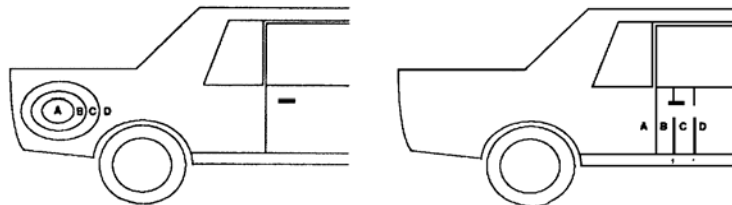


## SPOT REPAIRS WITH U-TECH SINGLE STAGE SYSTEMS

**DESCRIPTION:** The term spot repair is understood to include all repairs to damaged areas resulting in the repaired area blending invisibly into the still intact existing finish. As a result, the technician is not compelled to spray large panels in the case of minor damage. The spot repair technique also enables minor differences in color and effect between the original finish and the repair to be made invisible. The procedures may be used for all U-Tech single stage systems.

**PREPARATION:** (These notes apply for both solid and 1 step metallic colors.)



Clean all areas: first degrease with R859 Wax and Grease Remover. Where VOC emission regulations apply, use recommended compliant Cleaner.

In the above drawings, area "A" is the area under repair. Shape it and build up the area using the appropriate products. After the products have dried, sand the area under repair "A" as well as the adjacent area "B". When spot repairs are made, wet sanding by hand is preferred.



Sand areas "A" and "B" with waterproof #P600 to #P800 grit paper wet. Thoroughly compound areas "C" and "D" (whole panel) with a medium grade compound. Clean and degrease all areas with M600 Surface Cleaner.

### APPLICATION OF 3.5 HSP COLOR (EXAMPLE):

1.



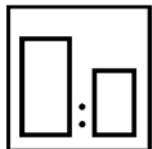
Contains xylene and other ingredients. When mixed, also contains isocyanates.

3.



Use the U-Tech measuring stick and stir thoroughly.

2.



**3:1**  
3.5 HSP single stage color  
3.5 Activator


4.

**Mixing Ratio:**  
3 parts by volume 3.5 single stage  
1 part by volume 3.5 Activator

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## SPOT REPAIRS WITH U-TECH SINGLE STAGE SYSTEMS

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5.  **1.5 x 1 or 2-3 x 1**  
 Spray one coat followed by a cross coat or two to three single flowing coats.

Application Method: Spray single coats in areas A & B until opacity is achieved. Allow 5–10 minutes flash off time between coats.

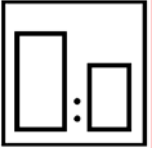



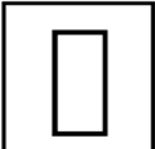
Fade out each coat into area C, with each succeeding coat extending slightly beyond the previous one. After each application, remove dry overspray carefully from areas C and D with a Tack Cloth.

6.  10–15 minutes at 70°F (20°C)

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### BLENDING:

#### For 3.5 HSP solid color Systems:

1.  100:100  
 U-Tech 3.5, ready to spray  
 R200 Reducer
2.  Use the U-Tech measuring stick.
3.  **1x1**  
 Spray 1 single fade out coat
4. 
5.  R201 Blending Reducer  
 Ready to spray

**Application Method:** Add to the ready to spray paint, 100 parts by volume R200 Reducer.

With this over-reduced material, extend the application, fading out into area D.

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## SPOT REPAIRS WITH U-TECH SINGLE STAGE SYSTEMS

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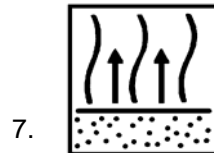
### BLENDING:

#### For 3.5 HSP solid colors: (Continued):



2x1

Use pure R201 Blending Reducer to dissolve overspray edge.  
 Spray 1 medium coat.  
 Flash for 15 seconds.  
 Apply final thin coat.



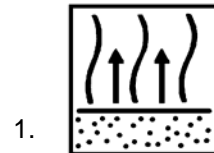
15 seconds at 70°F (20°C)  
 between coats of R201  
 Reducer



15 hours at 70°F (20°C)  
 45 min. at 140°F (60°C).

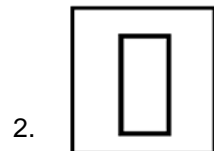
### BLENDING:

#### For Utech 3.5 HSP 1 step metallic colors:



10 minutes at 70°F (20°C)

**Application Method:** After the last coat of 3.5 HSP Metallic. Flash for a minimum of 10 minutes. (Do not add extra reducer to fade out into area D.)

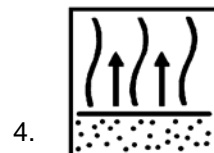


R201 Blending Reducer  
 Ready to spray



2x1  
 Apply 2 single coats

Use pure R201 Blending Reducer to dissolve overspray edge. Spray 1 thin coat, flash for 15 seconds, apply final thin coat.



