

Steps	Description	Special notes
1	Degrease the surface to be treated	Lint-free cloth soaked in surface cleaner
2	Sand the area to be electro zinc plated	P280 dry - P400 slightly damp
3	Clean the surface	Damp cloth
4	Dampen the surface with the cap fixed on the anode which is impregnated with zinc solution	
5	Switch on the power supply to the generator (green indicator light on)	
6	Sweep the surface with the anode holder several times	
7	Rinse the treated surface with water	
8	Dry by wiping or using compressed air	

Note:

After use at the end of the day rinse the caps with water.

The speed of the sweeping must be approximately 25 cm/s.



The cap must always be soaked in zinc solution.

If any black patches appear on the treated area, remove them by gently sanding with a grey abrasive finishing pad.

Painting ([see 94A, Paint application range for panels, Steel bodywork component: Preparation and paint range](#)) must be carried out immediately to ensure that the zinc does not oxidise.



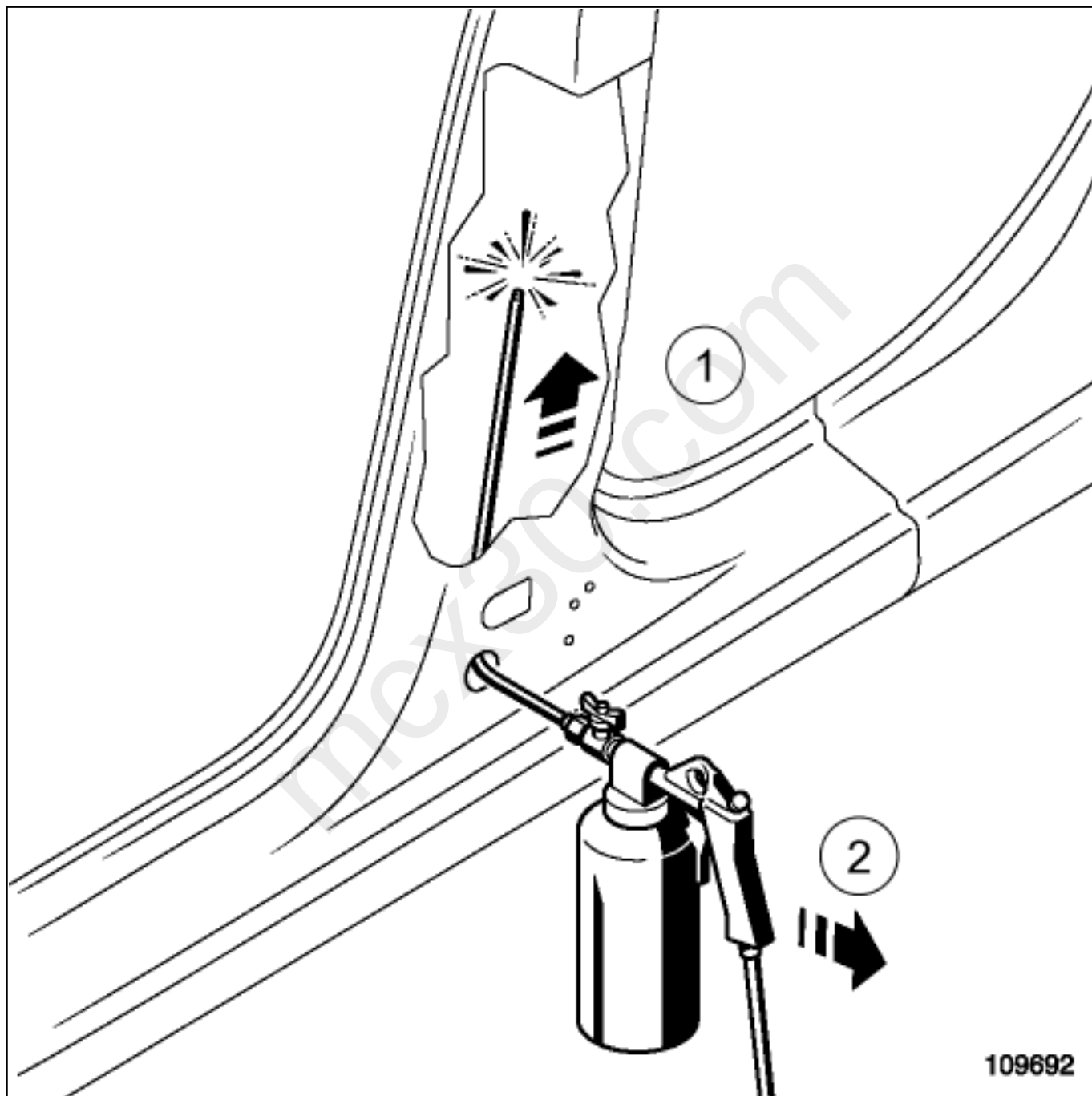
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ANTI-CORROSION PROTECTION OF JOINTS AFTER WELDING

