



**IMRON®**

# Single-stage Topcoat Application

## Step 1 | Quality Control

- Ensure the repair is ready for topcoat
- Verify the color is correct by comparing the spray out to the vehicle. See Spray Out SOP

## Step 2 | Mix

- Mix topcoat on ColorNet® scale after determining the amount needed to avoid waste
- Use appropriate components based on temperature, humidity, air movement, and size of repair per TDS

## Step 3 | Spray Gun

- Select the appropriate spray gun based on Spray Gun SOP
- Adjust the air pressure at the wall, and make micro adjustments at the gun
- Check spray pattern on paper to ensure it is functioning properly

## Step 4 | Clean

- Thoroughly clean surface as per Surface Cleaning SOP
- Properly blow and tack off panels to be topcoated

## Step 5 | Apply 1<sup>st</sup> Coat

- Apply topcoat according to the TDS recommendations
- Pay special attention to gun distance, use 50-60% overlap and gun speed of approximately 3 feet per second
- Apply the first coat in an up and down or vertical pattern (commonly referred to as "north and south")

## Step 6 | Apply 2<sup>nd</sup> Coat

- Within 30 seconds to 5 minutes apply the 2nd coat in a side to side or horizontal pattern (commonly referred to as "east and west") using the same spray technique, according to the TDS recommendations. NOTE: Medium to large panels can be coated back-to-back. High metallics may require a little longer flash. Pay special attention to overlap areas to avoid excess application

## Step 7 | 5S (Sort, Straighten, Shine, Standardize, and Sustain)

- Clean spray gun
- Dispose of waste according to local environmental regulations
- Return all items to their proper place