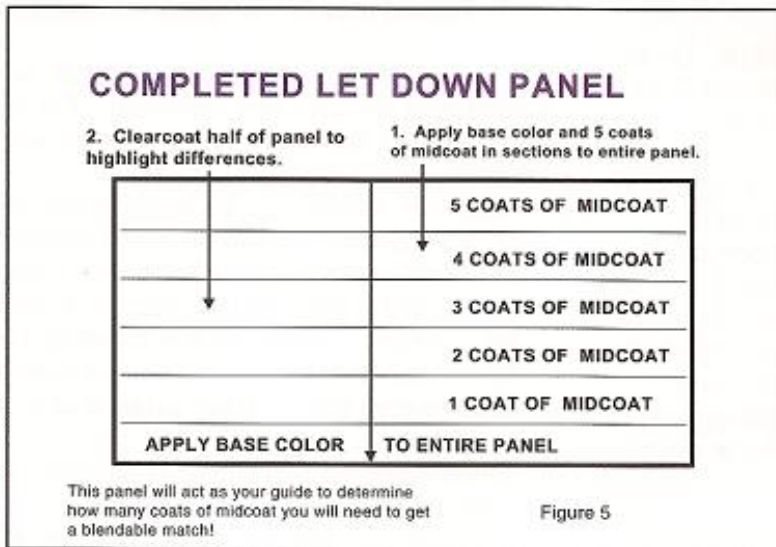


Understanding Tri-coats

When painting candies, pearls or tri-coats the number one thing to remember is that the more coat that you put down, the darker the color will become. Unlike a regular basecoat color, once that you achieve hiding the color will not change. With Tri-coats you have a base coat, a midcoat (which causes the effect-candy, pearl, etc) and a clear coat. In order to match or blend we must first build a let down panel in order to see exactly how many midcoats that we are going to need.

Building a Let Down Panel



Try to find an area on the vehicle that does not have midcoat and clearcoat. Such as in the trunk floor, under hood, radiator supports, inner fenders, etc. Spray an test panel with the basecoat and compare with this area to insure a starting matching color base. Tint the base if necessary.

Now mask off 1 section of basecoat, do not put midcoat over it. Then mask off 4 more sections of base color so that you can remove them one at a time while applying successive coats of midcoat color.

Mix and apply the midcoat over the panel, removing 1 section at a time so you end up having 5 coats of "midcoat over base" at the top of your let down panel and 1 coat of "midcoat over base" at the bottom.

Let your midcoats dry enough to mask, then mask off 1/2 the panel vertically and clear 1/2 the panel. You now have a way to determine how many midcoats will be needed for that vehicle.

Every painter has a different overlap, a different speed and a different gun with different atomization. That is why a Let Down panel must be made.

We now compare the panel to the car and choose the section that gives us the best match. If we have a color that falls in between 2 sections, for example 3 1/2 coats. We can then adjust the last coat. We mix a partial midcoat by using a color blender, DBC500. For the 4th coat we would mix 1 part ready to spray midcoat with 1 part DBC500 color blender. This will give us a 1/2 strength midcoat. For example 6 ounces of ready to spray midcoat with 6 ounces of DBC500 color blender.