(see 04F, Bodywork products and mountings, Anti-corrosion protection products after assembly: Use)

1. PROTECTION IN A HOLLOW SECTION



(1) Insert the probe as far as possible via the access hole into the hollow section.

(2) Spray the wax moving the probe slowly and regularly back towards the access hole.

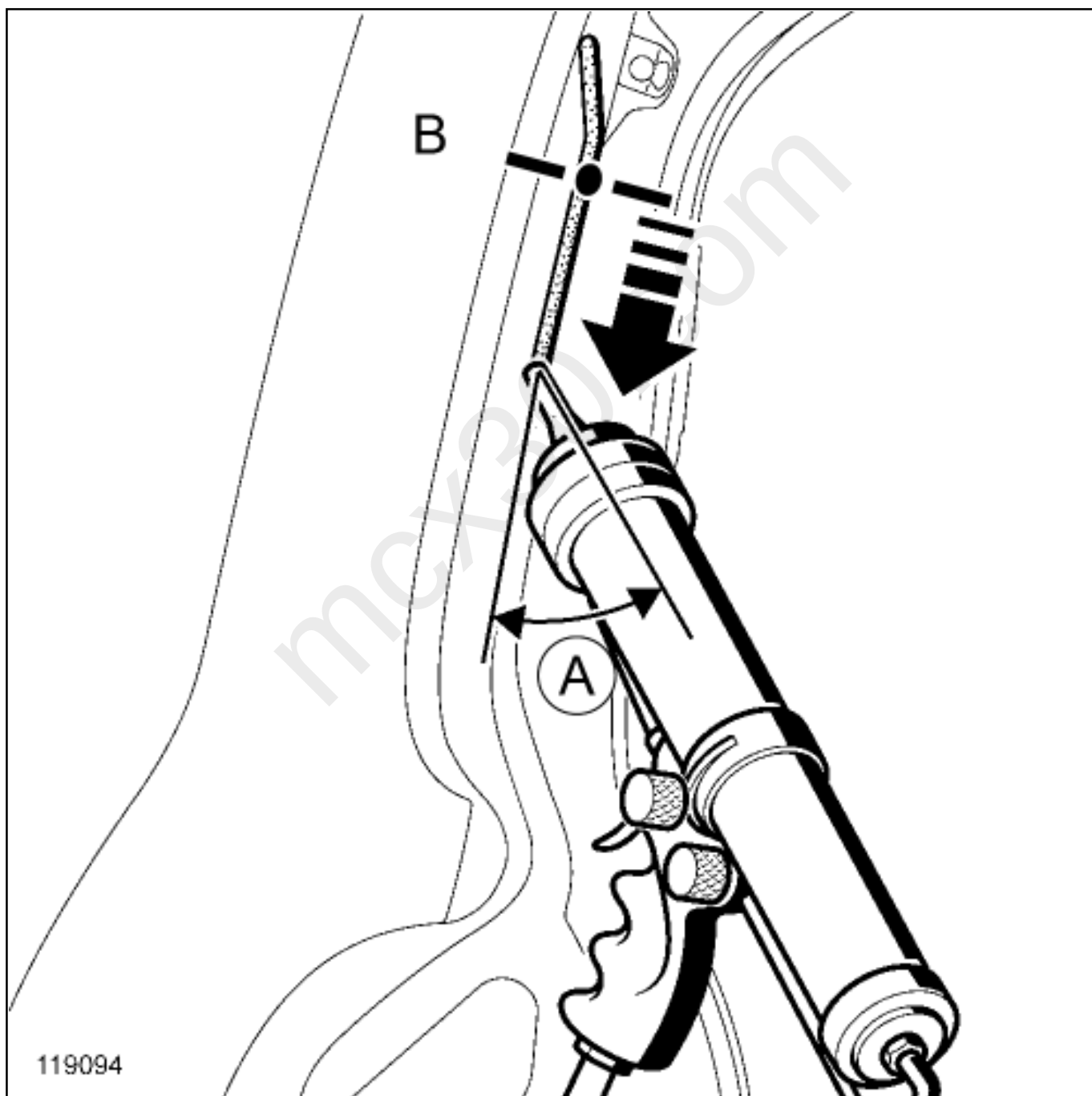
2. PROTECTION ON AN EDGE OR ON A SURFACE

