

Standard Operating Procedure

Type of Repair - 2K 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, P600 and P800



5. Generously clean surface with Wax and Grease Remover 368-0094
6. Use an ultra fine scuff pad in the surrounding area and back-mask where adhesion promoter & primer will be used

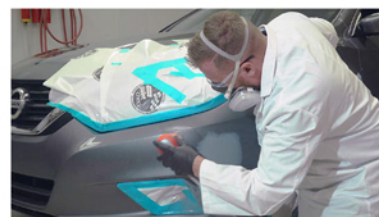
Primer Filler Stage



7. Apply a light coat of Plastic Adhesion Promoter 368-0009 and allow to flash for 10 minutes before priming
8. After activating 2K Rapid Primer Filler 368-0031 adjust variator, perform a spray test and apply, allow 10 minutes flash off time, then apply a second coat



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
10. Apply Guide Coat Black 368-0100 over primer to aid in proper light sanding to follow
11. Mechanically sand or hand sand primed area with P400 then P600



12. Clean surface with Wax and Grease Remover 368-0094
13. Mechanically sand or hand sand edges, wet with P1000, P2000, P3000
14. Generously clean surface with Wax and Grease Remover 368-0094

Basecoat / Clear Coat / Spot Blender Stage



15. After performing a spray test, apply mixed Waterborne Basecoat
16. Allow Basecoat to flash off – an air gun can be used to speed dry
17. Apply 3-4 coats of Basecoat as required to achieve satisfactory colour coverage
18. Allow to flash off between coats – an air gun can be used to speed dry



19. After activating 2K Clear Glamour 368-0061 and performing a test spray, apply over painted repair area
20. Allow to flash off
21. Apply another layer of 2K Clear Glamour 368-0061



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