Blending Process – Blending Process for Light Shade Solid Colours

Technical Process Bulletin

April 2019

INTERNATIONAL MASTER FOR PROFESSIONAL USE ONLY

Technical Information

General Process Notes

DESCRIPTION:

New solid light shade colours are becoming ever more popular in the markets. Repairs requiring a blend process can be difficult – sometimes resulting in a halo around the repair or surrounding blend-in area (this halo is particularly visible in bright sunlight).

Colours in the light solid grey colour space are more likely to show this defect and it can be difficult to achieve an acceptable appearance in the blend area.

WHY DOES THIS HAPPEN?

In most cases this phenomenon is related to pigment flotation due to different densities of the toners used. Light shade colours will contain higher amounts of white toner in the formulation. Throughout the toner system, there is a difference in between the density of white toner versus the other toners from the range of the mixing scheme. The biggest difference is seen in the density of the black toners versus white (blacks are the lightest).

If full, thicker wet coats of basecoat are sprayed then a lot of movement is possible across the layer - allowing pigment migration. If a light coat is applied eg. like on the blending area then less space for pigment migration. This can result in the lighter, halo like appearance on the blended area. Due to that perception of the final colour can be related to the film thickness of the colour coat.

PROCEDURES:

The following processes and guidelines is for blending of Light Shade Solid Colours sprayed with AQUABASE® Plus Basecoat.

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Products and Process

PREPARATION:

Thoroughly wash surface to be prepared with soap and water.
Clean all areas with P850-14/1402 Spirit Wipe Pre-cleaner.
Thoroughly sand using an abrasive appropriate for blending process.
Blow off and re-clean with P980-8252 Aquabase Plus Precleaner.
CAUTION: Do not sand through the OEM topcoat during preparation if possible.

For the Light Shade Solid Colours Blending Process following products are needed:

- Ready Mixed Colour P989-
- Performance Blender P935-1450
- Aquabase Plus Thinner P980-5000 or P980-5050
- Optional: P935-1250 Performance Additive

Product preparation:

1. Mix the appropriate colour formula –
2. Thin the readymix 20% with P980-5000 or P980-5050. ***NOTE:** A STD thinning combination with P935-1250 can also be used.
3. Prepare P935-1450 in a separate spraygun or any dispenser system for sprayguns. (P935-1450 is ready for use in can).
4. For large area blend and very critical colours prepare a RFU mix – 100:100 (diluted colour (RDM) P935-1450). This mix is to be used as last fade out and control coat in blend area.
5. For application in high temperatures and low humidity, it can benefit to bring the viscosity of P935-1450 down to 25 sec. Mixing Ratio: 100:5 (P935-1450/P980-5000 or 5050)

Process

1. Apply P935-1450 in 1½-2 coats (has to be wetted up) in the area to be blended. The blend bed has to be applied as a wet layer to enable the pigments to get the correct lay-down.
2. Apply 1 coat one thin control/effect coat in the repair area, followed by STD blend in process to opacity. Avoid heavy layers. Blend the fade-out area as smooth as possible. End the process with a light control coat in the blend area.

   2a. For large area blends and very critical colours use the 1:1 RFU mix to blend the fade-out area as smooth as possible followed by a light control coat.

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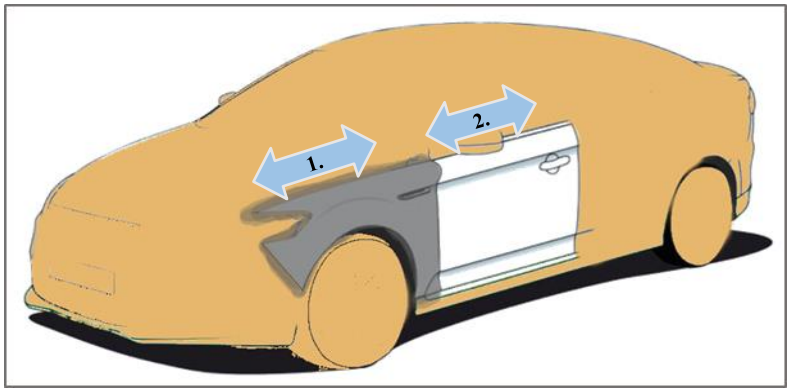
1. **Repaired or new panel**

