

## PS-0815: BLENDING POSITION STATEMENT

### Blending of Color:

When a color has been determined for a good blend match, there are many variables that can affect color perception. Technician application technique, experience, spray gun pressure, spray gun manufacturer and spray needle/nozzle setup, all create variables to alter the appearance of a color. Other factors that create challenge would be a previous repair, vehicle owner care of the paint finish, age of the vehicle and exposure to damaging UV rays. Additional challenges from OEM's are their panel styling and increase of special effect colors that add repair complexity.

**This document is a position statement for the blend application of color and clearcoat.**

#### Color blend recommendations:

- Two stage basecoat colors require a **minimum** of 18 inches (45cm) to blend
- Multistage basecoat, including translucent colors require a **minimum** of 24 inches (60m) to blend

After all color tool investigation, spray gun adjustment and application technique, and/or spray card samples do not provide a good blend match, then tinting / adjustment should be considered.

#### Blending of Clearcoat:

Blending clearcoat within a repair panel is not warranted by the PPG Limited Lifetime Guarantee.

PPG warranty requires full panel clear application to a panel edge separated by an adjacent panel or break point when refinishing. There can be failure where any type of color or topcoat clear blend stops before the end of a full panel and leaves an unprotected tapered color or topcoat clear edge. The topcoat clear must be applied fully to a panel edge or distinct break off point.

- Clearcoat blending performed to an internal area requires conversation of three parties. The customer, repair facility and insurance carrier. An expectation of a clearcoat blend performed in internal areas may be of different opinion of different vehicle owners.
- The final decision, based on the age of the vehicle, customer expectation and repair performed by a collision center to pre-accident conditions should be documented and agreed upon by all three parties. The variables of technician expertise, surface preparation and proper use of aftermarket materials to perform internal blends is subject to controversy. PPG guarantees clearcoat application with proper topcoat clear thickness of minimum 2 mils (50.8 microns). A blended clearcoat edge may compromise the minimum thickness and may not be warranted.

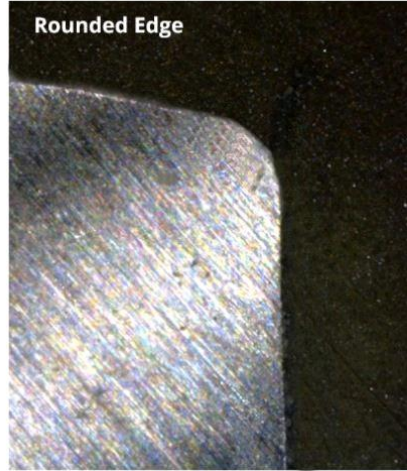
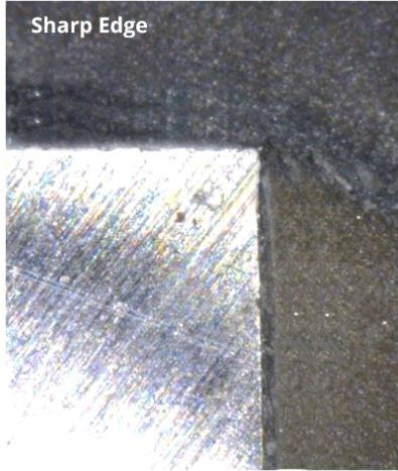
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- Proper mechanical adhesion is necessary before clear coat application onto existing OEM or aftermarket substrates.
- Clear film thickness of less than 2 mils can affect adhesion when performed on a rounded edge, concave or convex curved edge, or radius edge.
- PPG does have blend agents available to assist a technician if all parties agree on a non-warranted blended topcoat clear edge internally or externally.
- Review the visual examples of the construction of body panels with sharp edge, rounded edge, radius edge and panel edge.



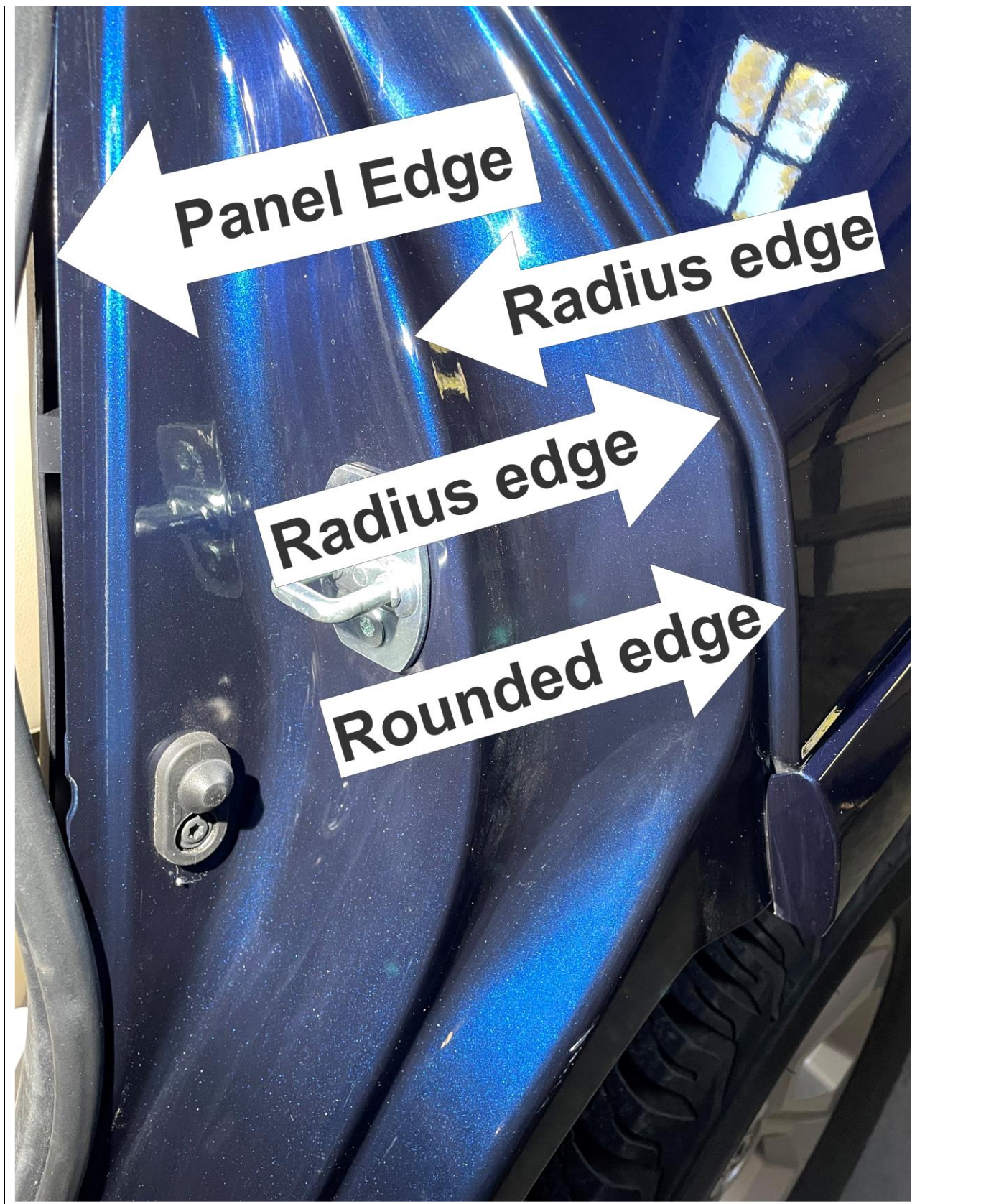
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## EDGE SAMPLES:





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