



STANDARD OPERATING PROCEDURE

**Blending Solid & Metallic Colors**

**Application with No Mix® HS & MS Basecoat**

Inspect	1	Inspect vehicle & blend area for proper preparation (priming, sanding, masking, cleanliness). For detail on prep & sanding, see Transtar SOP 051. For Steel Finishing, see SOP 111. For plastic finishing, see SOP 251/2.	
		To assure that a blendable color match has been achieved create a sprayout card. For Color Selection & Matching, see Transtar SOP 501.	
Mix	2	Mix the basecoat color using No Mix PLUS software & scale. Assure a blendable color match is achieved. Always mix with Basecoat Activator.	
		<b>Important:</b> Use only No Mix components & Transtar Reducer for proper weight & color consistency.	
Clean	3	Blow off vehicle. Clean panel(s) with waterborne degreaser, Aqua SCAT 2 #1394.	
Seal	4	Tack off vehicle. Apply sealer if necessary. For improved hiding, select proper Star Shade value. Follow Transtar TDS for sealer. Allow proper flash time.	
Basecoat	5	Tack off. Apply No Mix Basecoat Blender, #LV-500. Spray 1 medium wet coat as a wet-bed over blend panel. Allow 10-15 minute flash before application of basecoat.	
	6	Tack off. Apply No Mix basecoat 2-3 coats or until hiding is achieved. Extend each coat slightly beyond previous coat into blend area/panel. Allow proper flash times. Tack off between coats.	
Mix	7	Mix LV500 1:1 with RTS No Mix basecoat color.	
Blend	8	Apply 1-2 medium wet coats of 1:1 LV500/RTS No Mix over the entire basecoated area. Extend application slightly beyond into blend area /panel.	
Inspect	9	Inspect blend. Turn lights off in booth to check blend with a single light source. Assure proper coverage & blend looks acceptable. If blend is visible, continue to blend color.	
Dry		Allow basecoat to dry 15-20 minutes before application of clearcoat. Dry times may vary due to shop temperature & reducer selection. Recoat time of activated basecoat is 2 hours @ 77°F.	
Mix	10	Mix clearcoat according to Transtar TDS. On plastic substrates, mix clearcoat with Flex Additive, #9194, per TDS.	
Clear		<b><u>Clearcoat Entire Panel whenever possible.</u></b>	<b><u>Clearcoat Blend for economical repairs.</u></b>
	11	Tack off vehicle. Apply 2-3 coats of clearcoat per Transtar TDS.	11 Tack off. Apply 1st coat of clear per TDS stopping 3" short of sanded edge in blend area.
		Assure minimum dry film thickness of 2 mils after sanding & buffing.	12 Apply 2nd coat of clear 3" past where 1st coat stopped. Cover sand scratches & first coat of overspray.
			13 If necessary, apply 3rd coat of clear 3" past where 2nd coat stopped.
Blend			Assure minimum dry film thickness of 2 mils after sanding & buffing.
			14 If necessary (based on blend area/edge), <i>immediately</i> after last coat of clear, apply Melt Away Edge Blender #6363. Maintain 12-14" distance from panel. Apply 1-2 coats in light sweeping motion along blend edge.

- For Paint Defect Removal, see SOP 817. • For Blending Tri-Coats, see SOP 514.
- Refer to OEM recommendations for repair & refinish as some manufacturers have specific procedures for warranty repairs.

**SUGGESTED MATERIALS FOR JOB**

- Sprayout card • Transtar Waterborne degreaser, #1394 • Lint-free Towels • Masking materials • Tack rags • Transtar Sealer
- Transtar No Mix Basecoat • Transtar Basecoat Activator • Transtar Reducer • Transtar No Mix Basecoat Blender, #LV-500
- Transtar Clearcoat • Transtar Melt Away Edge Blender, #6363

\* Always refer to Transtar Technical Data Sheet (TDS) for specific product application, suitable substrates & other product information.