



SYSTEM INFORMATION

Blending in on the adjacent panel with Glasurit 90 Line tri-coat colors (translucent step 2)
Mazda 46V Soul Red Crystal Met.

This service mixing formula is recommended to be used in conjunction with this blending process, listed below.

With all translucent colors there is the need to verify the amounts of spray coats needed for each color match for each vehicle. Therefore, and due to differences in application techniques we recommend to apply different amounts of spray coats of Step 2 (translucent coat) to test panels of Step 1 to match the process and color of the vehicle to be repaired.

This process provides paint material and time saving advantages:

- Easier and safer blending process
- Do not use Glasurit Blending Clear 90-M50 or 90-M5.

Service Formula 1	
Mazda 46V	Step 1
90-M4	63.14
93-M363	16.15
90-M99/01	1.76
90-3A0	11.75
90-A347	7.20
Mazda 46V	Step 2
90-M4	4.08
90-M5	89.91
90-3A0	6.01

Recommendation:

Service formula 1 usually only needs 2½ coats of Step 2.

Please check color and application first on test panels before applying to the vehicle.

Please refer to the following Blending Process:

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Blending in on the adjacent panel with Glasurit 90 Line tri-coat colors (translucent step 2) Mazda 46V Soul Red Crystal Met.

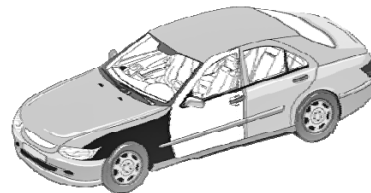
Properties: In principle, panel repairs with translucent 90 Line tri-coat colors are possible. Therefore, it is in general not necessary to respray adjacent body parts. But when color differences beyond allowable limits are to be expected, the more appropriate method to balance color differences may be to blend into the damaged area and/or the adjacent panel, depending on the damage. This procedure can be considerably more efficient and economical than time-consuming color matching.

- Remarks:**
- Stick to the recommended flash-off times.
 - Flash off after each spray coat until the surface is completely mat.
 - Flash-off times can be reduced by additional ventilation with blow equipment (e.g. Dry Jet).
 - Brief increase of temperature in combined spray booths or by intermediate drying at 40°C in the oven after the final coat.
 - An increasing basecoat thickness needs more flash-off time.

Final sanding of the filler surfacer with orbital sander, not coarser than P500, and not finer than P1000.

1. Pre-treatment of the adjacent panel

700-10 Glasurit® Degreasing and cleansing agent	 1x	 Wipe dry	 Foam pad P1000-P1200
700-1 Glasurit® Cleaner	 1x	 Wipe dry	



Mask the adjacent blending panel if necessary.

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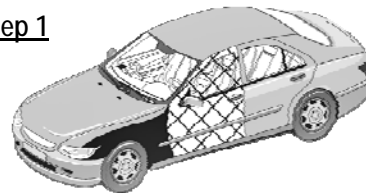


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2. Refinishing of the new panel / the panel to be repaired Step 1

90 Line Glasurit® Basecoat Step 1 Mazda 46V	 2:1 93-E3	 HVLP 1.3 mm 2.0 bar	 2 (spray to cover) + ½ coat to match the effect.
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Notes:

Demask the adjacent panel, after the last spray coat has dried.

Using Step 1 fade out and overlap each spray coat into the adjacent panel.

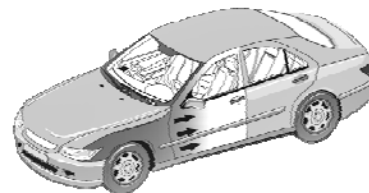
Keep the blend small and keep the edge transition soft and gradual.

Maximum pressure 1.5 bar when blending out.

Blending agent 90-M50 is not needed for this process.

2.1 Refinishing of the Blend transition area into the adjacent panel Step 1

90 Line Glasurit® Basecoat Step 1 Mazda 46V	 2:1 93-E3	 HVLP 1.3 mm 1.0-1.5 bar	 1 – 2 fading out on both panels	 ½ coat to match the effect	 flash off until mat
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Note:

Reduce spray gun pressure when blending.

After Step 1 has dried, use tack rack on the blended panel to remove any loose over spray

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3. Refinishing of the new panel / the panel to be repaired and of the adjacent panel Step 2

90 Line Glasurit® Basecoat Step 2 Mazda 46V	 2:1 93-E3	 HVLP 1.3 mm 2.0 bar	 2.0 bar on repaired panel. 1.5 bar effect coat	 1-2 + ½ to match the effect	 flash off until mat
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Note:

Fade out and overlap each spray coat into the adjacent panel.
Reduce pressure when blending into adjacent panel if needed,

Apply the ½ coat to match the effect over the repaired area with reduced pressure of 1.5 bar.
Apply staggered overlaps to produce consistent basecoat finish.

4. Clearcoat application

923- Glasurit® HS VOC Clearcoat	 Refer to the Technical Data Sheet	 HVLP 1.3 mm 2.0 bar	 2	 30 min. at 60°C
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Safety advice:

The products are suitable for professional use only.
It cannot be ruled out that these products contain particles < 0.1 µm.

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