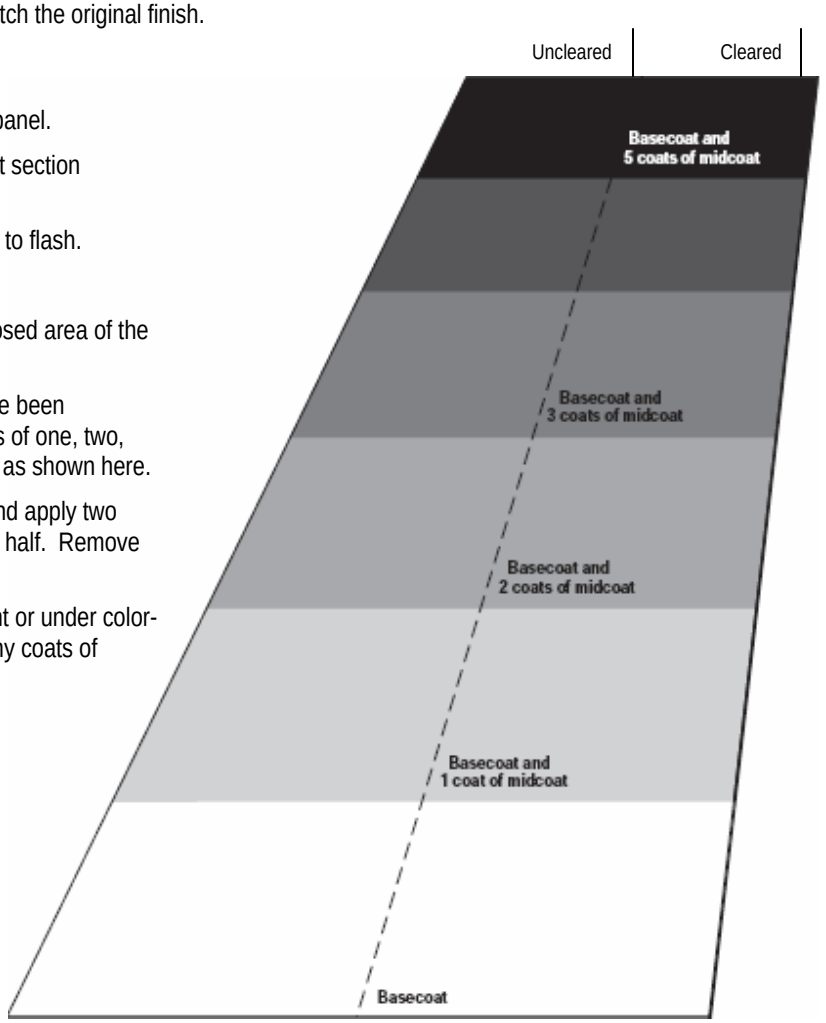
DUPONT® Refinish

Tri-Coat Repairs

The first step in the DuPont system for repairing OEM tri-coat finishes is to prepare a let-down panel. The let-down panel shows how many coats of midcoat it will take to match the original finish.

Step 1: Make a Let-Down Panel

1. Apply basecoat color to hiding over the entire panel.
2. Mask the panel in five sections, leaving the first section exposed.
3. Apply a medium-wet coat of midcoat and allow to flash.
4. Remove masking from next section.
5. Apply a medium-wet coat of midcoat over exposed area of the panel.
6. Repeat steps 4 and 5 until all five sections have been uncovered. Your panel will illustrate the effects of one, two, three, four and five coats of midcoat adhesion, as shown here.
7. Once the panel is dry, mask it off lengthwise and apply two coats of the appropriate clear to the unmasked half. Remove the masking paper and let the panel dry.
8. Compare the panel to the car in natural daylight or under color-corrected indoor lighting to determine how many coats of midcoat you will need to apply.



Step 2: Prepare the Surface

1. Clean and degrease the repair area with an appropriate cleaner (DuPont™ First Klean™ 3900S™, DuPont Kwik Clean™ 3949S™, or Prep-Sol® 3919S™.)
2. Pretreat and prime where needed.
3. Sand the primed area with P400 DA grit or P500-P600 dry or wet sand paper.
4. Sand all panels to be blended with 1500 grit sandpaper. Tri-coat colors require more area for extended blends than conventional base/clear colors.
5. Clean the area with an appropriate cleaner (DuPont™ Final Klean™ 3901S™, DuPont™ 3939S™ Lacquer & enamel Cleaner or DuPont™ Final Klean™ 3909S™.)
6. Seal the primed area.
7. Apply one coat of DuPont 222S Mid-Coat Adhesion Promoter over all sealed panels involved in the repair. This should be applied beyond the areas where the last coat of clear will go in order to help with adhesion.

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Step 3: Apply the Color, Midcoat and Clear

1. Apply the basecoat to full hiding, extending each coat slightly beyond the previous one. Allow adequate flash time between coats.
2. Apply the number of midcoats indicated by the let-down panel. Be sure to fully cover the base color before tapering the blend edge of each coat of midcoat. Blend each coat beyond the next, and allow sufficient flash time between coats.
3. Clear all the panels with ChromaPremier® 72500S™ Clearcoat or ChromaClear® clearcoat.

Tips for Success

For let-down panels, remember:

- *Use the panel as a guide to determine the number of midcoats needed to match the OEM tri-coat color.*
- *A separate let-down panel must be made for each OEM tri-coat color.*
- *Store the let-down panel for future use.*

When applying the midcoat during both the let-down panel preparation and the repair:

- *When using ValueShade®, apply under the base color only. Do not use ValueShade® under the midcoat.*
- *Agitate often to keep heavy mica flakes in suspension and properly oriented.*
- *Use the same reduction, air pressure and application equipment/setup for both the preparation of the let-down panel and the repair. Record the set-up on your let down panel.*
- *Build up the midcoat gradually by applying thin, light coats.*
- *Because of individual variations in technique and equipment, each refinisher should make his or her own let-down panel.*

When doing the actual repair:

- *Clean the spray area well. Dirt is a major enemy of a successful tri-coat repair.*
- *Plan on making light blends of the midcoat into adjacent panels.*
- *Never rush a tri-coat repair. Always allow sufficient time.*
- *Refer to Special Basecoat Blending Procedures, Technique II, for additional blending options.*

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VOC Regulated Areas

These directions refer to the use of products which may be restricted or require special mixing instructions in VOC regulated areas. Follow mixing usage and recommendations in the VOC Compliant Products Chart for your area.

Safety and Handling

For industrial use only by professional, trained painters. Not for sale to or use by the general public. Before using, read and follow all label and MSDS precautions. If mixed with other components, mixture will have hazards of all components.

Ready to use paint materials containing isocyanates can cause irritation of the respiratory organs and hypersensitive reactions. Asthma sufferers, those with allergies and anyone with a history of respiratory complaints must not be asked to work with products containing isocyanates.

Do not sand, flame cut, braze or weld dry coating without a NIOSH approved air purifying respirator with particulate filters or appropriate ventilation, and gloves.

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