

Sensitive substrates

Technical Bulletin

09/11/2019

L8.06.04 UK & Ireland

DESCRIPTION

This Technical Service Bulletin describes the optimum process to repair sensitive substrates.

Note that the indicated process will not always be applicable to every OEM substrate.

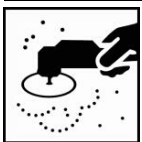
This Technical Service Bulletin will focus on the following steps:

- A solvent sensitivity test on the paint system
- The necessity for sanding larger featheredges
- The necessity for additional, finer sanding steps
- The necessity for Infrared drying
- Careful application of solvent borne products to avoid solvent penetration

SANDING



Clean the surface thoroughly with an appropriate surface cleaner.



- | | |
|----------|---|
| P80/P180 | Remove existing finish. |
| P280 | Sand larger featheredges than usual. |
| P320 | Remove sanding marks and extend the featheredge.
Make sure each visible layer is at least 2-3 cm wide. |

SOLVENT SENSITIVITY TEST

To check sensitivity, take a cloth and wet it with the reducer used in the product to apply.
Place this wet cloth for 1 minute on the featheredge.

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REPAIR PROCESS



Thoroughly clean the surface with the appropriate surface cleaner.



Irradiate by use of Infra-Red for approximately 10 minutes at High Power.



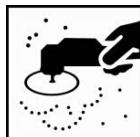
Apply the appropriate polyester body filler, preferably preceded by 1 coat of 2K Epoxy Primer.

Optional: Infrared drying for approximately 5 minutes at Low Power only.



P80 / P180 1st sanding step of the polyester bodyfiller.

P280 2nd sanding step of the polyester bodyfiller,
Use a guide coat for optimal control.

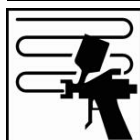


P280 Create a larger featheredge.
P320 Remove all P280 sanding marks

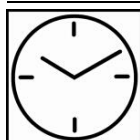
P400 Sand the surrounding area of the repair.



Degrease the sanded area.
When using a waterborne degreaser, avoid contact with the bodyfiller.



Apply the appropriate primer and filler.
To reduce the risk for solvent penetration, apply thinner coats and longer flash-off times.



Drying times according relevant TDS information

Optional:
IR drying using indication in TDS L9.01.01 for Infrared drying times information.

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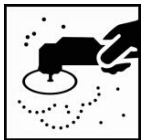
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P320

Block sand to remove the last irregularities of the repair area.



P400-P500

Final sanding step prior to the application of topcoat.



Thoroughly clean the surface with the appropriate surface cleaner.



Basecoat – Clearcoat / Topcoat application.

When applying a solvent borne topcoat system, apply thinner coats to reduce the risk for solvent penetration.



Drying times according relevant TDS information

Optional:

IR drying using indication in TDS L9.01.01 for Infrared drying times information.

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