

Blending method

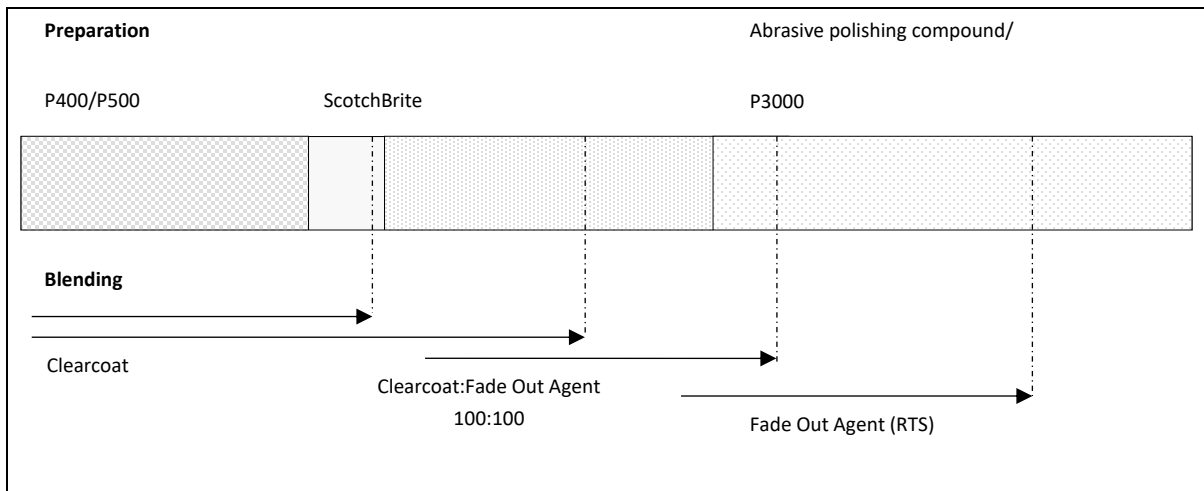
Technical Bulletin

09/11/2019

L8.01.01 UK & Ireland

DESCRIPTION

The term spot repair and blending is understood to include all repairs of damaged areas resulting in an invisible repair or blend into the still intact existing OEM finish. As a result, the car refinisher is not compelled to spray complete panels in the instance of minor damage. The application method and technique described below is appropriate for spots and blends with all Lesonal topcoats and clearcoats.



BLEND AREA PREPARATION



Thoroughly polish the blending area with an abrasive polishing compound, preferably in combination with a polishing machine.

Optional: the blend area can be treated with very fine abrasive like P3000 or comparable



Remove contamination with an appropriate surface cleaner.

ensure it is thoroughly cleaned and wiped dry with high performance surface cleaning cloths.

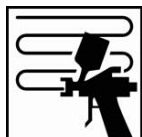
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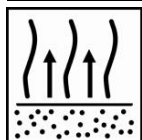
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BLENDING APPLICATION

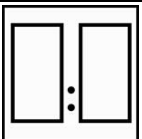


Apply topcoat/clearcoat according TDS recommendation

Extend the 2nd coat beyond the 1st coat



Respect flash-off times according TDS at 20°C

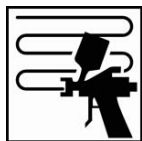


100 Topcoat / clearcoat

100 Fade Out Agent / Thinner Fade Out

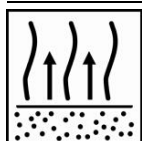
Extra thinned material creates a lower spray viscosity.

Apply the following blending steps using a reduced application pressure.

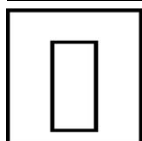


Apply one full flowing coat over the blend area, slightly fading into the polished area.

Optional: fade into the area treated with P3000.



Approximately 15-30 seconds at 20°C



Fade Out Agent (RTS)

Thinner Fade Out (RTS)



Apply 1-3 thin coats on the blending area, extending forward into the polished area.

Allow for approximately 15-30 seconds flash off time between layers.

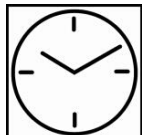
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DRYING



Drying of the topcoat / clearcoat according product TDS recommendations.

Let the object cool down to ambient temperature prior to polishing



Additional drying by infra-red will secure optimum through hardening in the blend area.

*For additional infrared drying information; see TDS L9.01.01 InfraRed Curing.
Let the object cool down to ambient temperature prior to polishing*

POLISHING OF THE BLENDED AREA



Polish the blended area by hand or machine using a fine polishing compound.
Use coarser polishing compound in case more effort is needed.

*Polishing by machine using a soft compounding pad at low rotation speed.
Use a hard pad in case more effort is needed.*

SUITABLE PRODUCTS

Fade Out Agent/Thinner Fade Out can be use in all Lesonal topcoats and clearcoats

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