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TECH TIPS

SOLVENTBORNE BLENDING REPAIR TECHNIQUES

FOLLOW THESE BEST PRACTICES TO ACHIVE EXCELLENT BLENDING RESULTS IN SOLVENTBORNE REFINISH REPAIR:

- 1. Final sand the repaired area where the blended color will be applied**
 - Use a guide coat over primer surface
 - Hand block with P320 grit sheet; Finish with P600 grit or DA sand using a finishing DA with an interface pad with P400 grit
 - Finish with P600 grit if primer sealer will **NOT** be used
 - Sand just beyond the primer surface area
- 2. Sand the remainder of the panels**
 - DA sand using an interface pad with P600-800 grit or hand sand with gray or gold scuff pad and **DX101** Sanding Paste
 - Hand sand all edges and areas where a DA will not fit with a gray or gold scuff pad
 - Sand area to be cleared with 1000-1200 grit. Sand all the way to the ends of the panels where clearcoat is to be applied
- 3. Clean all panels**
 - Blow away sanding dust while wiping with a clean cloth
 - Thoroughly wash off all traces of sanding paste with clean water; clean with **DX330** Wax & Grease Remover
 - Tack off all panels
- 4. Apply approved Primer Sealer such as DAS3055 (gray)**
 - Use G-Series shades of gray sealer recommended for the basecoat color (optional if shades of gray surface is used and no bare metal is exposed)
 - Apply sufficient material to cover the entire primer surface area
- 5. Apply basecoat color**
 - Use **DBC500** when blending out basecoat colors. First, spray a coat of color blender onto the area out beyond where the basecoat is to be applied.
 - Apply the number of color coats as indicated by the sprayout card. Step out each color coat further than the previous one for an invisible blend. Reduced **DBC500** may be mixed with the ready-to-spray color for stepping out the blend edge.
 - Allow 15-20 minutes flash time at 70 deg before clearcoating with appropriate **PPG** clear.
 - Lightly tack off all panels after sufficient flash time.
- 6. Apply clearcoat**
 - Apply first coat to cover basecoat color area
 - Apply final coat to the ends of all panels
 - Partial panel clearcoating is not recommended