

Urethane Cross-Coat Spray Out



Step 1 | Mix

- Mix and reduce color on the scale
- Select the appropriate components based on temperature and size of the job

Step 2 | Spray Gun

- Choose the appropriate spray gun setup and air pressure based on TDS and Spray Gun SOP
- Check spray pattern on paper to ensure spray gun is functioning properly

Step 3 | Spray Out Panel

- Prepare three spray out panels
- Select the appropriate spray out panel, M-5987 is best practice
- Clean the panel and apply a check-hiding sticker
- Attach spray out card to an easel and replicate spraying a vehicle

Step 4 | 1st Spray Out Panel (Lower PSI)

- Set spray gun PSI at recommended pressure 24-25
- Apply one even closed coat on the panel spraying 6-10 inches from the panel with a 50-60% overlap
- Spray the same way you would spray the vehicle. The first coat should be sprayed up and down or vertical pattern (commonly referred to as "north and south")

Step 5 | Apply 2nd Coat of Color (Lower PSI)

- Allow a 30 second to 5 minute flash
- Apply the 2nd coat much like the first with increased gun distance 14 inches
- Spray should be a side to side or horizontal pattern (commonly referred to as "east and west")

Step 6 | 2nd Spray Out Panel (Increased PSI)

- Increase spray gun PSI to 29-30 pounds
- Repeat steps 4 and 5

Step 7 | 3rd Spray Out Panel (Maximum PSI)

- Increase spray gun PSI to 34-35 pounds NOTE: Refer to spray gun manufacturer recommendations to avoid a split pattern
- Repeat steps 4 and 5
- If spraying EY quality, prepare and spray additional spray outs adding 359S to the mix

Step 8 | 5S (Sort, Straighten, Shine, Standardize, and Sustain)

- Clean and return all items back to their proper place