

Basecoat Application



IMRON®

Step 1 | Quality Control

- Ensure the repair is ready for topcoat
- Verify the color position by comparing the spray outs to the vehicle. See Spray Out SOP

Step 2 | Mix

- Mix basecoat on the ColorNet® scale after determining the amount needed to avoid waste
- Use appropriate components based on temperature, humidity, air movement, and size of repair per TDS

Step 3 | Spray Gun

- Select a quality spray gun and fluid nozzle set up
- Adjust the air pressure at the wall, and make micro adjustments at the gun
- Check spray pattern on paper to ensure it is functioning properly

Step 4 | Clean

- Thoroughly clean surface as per Surface Cleaning SOP
- Properly blow and tack off panels to be topcoated using Sontara cloth E-4141

Step 5 | Apply 1st Coat

- Apply basecoat according to the TDS recommendations
- Pay special attention to gun distance, use 50-60% overlap and gun speed of approximately 3 feet per second
- Apply the first coat in an up and down or vertical pattern (commonly referred to as “north and south”)

Step 6 | Apply 2nd Coat

- Within 30 seconds to 5 minutes apply the 2nd coat in a side to side or horizontal pattern (commonly referred to as “east and west”) using the same spray technique, according to the TDS recommendations NOTE: Medium to large panels can be coated back-to-back
- Pay special attention to overlap areas to avoid excess application

Step 7 | Blending

- If blending of basecoat is necessary, a wet bed can be applied prior to basecoat application
- Clearcoat to the end of the panel for best results. Review Blending SOP

Step 8 | 5S (Sort, Straighten, Shine, Standardize, and Sustain)

- Clean spray gun
- Dispose of waste according to local environmental regulations
- Return all items to their proper place