

The following Best Practices in the Mixing Room are designed to be a guideline of good shop habits that will help a shop reduce waste, save money, and ultimately provide the most consistent and best possible color match.

Waterborne Basecoat

Mixing Cabinet:

- Safely and securely anchor the cabinet to the wall. Two cabinets mounted side by side are a full 88" wide.
- The cabinet should be kept clean and free of all debris.

Toners:

- Store toners in a temperature controlled environment, and prevent them from freezing. The storage temperatures should be between 41°F - 105°F (5°C - 41°C).
- Prior to use, vigorously hand shake unopened toners. DO NOT place waterborne toners on a mechanical mixer or shaker.
- Rotate your stock and use older toners first. Record the date on the bottle when it's first opened for use.
- Keep pour spouts clean to insure contamination is minimal. The 'mouth' of the pour spout should be wiped off after each use to prevent toner build up.

Mixing Color:

- Use PPG approved plastic mixing cups or lined metal cans. An unlined can is **NOT** recommended when mixing waterborne color.
- Once your formula is mixed, reduce the color while it's on the scale. This will allow for accurate reduction and the toners will mix together more easily.
- Cleanly scrape the sides and bottom of the container before placing a lid on it. Hand shake thoroughly. Plastic or metal stir sticks can also be utilized. Do not place the mixed color on a mechanical mixer or shaker.
- Once the color has been reduced and thoroughly mixed, check the viscosity using the DIN4 cup. Ready-to-spray (RTS) viscosity should be 23 - 28 sec.

Solventborne Basecoat

Mixing Bank:

- Agitate toners for 30 minutes upon initial power up of the mixing bank. Cycle the bank at least 3 more times throughout the day for 15 minutes at a time to insure toners are kept well mixed.
- If any lubrication to the bank is required, use ***only*** castor oil or mineral oil to prevent contamination.
- For especially warm climates, keep the mix room as cool as possible to help prevent solvent loss in the toners. Once a toner loses too much solvent, it can become too concentrated and may compromise color match.

Toners:

- Store toner replacements upside down to avoid pigment settling. Rotate your stock regularly and use older toners first.
- Unopened toners should be placed on the shaker for 30 minutes before placing them on the bank.
- Record the date on the can when its first opened for use.
- PPG does not recommend pour offs. Toners should not be poured off into a smaller container for use.
- Check the cans. Damaged cans may not properly fit on the mixing bank or allow the mixing paddles to turn freely and agitate properly.
- Keep agitator lids clean to ensure an airtight seal. This will keep solvent loss and contamination to a minimum. The "mouth" of the mixing lid should be wiped off after each use.

Mixing Color:

- Mixing color in a metal can is recommended. Newly mixed color formulas should be placed on a shaker for 20 minutes especially when using powdered pearls. This will insure a uniform mix.
- Be careful when pouring toner into the mixing container. If paint lands on the chime of the rim on the container, it won't be part of the mix and color match may be affected.
- Mixing color in a metal can is recommended since the color should be put on a shaker prior to use to insure a uniform mix.

General Paint Mixing

- When tinting do not substitute toners. Only tint with toners that are in the formula.
- Use of a plastic cup on an ungrounded scale can lead to static charge build up and contribute to scale drift. In extreme cases of drifting, discontinue the use of plastic containers.
- Store mixing containers (cups, cans, etc.) upside down to prevent dust and dirt from collecting in the container before use.
- If you must leave the mixing area for a brief time, place a lid over your mix container to prevent contamination.
- When reducing products, do not “guess” the amount when you are mixing. It is highly recommended to use the PAINTMANAGER® Software systems and reduce products by weight for the most accurate mix. If not mixing by weight, use of a PPG mixing cup or mixing stick is recommended.
- Do not use a mixing stick in a container with tapered sides. This will cause inaccurate volume mixing.

Scales

- Sartorius scales need to be powered on for a period of 30 minutes warm up time. This is especially important with extreme climates changes.
- Keep the scale clean. Paint build up on the scale can cause the scale to improperly weigh material.
- Place the scale in a location with little air movement. Even the slightest draft can cause a variance during the mixing process.
- All scales should be electrically grounded to prevent static charge build up.
- Keep the scale level and insure the pan is on correctly and supports are not bent. If bent, remove and straighten.
- Keep the scale in an environment that does not experience “vibration” (such as near a compressor). Such an area will cause inaccuracies.
- Calibrate scale with provided manufacturer weights per manufacturer’s recommendations.

PaintManager Software System

- The refinish systems use high strength toners in small amounts. Breaking down formulas into too small of an amount may jeopardize color match. A “Minimum Mix” warning bar will display on the formula screen if this occurs.
- To receive formula updates:
 - Internet - Connecting the mix room computer to the internet affords monthly and sometimes daily updates to color formulas, new products and new software enhancements automatically.
 - Media - DVD media are released four times per year and contain updated color formulas, new products and new software enhancements.

TOUCHMIX® XI Computer System

- *TouchMix* XI Computer systems are an approved computer / touchscreen solution for placement inside mixing rooms. The system can be stand, pole or wall mounted for convenience.
- Store computer in a cool, dry area. Keep the filter in the back of the computer cabinet clean.
- Use a clean razor blade to clean the screen (Same as removing paint from a windshield)
- Peripherals (printers and spectrophotometers) must sit outside the mixing room. Conduit assembly and scale connectivity instructions are available at www.PaintManagerXI.com.