



SPECIAL BASECOAT BLENDING PROCEDURES



GENERAL

Extra attention and some special techniques may be required to blend difficult colors into each other. The techniques below can be used for solid colors, metallics, pearls, and even tri-coats. These blending recommendations are fast, easy and durable. There should be no impact on productivity, since the application is fast, with no extra flash time required. These techniques keep a painter from having to work excessively hard to get an acceptable blend edge and color match.

The products referenced herein may not be sold in your market. Please consult your distributor for product availability.

OPTION 1

- Activate and reduce ChromaBase® Basecoat and ChromaPremier® Basecoat color per recommendations, substituting 69301S™ Basecoat Blender for the suggested Basemaker.
- Blend as usual, spraying to hiding over the repair area and 2-3 coats gradually blended out past the repair area. Lower air pressure usually helps blending.

OPTION 2 PREFERRED METHOD (FOR DIFFICULT-TO-BLEND COLORS)

- Prior to the repair, prepare a "blender add" by mixing 1:1, 69301S™ Basecoat Blender and 175K™ Basecoat Binder (for ChromaBase®) or 62330F™ Basecoat Balancer (for ChromaPremier®).
- Reduce and activate ChromaBase® Basecoat or ChromaPremier® Basecoat, substituting 69301S™ Basecoat Blender for the suggested Basemaker.
- Spray to hiding over the repair area.
- Add equal amounts of prepared "blender add" to the remaining reduced paint, mix well and apply 2-3 coats blended out past the repair area.

Tips for Success

- Application equipment does have an impact on the results. On tough blends, use a narrow fan, reduced fluid flow and reduced atomizing air pressure just high enough to give sufficient breakup. Gravity and HVLP equipment usually perform better than siphon.
- For optimum results, use smaller fluid tips (1.5 mm or smaller) set to the lowest air pressure that still gives good atomization.
- Agitate ready-to-spray paint thoroughly, especially high metallics and pearls, and be sure to spray immediately after loading the gun. Do not allow paint to settle in the gun cup. Stir paint again between coats if necessary.
- Apply base color over properly prepared surfaces, and be sure to allow ample flash time between coats.
- The base color should dry to a dull finish before application of ChromaClear® or ChromaPremier® clearcoat.

Revised: May 2013

In the United States:
1.855.6.AXALTA
cromax.us

In Canada:
1.800.668.6945
cromax.ca