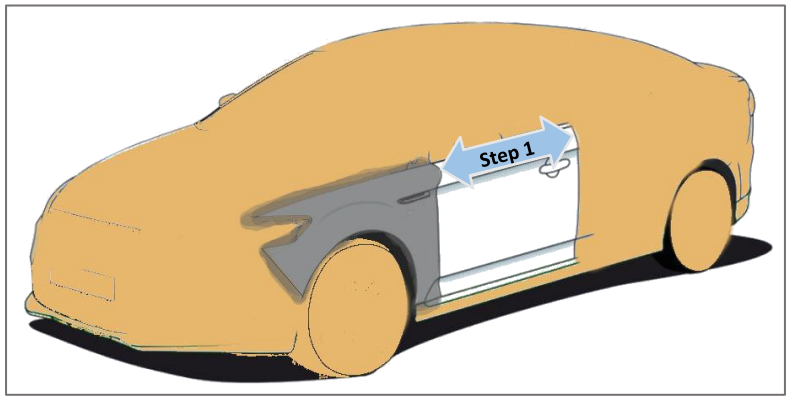
2. **Adjacent blend panel**



STEP 1:
Blend Bed Adjuster

1. Apply P935-1450 as a wet coat in blend/fade-out area.

(The wet bed will allow the correct pigment lay down in the blend area)

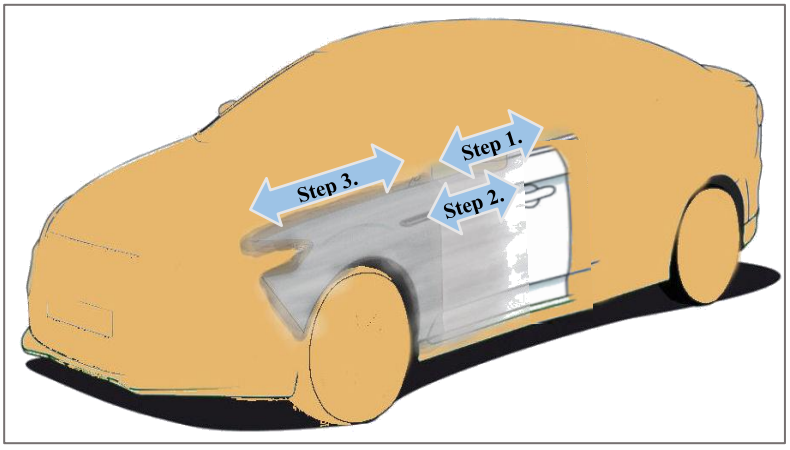


STEP 2
WBBC Colour RFU

1. Apply a light coat into the wet bed.

2. Apply STD blend process into the wet bed. Blend/fading-out as smooth as possible. End the blend process with a light control coat on blend area.

2a.*For very critical use RFU mix –100:100 (RDM+ P935-1450) This mix is to be used a last fade out and control coat in blend area.



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Equipment

This process works very well with most types of sprayguns

- 1.2 mm RP
- 1.3 mm HVLP
- 1.2 mm Mini/Small Repair sprayguns

For spraygun set ups please refer to the relevant manufacture.

NOTICE:
When choosing a spraygun, take into the consideration the repair type (adjacent panel or spot repair).

For spot repairs and spots in the middle of a panel a mini jet/small repair spraygun is strongly recommended to be used.

These products are for professional use only, and are not to be used for purposes other than those specified. The information on this TDS is based on present scientific and technical knowledge, and it is the responsibility of the user to take all necessary steps in order to ensure the suitability of the product for the intended purpose.

For Health and Safety information please refer to the material Safety Data Sheet, also available at: **www.nexaautocolor.com**

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