

Basecoat Blending



Step 1 | Quality Control

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

Step 2 | Mix

- Mix basecoat 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 the TDS information
- 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 | Blending Color

- If blending of basecoat is necessary, a wet bed can be applied prior to basecoat application. Refer to TDS for mixing & application of 8401EW Quality, to make a transparent blending wet bed. Spray the wet bed beyond the blend area or to the end of the panel. After blending color within the wet bed, apply clearcoat to the end of the panel for best results.

Step 6 | Apply 1st Coat

- Apply basecoat according to the TDS recommendations
- Pay special attention gun distance, use 50-75% 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"). Using a small wrist role taper the edge of the basecoat.

Step 7 | Apply 2nd Coat

- Within 30 seconds to 5 minutes apply a larger area of basecoat in a side to side or horizontal pattern (commonly referred to as "east and west") using the same spray technique, use a small wrist role to taper the edge of basecoat according to the TDS recommendations
- NOTE: Medium to large panels can be coated back-to-back

Step 8 | 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