarks:

- Stick to the recommended flash-off times.
- Flash off after each spray coat until the surface is completely mat.
- Flash off times can be reduced by additional ventilation with blow equipment (e. g. Dry Jet).
- Brief increase of temperature in combined spray booths or by intermediate drying at 40°C in the oven after the final coat.
- An increasing basecoat thickness needs more flash off time.

Final sanding of the filler surfacer with orbital sander, not coarser than P500, and not finer than P1000.

1. Pre-treatment of the adjacent panel.

| | | | |
|--|--|---|--|
| <p>700-10 Glasurit® Degreasing and cleansing agent</p> |  1 x |  wipe dry |  Foam pad P1000- P1200 |
| <p>700-1 Glasurit® Cleaner</p> |  1 x |  wipe dry | |



Mask the adjacent panel if necessary.

Safety advice:

The products are suitable for professional use only.




It cannot be ruled out that this product contains particles < 0.1 µm.

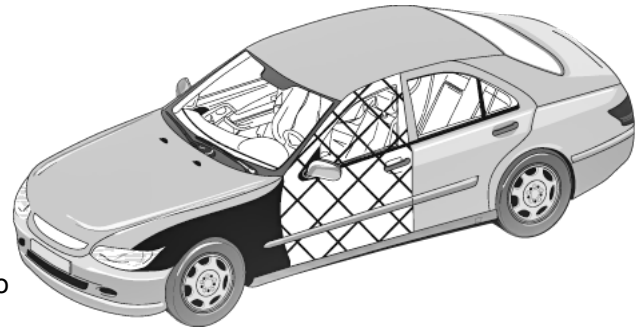
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2. Refinishing of the new panel / the panel to be repaired (Step 1)






| | | | |
|--------------------------------------|---|---|---|
| 90 Line Glasurit® Basecoat step 1 |  |  |  |
| | 2:1 93- E3 | HVLP 1.3 mm 2.0 bar | 2 (spray to cover) + 1/2 to match the effect |

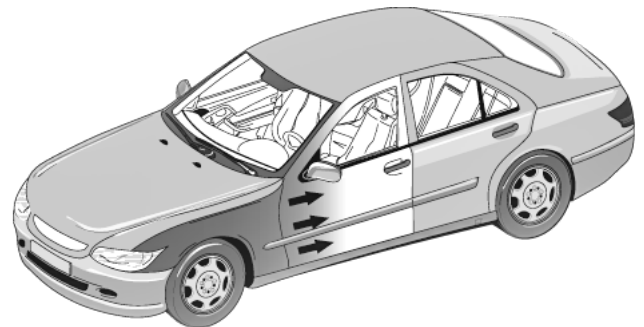


Notes:

Demask the adjacent panel, after the last spray coat has dried.
Using Step 1 fade out and overlap each spray coat into the adjacent panel.
Keep the blend small and keep the edge transition soft and gradual.
Maximum pressure 1.5 bar when blending out.
Blending agent 90-M50 is not needed for this process.

2.1 Refinishing of the blend transition area into the adjacent panel Step 1

| | | | | | |
|--------------------------------------|---|---|---|---|---|
| 90 Line Glasurit® Basecoat step 1 |  |  |  |  |  |
| | 2:1 93- E3 | HVLP 1.3 mm 1.0 - 1.5 bar | 1 - 2 fading out on both panels | 1/2 to match the effect | flash off until matt |



Notes:

Reduce spray gun pressure when blending.
After Step 1 has dried, use tack rag on the blended panel to remove any loose over spray.

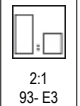
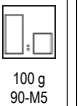
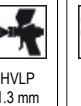

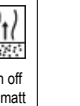
Safety advice:

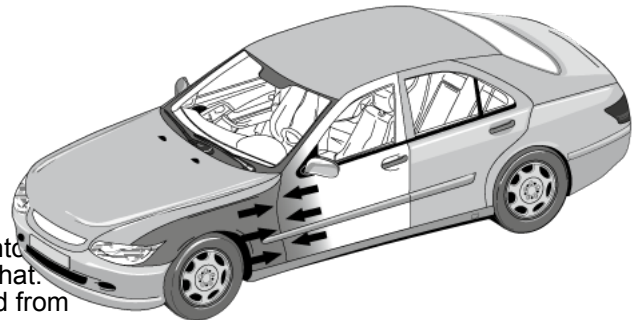
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2.2 Refinishing of the transition area [optional]

| | | | | | |
|---|--|---|---|--|--|
| 90-M5 Glasurit® Tri- coat-Additive |  2:1 93- E3 |  100 g 90-M5 (RFU) 30 g Step 1 (RFU) |  HVLP 1.3 mm 1.0 - 1.5 bar |  2 - 3 |  flash off until matt |
|---|--|---|---|--|--|

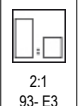

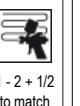
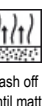


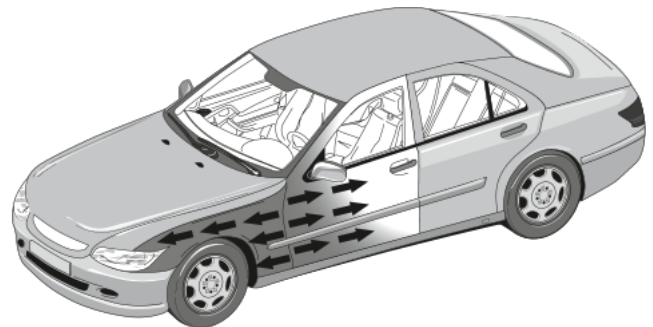
Notes:

For some colours it can be helpful to blend smoother into the transition area. This optional step can be used for that. For a smoother transition, 2 -3 coats should be sprayed from the outside to the inside.

Loose over spray should again be removed by a tack rag when dry.

3. Refinishing of the new panel / the panel to be repaired and of the adjacent panel Step 2

| | | | | | |
|--|---|---|--|---|---|
| 90 Line Glasurit® Basecoat step 2 |  2:1 93- E3 |  HVLP 1.3 mm 2.0 bar | 2,0 bar on the repaired panel; 1,5 bar on the blending in zone |  1 - 2 + 1/2 to match the effect |  flash off until matt |
|--|---|---|--|---|---|



Notes:

Fade out and overlap each spray coat into the adjacent panel.

Reduce pressure when blending into the adjacent panel.

Apply the ½ coat to match the effect over the repaired area with reduced pressure of 1.5 bar.

Apply staggered overlaps to produce consistent basecoat finish.

Safety advice:





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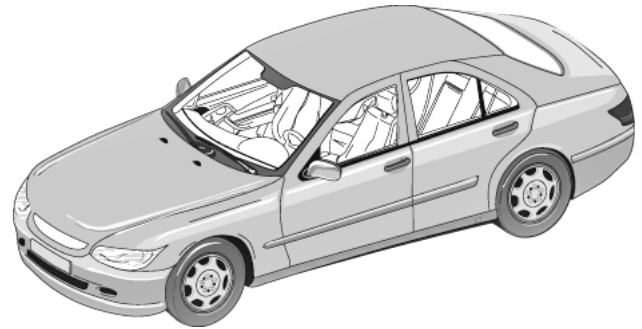
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4. Clearcoat application

| | | | | |
|--|--|--|---|---|
| <p>923- Glasurit® Clear VOC</p> |  <p>Refer to the technical data sheet</p> |  <p>HVLP 1.3-1.4 mm 2.0 bar</p> |  <p>2 spraycoats</p> |  <p>30 min. at 60 °C</p> |
|--|--|--|---|---|



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