



IMRON®

Clearcoat Application

Step 1 | Apply Basecoat

- Apply basecoat and blend per Basecoat Application SOP

Step 2 | Mix Clearcoat

- Mix and reduce clearcoat on the scale
- Choose activator and accelerator combinations based on air flow, size of job, and temperature
- Determine amount needed using the Heavy Duty Truck volume calculator

Step 3 | Choose Spray Gun

- Choose the correct spray gun and setup based on the TDS information, temperature, and air flow

Step 4 | Apply 1st Coat

- Apply the first closed coat of clearcoat wet to the repair area using a top to bottom or vertical application (commonly referred to as "north and south")
- Flash per TDS dry time recommendations, generally, 30 seconds to 5 minutes

Step 5 | Apply 2nd Coat

- Apply the second coat of clearcoat medium-wet to the entire area using a side to side or horizontal application (commonly referred to as "east and west")
- Follow TDS dry time recommendations
- Note: Blending clearcoat within a panel is not a warranted procedure

Step 6 | Overlap Areas

- To prevent over application, stagger overlap areas of adjoining panels

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