

# Standard Operating Procedure

Type of Repair - 1K 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 area beginning with P220 grit abrasive then P400
4. Continue to mechanically sand the area around working towards the edges with P600



5. Use an ultra fine scuff pad in the surrounding repair area
6. Generously clean surface with Wax and Grease Remover 368-0094

## Primer Filler Stage



7. Shake 1K 3 in 1 Primer Shade - Gray 368-0404 well for 2 minutes - after you hear the mixing balls rattle
8. After performing a spray test apply 1K 3 in 1 Primer - Shade Gray 368-0404
9. After allowing first coat to flash, perform test spray and then apply second coat of 1K 3 in 1 Primer Shade - Gray



10. Allow approximately 10 minutes flash-off time - alternatively you can use a heat gun to speed up the process
11. Apply Guide Coat Black 368-0100 over primer to allow for proper light sanding to follow
12. Mechanically sand or hand sand the primed area with P600 then P800



13. Clean surface with Wax and Grease remover 368-0094
14. Mechanically sand or hand sand edges wet with P1000, P200 and P3000
15. Generously clean surface with Wax and Grease Remover 368-0094

## Basecoat / Clear Coat / Spot Blender Stage



16. After performing a spray test, apply mixed 1K FillClean Waterborne Basecoat
17. Allow Basecoat to flash off - an air gun can be used to speed up the process
18. Apply another layer of mixed 1K FillClean Waterborne Basecoat



19. Allow to flash off between coats - apply 3-4 coats of Basecoat as required to achieve satisfactory colour coverage - an air gun can be used to speed dry
20. After performing a test spray apply 1K Clear Acrylic 368-0058
21. Allow to flash off



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