

VX-400 BLENDING SOLVENT

Valorem VX-400 Blending Additive Solvent is a specialty material designed for dissolving the overspray and fade out edge created during spot repairing and blending. VX-400 Blending Solvent can be used with any Valorem clearcoat.

**SAFETY CONSIDERATIONS**

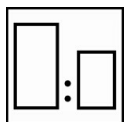
- Use suitable personal protection. When exposed to paint or solvents AkzoNobel recommends the use of a fresh air supply respirator.

**FADE OUT EDGE PREPARATION**

- Prepare the full-strength clearcoat application area with P1000 on a D/A with interface pad or a gray scuff pad and quality scuff paste.
- Prepare the ready to spray paint + VX-400 application area with a gold scuff pad or damp sponge and quality scuff paste. The area must extend past the intended melt-in area.

**USE WITH READY TO SPRAY PAINT**

- For blending applications, prepare the clearcoat as described in the clearcoat TDS then add VX-400 Blending Solvent.

**MIXING**

Mix	By Volume
2	Ready to spray clearcoat
1	VX-400 Blending Solvent

**EQUIPMENT**

**Clearcoat + Blending Solvent
Spray-Gun:**

- 1.3 – 1.5 mm HVLP Gravity
- 1.3 – 1.5 mm Compliant Gravity

Reduce Application Air Pressures:

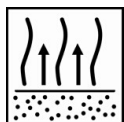
- HVLP – 6-8 psi (.4-.5 bar) at the air cap.
- Consult manufacturer specifications.

**APPLICATION****Clearcoat + VX-400 Blending Solvent Application**

- Control application to restrict the overspray to the edge of the application.
- Apply 1 thin coat of clearcoat mixed with Blending Solvent over the full strength clearcoat overspray edge and extending into the prepared existing finish.
- Apply a second application after a short flash if needed.

**APPLICATION****Pure VX-400 Blending Solvent Application**

- Lower pressure to apply pure VX-400 Blending Solvent and check the spray pattern.
- Apply 1 thin coat to the edge of the clearcoat + VX-400 Blending Solvent edge.
- If needed apply a second coat of VX-400 Blending Solvent after a short flash.

**FLASH OFF****Flash Between Coats at 70°F (21°C)**

- Clearcoat, 1-3 minutes.
- VX-400 Blending Solvent, 15-30 seconds.

Flash Before Force Drying at 70°F (21°C)

- Refer to the mixed product TDS for flash and bake recommendations.

**DRYING**

- Refer to the mixed and applied product TDS for drying recommendations.

Read the complete TDS and the product Safety Data Sheet (SDS) for detailed product information

VX-400 BLENDING SOLVENT**DESCRIPTION**

Valorem VX-400 Blending Additive Solvent is a specialty material designed for dissolving the overspray and fade out edge created during spot repairing and blending. VX-400 Blending Solvent can be used with any Valorem clearcoat.

**PRODUCT ASSORTMENT**

- VX-400 Blending Solvent – Item #594519 (Quart)

- Note: VX-400 Blending Solvent is only suitable for use in National Rule VOC areas. For VOC regulated markets use Valorem Aerosol Blending Solvent LV.
- Stock unopened or used products in approved closed containers with proper labeling. Store in temperatures between 40°F - 95°F (5°C – 35°C). Avoid too much temperature fluctuation. Optimum storage temperature is approximately 70°F (21°C).
- Shelf-life: 2 years
 - Refer to the price list for the most up-to-date shelf-life information.

**BLENDING OF CLEARCOAT**

- AkzoNobel strongly recommends the application of clear coat over the entire panel being repaired. There are, however, instances where this is not practical. Such as repairs on older vehicles where economics would dictate that a warranty is not required. In these instances, it may be acceptable to solvent blend the clear coat into small areas such as a rocker panel, sail panel or on vertical areas only.
- Solvent blending techniques and procedures explained in this TDS are not warranted by AkzoNobel or OEM approved.

**SUITABLE SUBSTRATES**

- Refer to TDS for the paint product that VX-400 Blending Solvent will be used with for information on suitable substrates.

**COMPATIBLE PRODUCTS**

- Valorem SB
- Valorem Acrylic Urethane Clearcoats

**BASIC RAW MATERIALS**

- VX-400 Blending Solvent – Specially formulated solvents

**PRE-CLEANING**

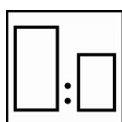
- If needed pre-wash the repair with warm soap and water. Rinse completely with clean water.
- Clean with VCD-10 Cleaner/Degreaser or VCD-20 Waterborne Degreaser (VOC compliant).

