



GLOBAL REFINISH  
SYSTEM



April 2019

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# Process Information

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## Blending Process for Light Shade Solid Colours

### Application Process



### PRODUCTS

ENVIROBASE® HP Ready Mixed Colour      T4xx

Process also requires :-

High Performance Blender	T4903
Envirobase High Performance Thinner	T494/T495
<i>Performance Additive (optional)</i>	T492

### 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 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 and oxide 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. 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 process and guidelines is for blending of Light Shade Solid Colours sprayed with Envirobase High Performance basecoat.

# PROCESS DESCRIPTION

## Preparation:

Thoroughly wash surface to be prepared with soap and water.

Clean all areas with D837 Spirit Wipe Pre-cleaner.

Thoroughly sand using an abrasive appropriate for blending process.

Blow off and re-clean with D8401 Waterborne low VOC Cleaner.

**CAUTION: Do not sand through the OEM topcoat during preparation if possible.**

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

- Ready Mixed Colour T4XX/ENVHP
- High Performance Blender T4903
- Envirobase High Performance Thinner T494 or T495
- Optional: T492 Performance Additive

## Product Preparation:

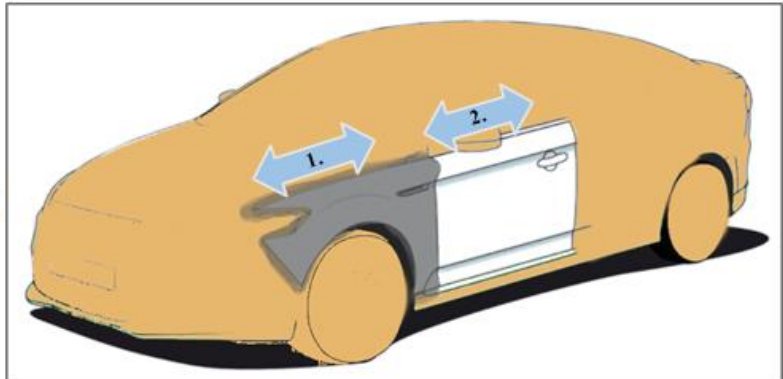
1. Mix the appropriate colour formula –
2. Thin the readymix 20% with T494 or T495 **\*NOTE: A STD thinning combination with T492 can also be used.**
3. Prepare T4903 in a separate spraygun or any dispenser system for sprayguns. (T4903 is ready for use in can).
4. For large area blend and very critical colours prepare a RFU mix – 100:100 (diluted colour (RDM) +T4903). This mix is to be used a last fade out and control coat in blend area.
5. For application in high temperature and low humidity, it can benefit to bring the viscosity on T4903 down to 25 sec. Mixing Ratio: 100:5 (T4903/T494 or T495).

## Application Process

1. Apply T4903 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.
  - a. 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.

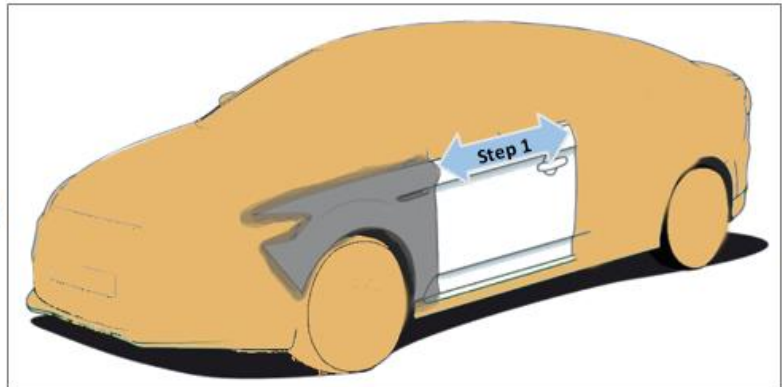


1. Repaired or new panel
2. Adjacent blend panel

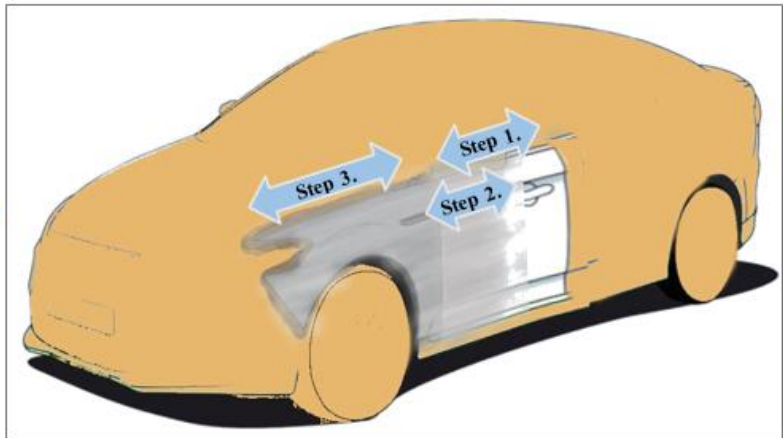


**STEP 1:**  
**Blend Bed Adjuster**  
 1. Apply T4903 as a wet coat in blend/fade-out area.

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



**STEP 2**  
**WBBC Color 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+ T4903) This mix is to be used a last fade out and control coat in blend area.



## Spraygun Set-up/Equipment

Recommended Spraygun Set-up:

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

For spraygun set ups please refer to the relevant manufacturer.

### 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.

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## VOC INFORMATION

The EU limit value for this product (product category: IIB.d) in ready to use form is max. 420g/litre of VOC. The VOC content of this product in ready to use form is max. 420g/litre.

Depending on the chosen mode of use, the actual ready to use VOC of this product may be lower than that specified by the EU Directive code.

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## HEALTH AND SAFETY

**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.ppgrefinish.com](http://www.ppgrefinish.com)

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