

COLLISION REPAIR INFORMATION

FOR THE COLLISION REPAIR PROFESSIONAL

TITLE: CLEAR COAT SOLVENT BLENDING
SECTION: REFINISH BULLETIN # 65
MODELS: ALL TOYOTA, LEXUS, and SCION
DATE: REVISED AUGUST 2013

A refinish technique called 'clear coat solvent blending' is an attempt to "melt" a refinish topcoat into an existing or factory finish. However, with modern auto finishes being thermoset (irreversibly hardened) this technique has several inherent flaws, and may not comply with established VOC regulations. It is the responsibility of each facility to verify and comply with all Federal, State and local Environmental Health & Safety regulations.

By their chemistry, modern thermoset finishes cannot be "melted" into one another. This melting phenomenon was previously a characteristic of thermoplastic lacquer finishes that auto manufacturers no longer use.

To achieve optimal paint film build for durability, paint manufacturers typically recommend 2.0 – 2.5 mils of clear coat film build. During solvent blending the clear coat film build is tapered from a recommended thickness to 0.0 mils. This lack of film build greatly reduces finish durability in the 'blend' area and leads to undesirable finish appearance issues such as:

- Hazing/Fading
- Visible blend lines
- Peeling/Delamination

Undesirable quality issues can negatively impact refinish durability, customer satisfaction, and the reputation of the repair facility performing clear coat blending. Therefore, Toyota recommends strongly against solvent blending clear coat.



Example Clear Coat Blend Preparation

**PLEASE ROUTE THIS BULLETIN TO YOUR COLLISION REPAIR CENTER
MANAGER AND COLLISION REPAIR TECHNICIANS**