VX-400 BLENDING SOLVENT**FADE OUT EDGE PREPARATION**

- Prepare the full-strength clearcoat application area with P1000 on a D/A with interface pad or a gray scuff pad and quality scuff paste.
- Prepare the ready to spray paint + VX-400 application area with a gold scuff pad or damp sponge and quality scuff paste. The area must extend past the intended melt-in area.

**SURFACE CLEANING – PRIOR TO PAINT APPLICATION**

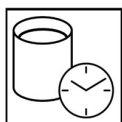
- Clean with VCD-10 Cleaner/Degreaser or VCD-20 Waterborne Degreaser (VOC compliant).



READY TO
SPRAY

MIXING for spray gun application**Mix**

- | | |
|----------|------------------------------|
| 2 | Parts ready to spray paint |
| 1 | Part VX-400 Blending Solvent |

**POT-LIFE WHEN MIXED**

- The recommended pot-life does not change with the addition of VX-400 Blending Solvent.
- Refer the TDS of the product being applied for pot-life information.

**EQUIPMENT****Spray-Gun Set-Up**

- 1.3 – 1.5 mm HVLP Gravity
- 1.3 – 1.5 mm Compliant Gravity

Application Air Pressure:

- HVLP – 6-8 psi (.4-.5 bar) at the air cap.
- Consult manufacturer specifications.

**APPLICATION****Clearcoat + VX-400 Blending Solvent Application**

- Control application to restrict the overspray to the edge of the application.
- Apply 1 thin coat of clearcoat mixed with Blending Solvent over the full strength clearcoat overspray edge and extending into the prepared existing finish.
- Apply a second application after a short flash if needed.

**APPLICATION****Optional pure VX-400 Blending Solvent application**

- This optional application provides the smoothest transition and minimizes detailing.
- Lower pressure to apply pure VX-400 Blending Solvent and check the spray pattern.
- Apply 1 thin coat to the edge of the clearcoat + VX-400 Blending Solvent edge.
- If needed apply a second coat of VX-400 Blending Solvent after a short flash.

**DRYING**

- Dry the applied paint according to its TDS specifications.
- Additional drying with infrared will provide the most favorable through hardening in the blend area and less chance of damaging it during detail.
- If the paint is baked, follow the product TDS recommendations for cool down before detailing.

**RECOATING**

Refer to the applied product TDS for information on recoating.

VX-400 BLENDING SOLVENT**DETAILING / POLISHING**

- Polish the blended area by hand with 3M #06064 Perfect-It Machine Polish or a similar fine polishing compound. Do not use an abrasive polishing compound.
- In case more effort is required, polish by machine, using light pressure and a 3M #05707 Perfect-It Foam Polish Pad. Final clean up with a 3M #06016 Perfect-It Detail Cloth.
- After polishing the area may be waxed with a silicone free wax.

**VOC / REGULATORY INFORMATION**

- Notice: Do not handle until the Safety Data Sheets have been read and understood. Regulations require that all employees be trained on 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.

VX-400 Blending Solvent Ready to spray VOC:

Product Mix	lb/gal	g/L
VX-400 Blending Solvent	7.0	840

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FOR PROFESSIONAL USE WITH SUITABLE HSE EQUIPMENT

IMPORTANT NOTE The information in this data sheet is not intended to be exhaustive and is based on the present state of our knowledge and on current laws: any person using the product for any purpose other than that specifically recommended in the technical data sheet without first obtaining written confirmation from us as to the suitability of the product for the intended purpose does so at his own risk. It is always the responsibility of the user to take all necessary steps to fulfill the demands set out in the local rules and legislation. Always read the Safety Data Sheet and the Technical Data Sheet for this product if available. All advice we give or any statement made about the product by us (whether in this data sheet or otherwise) is correct to the best of our knowledge but we have no control over the quality or the condition of the substrate or the many factors affecting the use and application of the product. Therefore, unless we specifically agree in writing otherwise, we do not accept any liability whatsoever for the performance of the product or for any loss or damage arising out of the use of the product. All products supplied and technical advices given are subject to our standard terms and conditions of sale. You should request a copy of this document and review it carefully. The information contained in this data sheet is subject to modification from time to time in the light of experience and our policy of continuous development. It is the user's responsibility to verify that this data sheet is current prior to using the product.

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