# **Standard Operating Procedure**



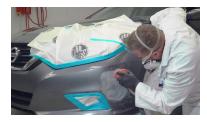
### Type of Repair - 2K Plastic

# Quality Level - Professional

### Surface Preparation Stage



- 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
- Continue to mechanically sand the area around working towards the edges with increasingly finer abrasives P320, P600 and P800



- 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
- 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



- 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