Note:

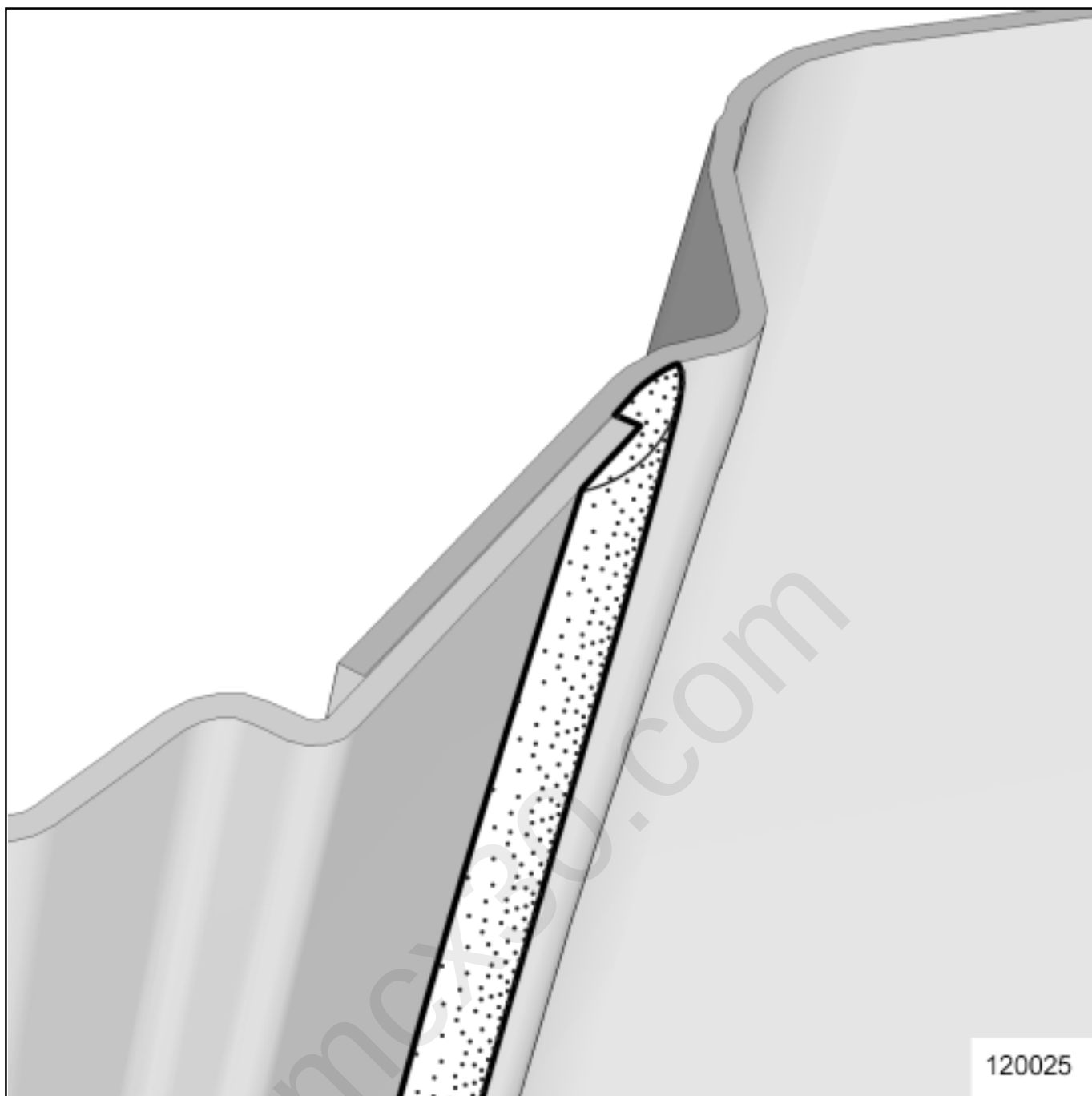


The following operations are to be carried out on machine finished surfaces which have been dry sanded to P3200r scoured with a red abrasive pad.

