

# PANEL REPAIR

01

## PREPARATION

- Inspect small panel damage.
- Degrease and clean.
- Cleaning:
  - Air blow.

02

## COLOUR CHECK

- Option 1: Use the Valspar Spectrophotometer.
- Option 2: Check for identification plate colour code.
- Refer to Valspar Color Box.
- Check for the best match.
- Mix the formulation in the required quality and quantity.
- Make spray out for colour match.

03

## SAND & ROUGH MASK

- Sanding with P120-P240-P320.
- Clean and degrease.
- Rough masking application.
- Clean and degrease once more.
- Cleaning:
  - Air blow and tack rag.

04

## ETCH PRIMER APPLICATION

- Apply 1 coat of etch primer on bare metal areas.
- Flash off for 10 minutes.
- Cleaning:
  - Tack rag.

05

## SURFACER APPLICATION

- Apply 2-3 coats of surfacer on the repair area.
- Drying:
  - Infra Red or
  - Force drying at 60°C/140°F.

06

## SANDING

- Sand the surfacer with P400-P500 with a soft pad.
- Sand the rest of the panel with a grey pad P1500 or equivalent.
- Guide coat for each if the sanding steps, removing any imperfections.

07

## DEGREASE & CLEAN

- Final degreasing and cleaning before basecoat application.
- Cleaning:
  - Air blow and tack rag.

08

## BASECOAT APPLICATION

- Apply the basecoat.
- Flash off sufficiently.
- Apply the final coat at 1bar, dropcoat to avoid mottling and for color match.
- After final flash off tack rag carefully.

09

## CLEAR COAT APPLICATION

- Apply clear coat in 1,5 or 2 thin closed layers with flash off.
- **TIP** - For light metallic colours, only apply 1 coat of clear over the end of panel if possible to avoid darkening or colour change.

10

## DRYING

- Infra Red drying has the preference as that is the most economical and fastest way or
- Force drying at 60°C/140°F.
- **TIP** - Points to take care of when using Infra Red: distance, half or full bake cycle, time & temperature (max 70°C/158°F). Keep enough distance between plastic parts and Infra Red to prevent deformation (check instructions Infra Red).

11

## POLISHING

- Sand with P2000 or P3000 and polish if required.

12

## FINISH

- Hand over vehicle to happy & satisfied customer.