

# Standard Operating Procedure

Type of Repair - 1K Metal/Plastic

Quality Level - Semi-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 areas and feather edge outwards
4. Clean surface with Wax and Grease Remover 368-0094
5. Apply All-In-One Premium Body Filler to the damage area – when cured block sand with P120



6. Sand body filler with increasingly fine grits of P320, P400, P600
7. Mask remainder of repair area and wipe down with a dust-free tack cloth

## Primer Filler Stage



8. Shake 1K 3 in 1 Primer Shade – Gray 368-0404 for 1-2 minutes – after you hear the mixing balls rattle
9. Adjust variator, perform a spray test, then apply 1K 3 in 1 Primer Shade – Gray 368-0404



10. After matte evaporation, approximately 5 minutes, apply a thin layer of Guide Coat Black 368-0100 over primer to allow for proper light sanding to follow
11. Sand with P600 to remove the guide coat and prepare surface for mechanical adhesion of topcoat – wipe down with a dust-free tack cloth

## Basecoat / Clear Coat / Spot Blender Stage



12. After performing a spray test, apply mixed 1K FillClean Waterborne Basecoat
13. Allow Basecoat to flash off – an air gun can be used to speed up the process
14. Allow to flash off



15. Apply 3-4 coats of Basecoat as required to achieve satisfactory colour coverage
16. Allow to flash off between coats
17. Perform a spray test and apply 1K Clear Acrylic 368-0056
18. Allow to flash off



19. Apply another layer of 1K Clear Acrylic 368-0058
20. Afterwards immediately apply Spot Blender 368-0093 into transition zone
21. After complete curing polish if necessary