1- EXTRUDED SEAL



SECTION B

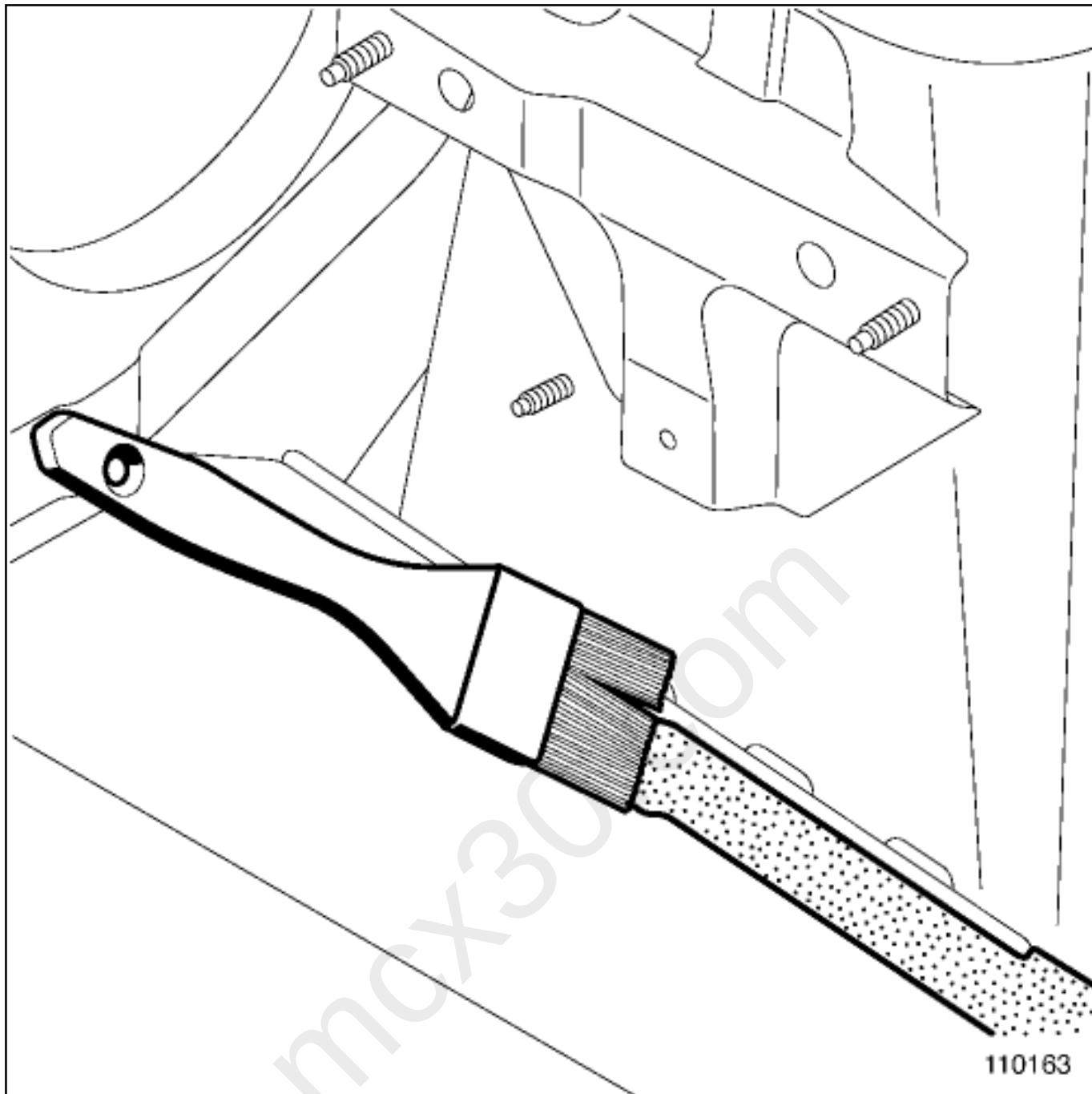


Position the nozzle, which has been previously cut to fit the shape and width of the desired seal, on the edge formed by the panel edge.

The appearance of the seal depends on the application speed and angle(A) of the nozzle in relation to the support.

Extrude the mastic in a uniform bead, observing the original length.

2- BRUSH SEAL



Apply an even seal thickness over the whole area to be treated.

Observing the width and look of the original seal.

3- SPRAYED SEAL