



STANDARD OPERATING PROCEDURE

Blending Tri-Coats

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 blendable color match has been achieved, create a letdown panel. For Color Selection & Matching, see Transtar SOP 501.	
Clean	2	Blow off vehicle. Clean panel(s) with waterborne degreaser, Aqua SCAT 2 #1394.	
Seal	3	Tack off vehicle. Apply sealer if necessary. For improved hiding, select proper Star Shade value. Follow Transtar TDS for sealer. Allow proper flash time.	
Mix	4	Mix the <i>Groundcoat</i> color using No Mix PLUS software & scale. Always mix with Transtar Basecoat Activator.	
		Important: Use only No Mix components & Transtar Reducer for proper weight & color consistency.	
Blend	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 groundcoat.	
Groundcoat	6	Tack off. Apply No Mix Groundcoat 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.	
	7	Inspect blend. Turn lights off in booth to check coverage with a single light source. Assure proper coverage & blend looks acceptable. If coverage is not acceptable, apply additional groundcoat.	
	8	Mix LV500 1:1 with RTS No Mix Groundcoat color.	
	9	Apply 1 medium wet coats of 1:1 LV500/RTS No Mix Groundcoat over the entire basecoated area. Extend application slightly beyond into blend area /panel.	
Mix	10	Mix the <i>Midcoat</i> using No Mix PLUS software & scale. Refer to letdown panel for number of coats of midcoat to apply.	
Midcoat	11	Tack off. Apply <i>Midcoat</i> over the Groundcoat & beyond using blend technique. Apply single coats until color match is achieved - as determined by letdown panel. On a spot repair keep midcoat application within ground coat application to produce an invisible repair. Allow 10-15 minutes between midcoat applications.	
	12	Mix LV500 1:1 with RTS No Mix Midcoat.	
Blend	13	Apply 1 medium wet coat of 1:1 LV500/RTS No Mix Midcoat over the entire basecoated area. Extend application slightly beyond into blend area /panel.	
Inspect	14	Inspect blend. Assure blend looks acceptable. Turn lights off in booth to check blend with a single light source.	
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	15	Mix clearcoat according to Transtar TDS. On plastic substrates, mix clearcoat with Flex Additive, #9194, per TDS.	
Clear		<u>Clearcoat Entire Panel whenever possible.</u>	<u>Clearcoat Blend for economical repairs.</u>
	16	Tack off vehicle. Apply 2-3 coats of clearcoat per Technical Data Sheet.	16 Allow proper flash time of basecoat. Tack off. Apply 1st coat of clear stopping 3" short of sanded edge in blend area.
		Assure a minimum dry film thickness of 2 mils after sanding & buffing.	17 Apply 2nd coat of clear 3" past where 1st coat stopped. Cover sand scratches & first coat of overspray.
			18 If necessary, apply 3rd coat of clear 3" past where 2nd coat stopped. Assure a minimum dry film thickness of 2 mils after sanding & buffing.
Blend		19 If necessary (based on blend area/edge), immediately 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 Solids & Metallics, see SOP 513. • For Color Selection & Matching, see SOP 501.
- Refer to OEM recommendations for repair & refinish as some manufacturers have specific procedures for warranty repairs.

SUGGESTED MATERIALS FOR JOB

- Sprayout card /Letdown panel • 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.