

Standard Operating Procedure

Type of Repair - 2K Metal/Plastic

Quality Level - Professional

Surface Preparation Stage



1. Vehicle is hand washed and dried, thoroughly inspected, then damaged area is compounded to remove any remaining road film and contaminants
2. Clean surface with Solvent Wash 368-0090

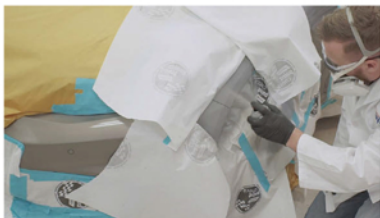


3. Mechanically sand the damaged area beginning with P120 grit abrasive then P240
4. Continue to mechanically sand the area around working towards the edges with increasingly finer abrasives P320, P400



5. Apply an All-In-One Premium Body Filler to damage area and when cured, block sand with P120
6. Sand body filler using increasingly fine grits of P320, P400, P600

Primer Filler Stage



7. Mask remainder of repair area and wipe down with a dust-free tack cloth
8. After activating 2K DTS Primer 368-4262 adjust variator, perform a spray test and apply
9. With IR-Heating: Distance 16 inches at 800 Watt / dry for 20 minutes - alternatively a heat gun can be used to speed up the process

Basecoat / Clear Coat / Spot Blender Stage



10. After performing a spray test, apply mixed Waterborne Basecoat
11. Allow basecoat to flash off - an air gun can be used to accelerate the flash time and
12. Apply 3-4 coats of Basecoat as required to achieve satisfactory colour coverage - allow to flash off between coats



13. Activate, perform a spray test, and apply 2K Clear Glamour 368-0061
14. Allow to flash off and then apply another layer of 2K Clear Glamour 368-0061



15. Afterwards immediately apply Spot Blender 368-0093 into the transition zone
16. With IR-Heating: Distance 16 inches at 800 Watt / dry for 20 minutes
17. After complete curing polish if necessary and check finished results with a Sun Lamp if available