

# Hail Damage Repair

Technical Bulletin

09/11/2019

L8.06.05 UK &amp; Ireland

## DESCRIPTION

This Bulletin describes the optimum repair system for substrate damages caused by hail.

## PROCESS STEPS

Dent removal should be executed to such an extent that the maximum film build of body filler does not exceed 500 µm.

Spraying Filler application should not be over 300 µm.



Clean the surface thoroughly with an appropriate surface cleaner.  
Next, clean the surface with warm water and detergent, rinse sufficiently with clean water.



P80/P180      Remove existing finish.

P280            Sand a larger featheredge.



Clean the surface thoroughly with an appropriate surface cleaner.



Apply a single coat of 2K Epoxy Primer

**Important:**

Apply a maximum layer thickness of 15 – 25 µm.

To avoid lifting do not apply 2K Epoxy Primer too wet

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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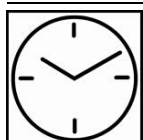
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Allow 5 minutes of flash off before Irradiation with Infrared.

**Recommended:**

5 minutes low power + 10 minutes high power  
50 – 70 cm distance



**Optional:**

45 minutes at 60°C  
or 16 hours at 20°C



P280-P320

Abrade the 2K Epoxy Primer  
Ensuring not to sand through the paint film!



Apply Bodyfiller Universal

Alternatively the below spraying filler



Apply Polyester Spraying Filler

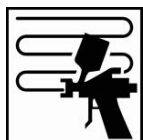
**Important:**

To avoid lifting, first apply a thin coat and flash off for at least 5 minutes.



P180-P280

After drying sand the Bodyfiller Universal or Spraying Filler.

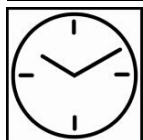


Apply 2K Epoxy Primer according to TDS L2.05.01



**Recommended:**

15 minutes low power, 50 – 70 cm distance  
Temperature should not exceed 90°C.



**Optional:**

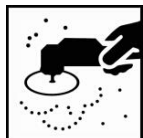
45 minutes at 60°C  
or 16 hours at 20°C

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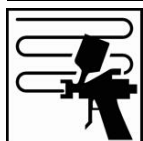
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P320-P400/P500 Sand the 2K Epoxy Primer



Clean the surface thoroughly with an appropriate surface cleaner.



Apply required topcoat according to the respective TDS

## Akzo Nobel Coatings LTD

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Churchward, Southmead Industrial Estate  
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**Tel:** 00 44 (0)1235 862226

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