15 seconds at 70°F (20°C)  
 between coats of R201  
 Blending Reducer



15 hours at 70°F (20°C)  
 45 min. at 140°F (60°C).

### AFTER TREATMENT:

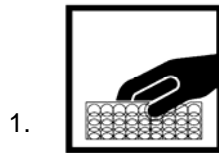
After the repair is completely dry, the fade out area may be polished with an ultra-fine polishing compound and waxed. (Please see the dry to polish time of the materials being used.)

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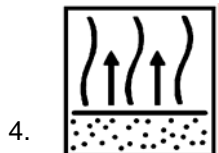
## SPOT REPAIRS WITH U-TECH SINGLE STAGE SYSTEMS

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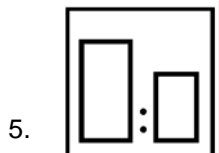
### ALTERNATE PROCESS: (FOR 3.5 HSP SOLIDS AND 1 STEP METALLICS):



U-Tech R859 Wax and Grease Remover



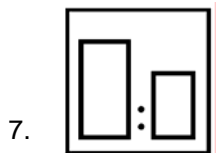
10 minutes at 70°F (20°C)



3:1  
 MS Clear  
 MS Activator



Use the U-Tech measuring stick.



100:100  
 MS Clear (Ready to Spray)  
 R200 Reducer

**Preparation:** Sand areas A and B with waterproof #P600 to #P800 grit paper wet. Scuff areas C and D (whole panel) with a white scuff pad.

Wash down area to be repaired with R859 Wax and Greaser Remover. This will remove any contaminant that cannot be removed with water.

**Application method:** Refer to the above data for application and fade out to U-Tech single stage solid color and/or 1 step metallic and fade out.

After the fade-out in area D, flash for a minimum of 10 minutes.

**MIX AND APPLY MS Clear AS FOLLOWS:**

3 parts by volume MS Clear  
 1 parts by volume MS Activator/  
 Hardener

With this normal mixture of MS Clear (Ready to Spray), add 100 parts R200 Reducer.


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## SPOT REPAIRS WITH U-TECH SINGLE STAGE SYSTEMS

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### ALTERNATE PROCESS:

(FOR U-TECH SINGLE STAGE SOLIDS AND 1 STEP METALLICS) CONTINUED:

8.  2-3x1  
Apply 2-3 single coats.
- With this over reduced MS Clear, first spray a thin coat only on fade out area D. Flash for 3-5 minutes. Apply one or two single coats of the same mixture of MS Clear over the whole panel\*. If this is not possible, dissolve overspray edge with pure R201 Reducer.

### NOTE:

\*If blending of the clearcoat is inevitable (sail panels), the preparation should be as follows: restore gloss and color with a medium grade compound, then clean with M600 Surface Cleaner.

9.  5 minutes at 70°F (20°C) Allow 5 minutes flash time between coats of clear.
10.  15 hours at 70°F (20°C)  
45 minutes at 140°F (60°C)

### ALTERNATE PROCESS (FOR U-TECH SINGLE STAGE METALLICS):

First spray a single coat of the over reduced MS Clear (mixing ratio: 3:1, then add to this ready-to-spray clear, 100 Parts R200 Reducer) over areas A, B, C and D. Then spray U-Tech single stage system (standard mixing ratio) in area A until complete opacity is achieved. Control color in area B. After approximately 10 minutes at 70°F (20°C), apply 1, maximum 2, single coats of MS Clear (mixing ratio: 100 parts ready to spray + 100 parts R200 Reducer) over areas A, B, C and D. Immediately thereafter, fade out with normally mixed U-Tech single stage metallic into the clearcoat.

**NOTE:** For regulated areas, The use of HS21 clear should be used.

Refer to the following Technical Data Sheets for more information:

- 3.5 single stage system
- 3.8 single stage system
- 2.8 single stage system
- 200 single stage system
- MS Clear
- HS21 Clear
- R201 Blending Reducer



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## SPOT REPAIRS WITH U-TECH SINGLE STAGE SYSTEMS

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### SAFETY ASPECTS:

#### READY TO

#### SPRAY VOC:

3.5 HSP System Single Stage:	3.5 lb/gal	420 g/liter
Ready To Spray 3.5 HSP (100:100) with R200 Reducer:	5.7 lb/gal	680 g/liter
MS Clear (100 ready to spray + 100 parts R200 Reducer):	5.4-lb/gal	659 g/liter
HS21 Clear (100 ready to spray + 100 parts R200 Reducer):	5.2-lb/gal	633 g/liter

#### NOTICE:

Do not handle until the Material Safety Data Sheets have been read and understood. Regulations require that all employees be trained on Material Safety Data Sheets for all chemicals with which they come in contact. The manufacturer recommends the use of an air-supplied respirator when exposed to vapors or spray mist.