

Repaired Metal Part Refinishing

Best Demonstrated Practices

Area: Body Repair

STEP 1:

Solvent test OE coating by the repair area. If insoluble, proceed to Step 2. If soluble, either remove coating or prepare to prime the complete panel.



STEP 2:

All bodywork must be finished with P180 grit sandpaper.



STEP 3:

Featheredge the repair area with P220 grit DA sandpaper, followed by P320 grit DA sandpaper. Extend the sanded area around the repair with P400 sandpaper to accommodate the primer application.



Area: Paint Prep

STEP 4:

Treat bare metal with PE995 or E2G970 Etching Primer.



STEP 5:

Apply 2–3 coats of P27 or P30 Primer Surfacer making sure that primer is not applied beyond P400 sand scratches. Allow a maximum of 5 minutes flash between coats for P27. If using P30, no flash necessary — not to exceed 2 minutes.



STEP 6:

Apply Short Wave Infra-Red at full power at 36" for 10 minutes. After primer has cured, apply P27 or P30 as a dry guide coat before block sanding.



STEP 7:

Block-sand with P400 grit sandpaper and re-apply dry guide to repair area.



STEP 8:

Finish sand repair area with P600 grit sandpaper. If using a DA to finish sand, an interface pad must be used.



Area: Spraybooth

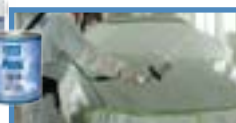
STEP 9:

Apply AWX® basecoat until coverage is achieved. Refer to Product Data Sheet AS2667. If blending is necessary, refer to 4550500 AWX® Blender Product Data Sheet AS2926.



STEP 10:

Allow the AWX® Basecoat to flash 15–30 minutes or until fully dehydrated before clearcoating.



STEP 11:

For low VOC areas apply 1100755, HPC21, CC920, CC921, CC923, CC927 or SRC2. See clearcoat Product Data Sheet. For National Rule Areas, 1100755, CC939, CC947 and HPC15 can also be used over AWX®.



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I-CAR recommends following the paint manufacturer's recommendations for paint preparation, mixing and application of automotive refinish products.



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Automotive Finishes

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