Tri-coat Spot Repair: Door Damage

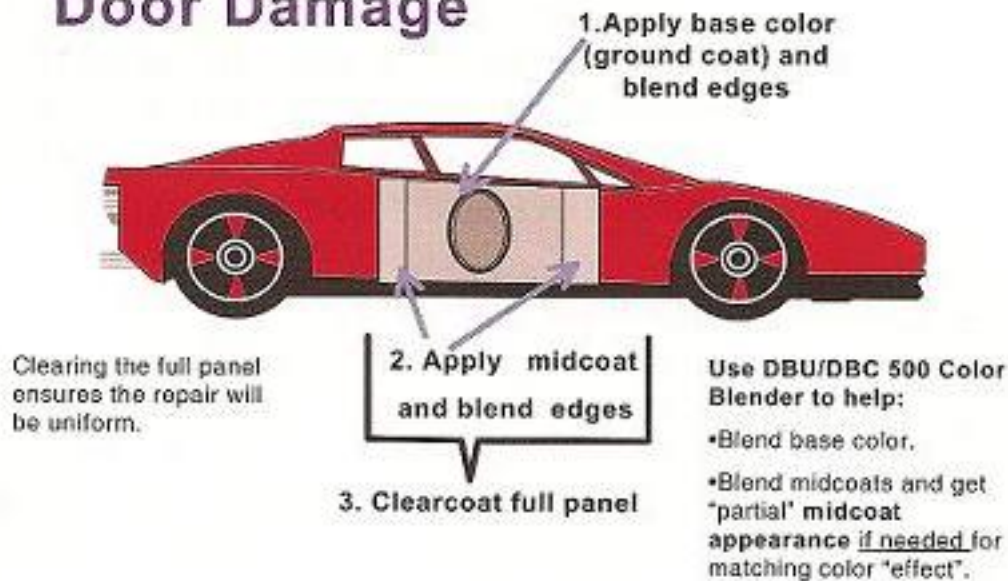


Figure 6

CAUTIONS:

1. Keep the repair as small as possible, these jobs can become large very easily.
2. Blend base color with the addition of color blenders (DBU/DBC 500, based on your chosen system). You can add up to 2 parts of reduced color blender to every 1 part of your ready-to-spray basecoat color. **2:1 ratio**
3. Use Step 2 when blending midcoats too. It actually applies to midcoats **even more so** than base color! **Any extra coats of full strength midcoat applied over the OEM tri-coat at the blend edge can show up as a dark halo or line!**
4. Use DX57 to provide extra strength when using the DBC Basecoat system. Add it to both base and midcoat color (*reference Technical Bulletin #TB-051 in the PPG Refinish Technical Information Manual*)

Tri-coat Panel Repair: Door Replaced

Don't forget
Color Blender
options in Step
1 & 2!

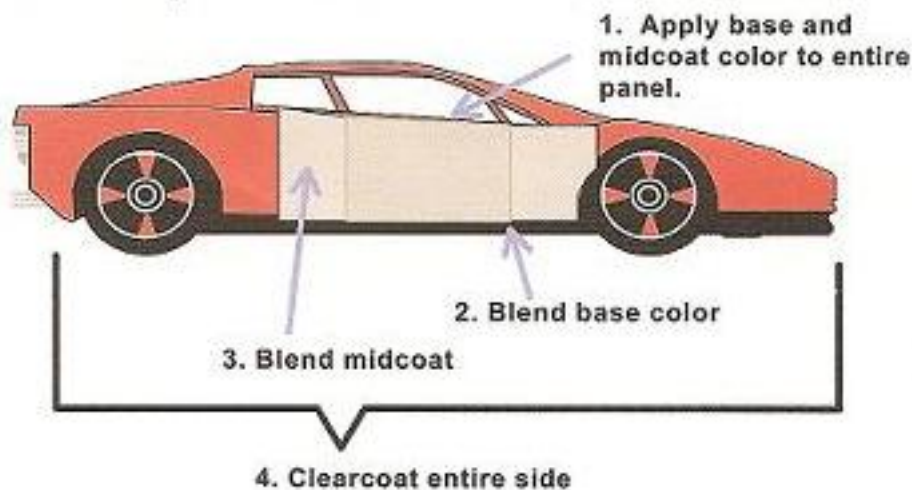


Figure 7

Keep the repair and blend areas as small as possible. One way to accomplish this is to use a **two gun method** for blending the repair. This method can be used for both base color and midcoat blend edges.

Example-Midcoat Blend:

- **Gun #1** contains regular RTS midcoat.
- **Gun #2** contains a mixture of RTS midcoat color **and** the appropriate RTS Color Blender to make it more translucent. *Take both guns into the booth and make sure they are within easy reach .*
- Use **Gun #1** to apply the regular midcoat to the **main repair area**. Keep the midcoat well within the repair area.
- Use **Gun #2** with the midcoat/Color Blender mix to **extend your midcoat blend edges!**

Final Step for any Tri-coat Repair:

Apply the chosen clear to the repair area following appropriate procedures.