

CAUSES	REMEDIES
Poor cleaning. Support contaminated by humidity. Sanding residues with grease, oil	Make sure the supports are cleaned. Wiping, blowing, degreasing
Support too cold	Heat the support. It must be at ambient temperature before paint application Avoid thermal shocks
The surface deforms or curls during application or drying	Remove the finishing coat of the areas concerned and reapply the paint. If required, remove all the paint and completely reapply on the bare metal



Repair-40x01x37x08-02x21-1-1-1.xml



PAINT: PRECAUTIONS FOR THE REPAIR



Note, one or more warnings are present in this procedure



All painting operations must be carried out in a location designed for these operations (e.g. booths).

The spray booths must comply with the standards currently in force (air speed at 0.40 m/s or above, no measurement below 0.30 m/s).

Periodic maintenance and checking of these facilities ensures their safety and quality.



WARNING

Always wear protective gear (gloves, goggles and breathing masks).

When drying with an infrared device, it is important to respect:

- the distance, time and temperature specified on the product technical sheet. Use a distance thermometer part number: 77 11 237 210.

- the user and safety advice given by the manufacturer of the infrared device.

In the same way as for paintwork, the safety equipment (masks, filter cartridges, gloves, safety goggles, overalls, etc.) for this equipment can be acquired from your local IXELL supplier.

1. BODYWORK ON CNG / NGV VEHICLES

1- BOOTH TEMPERATURE (T):

- if (T) lower or equal to 65°C: the CNG vehicle is permitted without emptying the fuel tank,
- if (T) between 65°C and 80°C: the vehicle is permitted in the booth only if the fuel tank is emptied,
- if (T) greater than 80°C: the CNG vehicle is not permitted in the booth unless the tank has been emptied and removed.

2. BODYWORK ON THE LPG VEHICLES

1- USING A SPRAY BOOTH

■

When a vehicle enters a spray booth, remove the tank as a precaution or carry out flaring and degassing with a flare, then make it inert with a nitrogen flush.

■

If equipment (infrared lamp, etc.) needs to be used for drying mastic, primer or paint, near to the LPG tank, such as during a retouching procedure, it is essential to carry out flaring and degassing of the LPG tank and then to make it inert with a nitrogen flush.



Note:

If working at under 50°C, it will be possible to leave the tank in place, on condition that it is filled to less than 70% of its capacity.

3. HIGH DURABILITY VARNISH

1- RECOMMENDATION

■

When the vehicle comes with original high durability varnish, it is strongly recommended that IXELL IXALIS type anti-scratch varnish is used during the repair.

■

Using this type of varnish guarantees the original function of the high durability varnish.

4. ANTI-CORROSION PROTECTION AFTER DRILLING



Each time a panel is stripped in the workshop when drilling, degrease and wipe the area and then use a fine paintbrush to apply the following:

■

■ A pre-treatment primer,