

Eastwood[®]

DO THE JOB RIGHT.[®]

PAINT INTERMIX COLORS

INSTRUCTIONS



EASTWOOD PAINT INTERMIX BLENDING SYSTEM custom mixed paint choices all feature the most modern automotive refinish technologies paired with premium raw materials in an incredibly user-friendly system. Delivers beautiful results in a wide range of colors including classic solids and eye pleasing metallics. May be used as a one-step single-stage topcoat, or in combination with Premium European or Premium Urethane Clearcoat for even better protection and a deeper gloss. Either way, this advanced urethane color system is the ideal choice to perfectly complete any project, from antique and classics to more modern muscle cars and resto-mods. Available in dozens of colors. This system is a Low-VOC formula topcoat, single-stage; Max. VOC 2.8 lbs/Gal.



CONTENTS

- (2) 5 Qt. Paint Mixing Cups with Lids
- (1) Paint Mixing Wand
- (1) 2 Gallon Plastic Blending Bucket with Sealable Lid

BLENDING COLORS

- Begin by thoroughly shaking and or stirring the paint separately in the individual color cans. The included Paint Mixing Wand may be chucked into a power drill and used to speed the stirring process.

Stirring must be done first to make sure all resins, pigments and metallic particles are fully blended into the color. **NOTE:** metallic particles in particular will tend to settle to the bottom of the can and can be difficult to stir into the color. Care must be taken to do this.



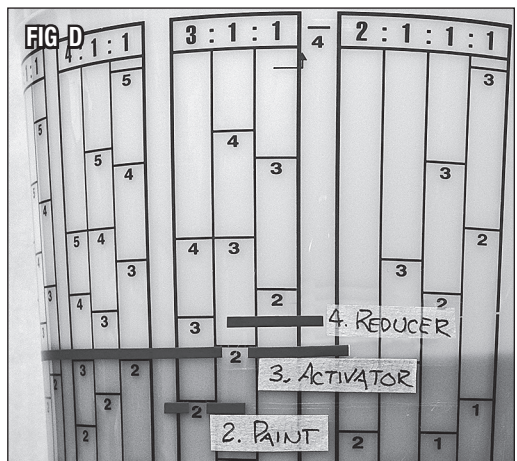
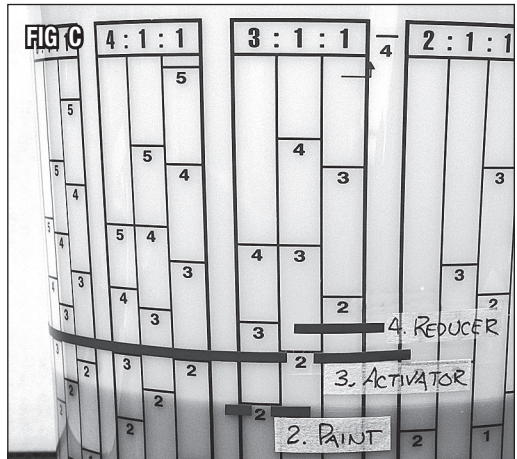
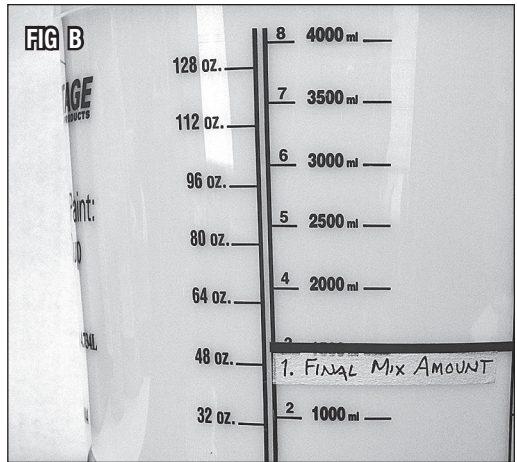
- Next, pour both cans of blended color into the 2 gallon mixing pail being careful to extract all color from the individual cans.
- The included Paint Mixing Wand may be chucked into a power drill and used to speed the stirring process (**FIG A**).
 - **IMPORTANT NOTE:** DO NOT Mix the activator into the 2 gallon bucket! Use the supplied mixing cup to mix only the amount needed.
 - The 2 gallon bucket has a re-sealable lid to preserve the blended color for storage prior to activation.
 - DO NOT return activated paint to the 2 gallon bucket as it will contaminate and partially cure any remaining color blend.

ACTIVATING BLENDED COLORS

- It is ***extremely important*** to mix the paint and activator in the proper **3 to 1 ratio** regardless of the amount of paint being mixed.
 - Too much activator will cause the paint mixture to cure too quickly and potentially harden in the paint gun making cleaning impossible and ruining the paint gun.
 - Too little activator will result in the paint finish failing to harden, remaining soft and becoming gummy when being sanded.
- Always use one of the included mixing cups to achieve the required 3 parts paint to 1 part activator.
- Only mix the required amount of paint that can be used in a maximum 2 to 3 hour period (@70°F/21°C) or any excess mixture after that period will become unusable.

