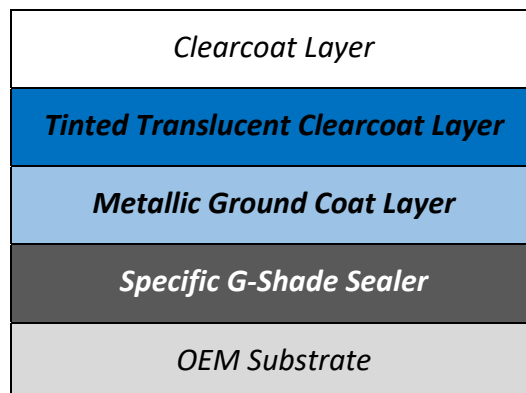




Some of today’s OEM automotive finishes utilize a tinted clear layer to produce a very clean candy blue effect. The repair process for these colors requires a tinted clearcoat layer that is applied over AQUABASE® Plus, DELTRON® DBC, ENVIROBASE® High Performance, GLOBAL REFINISH SYSTEM® BC and NEXA AUTOCOLOR® 2K® basecoat systems.

The tinted translucent clearcoat layer is made by combining a special PPG factory packaged ANDARO® Blue tinter with many of PPG’s popular express, speed, production or glamour clearcoats. A factory pack of the blue tinter may be ordered by calling PPG’s Customer Service or Color Library teams at 800.647.6050.

The refinish repair for B605P consists of a tri-coat process made up of a blue metallic ground coat layer, a tinted translucent clearcoat layer, followed by a final clearcoat layer. See illustration below:



PREPARATION OF THE SUBSTRATE

- Damaged body panels must be repaired using an approved PPG repair process, including using the correct under coating system for aluminum, steel and plastic substrates.
- Finish all body repairs and prep all blend panels for a refinish repair including sealer application. See specific product bulletins for the basecoat system and sealer for sanding and pre-cleaning instructions.
- For proper color alignment, finish the body work with the recommended sealer for that basecoat system using G7 or SG07 shade of gray.
- Be sure to thoroughly clean all surfaces with approved PPG cleaners and tack before applying sealer.

PREPARATION OF THE COLOR CHECK PANEL

NOTE: Prior to applying any color on the vehicle, a color check panel must be produced utilizing the same application method as would be employed in the actual refinish repair. This color check panel is required on every car being repaired due to OEM color variation from one area of the car to the next and from car to car. It is essential that color check panels be prepared to align the color before applying any metallic ground coat color to the vehicle.

Three G7 color check panels (Part #: ARMC464G7) should be prepared as follows:

- Mix and apply the metallic ground coat (OEM Code: B605P-PMC) until proper color is achieved (Waterborne systems require a control coat).
- Prepare the tinted translucent clearcoat by mixing the factory pack blue tinter with a PPG or Nexa premium clearcoat. The correct amount to add is 2.5%. For every 100 grams of unreduced clearcoat add 2.5 grams of the blue factory pack tinter.

Unreduced Clearcoat (grams)	Blue Factory Pack Tinter (grams)
100	2.5
500	12.5
1000	25

- Catalyze and reduce the prepared factory pack tinted clearcoat following the selected premium clearcoat's specific reduction instructions. Refer to the clearcoat's product bulletin for complete details.
- Apply one tinted clearcoat layer over all three color check panels. After flash off, remove one panel and apply a second coat to the remaining panels. After flash off, remove another panel and apply a third coat to the last panel. Allow to flash.

This will result in 3 color check panels with 1, 2 and 3 coats of tinted clear respectively.

- Apply one coat of un-tinted clear over all three panels and allow to dry.

NOTE: To avoid potential clearcoat compatibility issues between the tinted clearcoat and the top or final clearcoat layer, it is only recommended to use the same clearcoat throughout the repair process. A minimum of one topcoat clear layer must be applied over the tinted clearcoat layer.

CHECKING THE COLOR

- Use the completed color check panels to evaluate the color on the car.
- When one of the color check panels is considered “blendable” to the car, proceed in refinishing the vehicle. Be sure to spray the vehicle in the same manner and technique as the color check panels to achieve proper color alignment.
- If a color adjustment is necessary tint the metallic ground coat in the appropriate color direction and prepare another series of color check panels by repeating the above process. Continue in this fashion until a blendable match is achieved.

Important: The metallic ground coat layer may be tinted with toners from that formula only.

Adjusting the tinted clearcoat layer is not recommended. If necessary, contact the Color Library for additional assistance at 800-647-6050 and follow the prompts.

PERFORMING THE REPAIR

- Reduce and spray the basecoat layer as normal per instructions in the product bulletin for the basecoat being utilized for the repair.
- Apply medium light coats of the ground coat until proper color is achieved as determined by the color check panel (Waterborne systems require a control coat). Blend adjacent panels as necessary.
- Allow each coat of basecoat color to flash before applying the next. After each coat is thoroughly flashed, tack with a PPG ONECHOICE® tack rag (part #SX1070) to remove any dust or overspray that may have settled on the surface.
- Apply the tinted translucent clearcoat layer to the repair using the number of coats determined by the color check panels and using the same application technique to ensure similar coverage.
- **The tinted clearcoat must be reduced and catalyzed as normal following the addition of the special factory pack blue tinter. See the specific clearcoat product bulletin for proper mix ratios prior to application.**

When completing the repair, a minimum of one final PPG Premium Clearcoat layer must be applied edge to edge over the tinted clearcoat layer.