USING MIXING CUP

- Decide how much final 3 to 1 mixed paint is needed for the job and mark that on the Oz. Column. (In this example, we have chosen 48oz.) (**FIG B**). Next, trace around the cup to the 3:1:1 column and note the 1, 2, 3 or 4 step marks. Note where desired final mixed amount in ounces most closely equates to on the 3:1:1 column and choose. (For this example only, we have chosen a final mixed amount of approx. 48oz. which equates to using "2" in the center row).
- Add Paint slowly up to the 1st "2" row (2 for this example only) (**FIG C**).
- Add Activator slowly up to the 2nd "2" row (2 for this example only). This line will be your final mixed amount (**FIG D**). Thoroughly mix three parts Single-Stage Urethane paint with one part 21856ZP Activator. The mixture should be ready to spray.
- Only if needed, Reducer can then be added to the 3rd 1, 2, 3 or 4 row (**FIG D**). Additional reduction is not required, though it may help to improve flow and leveling. If reducing, Eastwood recommends **no more than 10% reduction** using either 14158ZP Fast/Low temp, 14159ZP Medium/Mid temp or 14160ZP Slow/High temp urethane reducers, or 50104ZP Zero-VOC reducer.
- Eastwood 14498Z Fish-Eye Eliminator may be added to the mixture, but only if fish eyes are found to be present. Add up to 1/2 fluid ounce to each sprayable quart of paint.



SURFACE PREPARATIONS

SUITABLE SUBSTRATES INCLUDE:

- Eastwood Epoxy Primer, Eastwood 2K Urethane Primer Surfacer, and properly prepared factory finishes. When painting over existing finishes or cured undercoat products, first, clean surface with Eastwood PRE Painting Prep, a specially-formulated blend of solvents designed to remove tar, wax, grease, road grime, silicone, buffing compound and other surface contaminates.
- Next, abrade surface to be painted with 400-600 grit sandpaper.
- Finally, re-clean with PRE or other comparable Surface Wash product to remove any debris before application.
- When applying over fresh primer, be sure to allow sufficient flash time. No additional prep steps are required, as long as primer is still within its recoat window.

POT LIFE

Use caution in mixing materials as activated Eastwood Single-Stage Urethane may begin to gel after approximately two to three hours (at 70°F/21°C).

SPRAY GUN SETUP

HVLP: 1.2 - 1.4 mm fluid tip. 28-32 PSI (1.9-2.2 bar) gun inlet pressure.

Conventional Gravity: 1.2 - 1.5 mm fluid tip 45-50 psi (3.1-3.4 bar) inlet pressure.

Conventional Siphon: 1.2 - 1.6 mm fluid tip 40-50 psi (3.1-3.4 bar) inlet pressure.

APPLICATION INSTRUCTIONS

Apply Eastwood's Single-Stage Urethane paints in two to three medium wet coats as necessary to achieve sufficient coverage, allowing ten minute flash between coats (may require more or less time depending on ambient air temperature, humidity, air flow and other atmospheric conditions).

Additional coats may be necessary to achieve total coverage for some metallic or pearl colors.

A final "drop coat" may be applied with metallic colors to help set an even flake pattern and/or adjust flake orientation.

A dry film thickness of approximately 2 mil. is recommended. This Urethane Paint may be applied as a stand-alone single-stage system, or in combination with Eastwood's European Urethane Clear as a basecoat/clearcoat system.

NOTE: Certain metallic colors should be applied with a clearcoat or a urethane candy topcoat, since the extra coarse aluminum used in those formulas will reduce the finished gloss when applied as single-stage paint.

NOTE: Some pearl colors must be applied over a ground coat, or a sealer. These midcoat pearl colors will not provide complete hiding, so a uniform ground coat is required. Pure White will give the brightest, truest pearl effect, but users may want to experiment with different ground coat colors for a variety of effects.

DRY TIMES

Paint should be dust free within 10-15 minutes and tack-free within one hour (at 70°F / 21°C).

Recoat any time after the previous coat has flashed, or before 18 hours. After 18 hours, paint should be abraded prior to recoating for proper adhesion purposes. Wait overnight before polishing. Wait at least 24 hours before striping and 48 hours before applying decals.

Eastwood's Single-Stage Urethane Topcoats may be force dried at 140°F / 60°C for 40 minutes after a 5-10 minute flash. Allow sufficient time for vehicle to cool down following bake cycle.

All dry times are approximate, at 70°F / 21°C. Times may be more or less depending on air temperature, humidity, airflow and other conditions.

POLISHING

When used as a Single-Stage Urethane Paint, this coating may be wet-sanded and polished for increased depth and gloss like any other urethane topcoat. Care should be taken when cutting metallic colors to avoid disturbing aluminum flake.

Start by sanding the finish with 1500 grit to abrade the surface and remove any slight imperfections. Next, sand the entire surface with 2000 grit to remove the 1500 sand scratches.

Follow with a high-quality finishing compound, then a finishing glaze applied by hand, or with a variable-speed buffer.

CLEANUP

Make sure all containers are sealed tightly immediately after each use. Spray gun and equipment may be cleaned with a solvent Gun Wash, Eastwood's PRE, or Eastwood's Aerosol Injected Cleaner (12846Z).

ADDITIONAL ITEMS

- #10041Z PRE Painting Prep, Aerosol
- #11949Z Low-VOC PRE Painting Prep, Aerosol
- #10194ZP PRE Painting Prep, 30oz.
- #10594ZP PRE Painting Prep, Gallon
- #14160ZP Eastwood Urethane Reducer, Slow
- #14159ZP Eastwood Urethane Reducer, Medium
- #14158ZP Eastwood Urethane Reducer, Fast
- #14498Z Eastwood Fish-Eye Eliminator

If you have any questions about the use of this product, please contact

The Eastwood Technical Assistance Service Department: 800.343.9353 >> email: tech@eastwood.com

PDF version of this manual is available at eastwood.com

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