

Proceed in the reverse order to removal.



Repair-32x04x01x01-01x37-1-173-1.xml



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# STEEL BODYWORK COMPONENT: PREPARATION AND PAINT RANGE



Note, one or more warnings are present in this procedure



## **WARNING**

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

### 1. OXIDISED PANELS

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| Steps | Description                                                          | Special notes                                                                                                                                                             |
|-------|----------------------------------------------------------------------|---------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
| 1     | Strip the oxidised section                                           | <a href="#">Tools for scraping rigid adhesives and paint: Use</a> (40A, General information)                                                                              |
| 2     | Wipe / blow                                                          |                                                                                                                                                                           |
| 3     | Sand the complete repair zone and increase the zone by 150 to 200 mm | P180-P240 dry                                                                                                                                                             |
| 4     | Wipe / blow                                                          |                                                                                                                                                                           |
| 5     | Degrease                                                             | Lint-free cloth soaked in surface cleaner <a href="#">Vehicle: Parts and consumables for the repair</a> (04B, Consumables - Products).<br>Wipe with a dry lint-free cloth |
| 6     | Carry out a cold electro zinc plating on the bare panel              | <a href="#">(see 04E, Paint, Anti-corrosion protection by cold electro zinc plating: Description)</a> (04E, Painting)                                                     |
| 7     | Rinse carefully in clean water                                       |                                                                                                                                                                           |
| 8     | Masking                                                              | Masking paper                                                                                                                                                             |
| 9     | Apply a pre-treatment primer                                         | <a href="#">Vehicle: Parts and consumables for the repair</a> (04B, Consumables - Products)                                                                               |
| 10    | Remove solvent                                                       |                                                                                                                                                                           |
| 11    | Apply a bi component primer                                          | <a href="#">Vehicle: Parts and consumables for the repair</a> (04B, Consumables - Products)                                                                               |
| 12    | Remove solvent / dry                                                 |                                                                                                                                                                           |

|    |                                            |                                                                                                                                                                           |
|----|--------------------------------------------|---------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
| 13 | Sand the primer                            | P400 to P500dry / P400 to P800with water                                                                                                                                  |
| 14 | Sand the whole component                   | P500 to P600dry / P800 to P1000with water                                                                                                                                 |
| 15 | Wipe / blow                                |                                                                                                                                                                           |
| 16 | Degrease                                   | Lint-free cloth soaked in surface cleaner <a href="#">Vehicle: Parts and consumables for the repair</a> (04B, Consumables - Products).<br>Wipe with a dry lint-free cloth |
| 17 | Masking                                    | <a href="#">(see 99A, Special notes on masking, Masking: Description)</a>                                                                                                 |
| 18 | Blow / rub with the abrasive finishing pad |                                                                                                                                                                           |
| 19 | Apply the finishing paint                  |                                                                                                                                                                           |

2. REPAIRED COMPONENTS

1- WITH POLYESTER MASTIC

| Steps | Description                                                          | Special notes                                                                                                                                                             |
|-------|----------------------------------------------------------------------|---------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
| 1     | Sand the mastic                                                      | <a href="#">Panelwork finishing products: Use</a> (40A, General information)                                                                                              |
| 2     | Sand the complete repair zone and increase the zone by 150 to 200 mm | P240 to P280 dry                                                                                                                                                          |
| 3     | Wipe / Blow                                                          |                                                                                                                                                                           |
| 4     | Degrease                                                             | Lint-free cloth soaked in surface cleaner <a href="#">Vehicle: Parts and consumables for the repair</a> (04B, Consumables - Products).<br>Wipe with a dry lint-free cloth |
| 5     | Masking                                                              | Masking paper                                                                                                                                                             |
| 6     | Apply a pre-treatment primer                                         | <a href="#">Vehicle: Parts and consumables for the repair</a> (04B, Consumables - Products)                                                                               |
| 7     | Remove solvent                                                       |                                                                                                                                                                           |
| 8     | Apply a bi component primer                                          | <a href="#">Vehicle: Parts and consumables for the repair</a> (04B, Consumables - Products)                                                                               |
| 9     | Remove solvent / dry                                                 |                                                                                                                                                                           |
| 10    | Sand the primer                                                      | P400 to P500 dry / P400 to P800 with water                                                                                                                                |
| 11    | Sand the whole component                                             | P500 to P600 dry / P800 to P1000 with water                                                                                                                               |
| 12    | Wipe / blow                                                          |                                                                                                                                                                           |

|    |                                            |                                                                                                                                                                           |
|----|--------------------------------------------|---------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
| 13 | Degrease                                   | Lint-free cloth soaked in surface cleaner <a href="#">Vehicle: Parts and consumables for the repair</a> (04B, Consumables - Products).<br>Wipe with a dry lint-free cloth |
| 14 | Masking                                    | <a href="#">(see 99A, Special notes on masking, Masking: Description)</a>                                                                                                 |
| 15 | Blow / rub with the abrasive finishing pad |                                                                                                                                                                           |
| 16 | Apply the finishing paint                  |                                                                                                                                                                           |

## 2- WITHOUT POLYESTER MASTIC

| Steps | Description                                                          | Special notes                                                                                                                                                             |
|-------|----------------------------------------------------------------------|---------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
| 1     | Wipe / blow                                                          |                                                                                                                                                                           |
| 2     | Degrease                                                             | Lint-free cloth soaked in surface cleaner <a href="#">Vehicle: Parts and consumables for the repair</a> (04B, Consumables - Products).<br>Wipe with a dry lint-free cloth |
| 3     | Sand the complete repair zone and increase the zone by 150 to 200 mm | P240 to P280 dry                                                                                                                                                          |
| 4     | Wipe / blow                                                          |                                                                                                                                                                           |
| 5     | Degrease                                                             | Lint-free cloth soaked in surface cleaner <a href="#">Vehicle: Parts and consumables for the repair</a> (04B, Consumables - Products).<br>Wipe with a dry lint-free cloth |
| 6     | Carry out a cold electro zinc plating on the bare panel              | <a href="#">(see 04E, Paint, Anti-corrosion protection by cold electro zinc plating: Description)</a> (04E, Painting)                                                     |
| 7     | Rinse carefully in clean water                                       |                                                                                                                                                                           |
| 8     | Masking                                                              | Masking paper                                                                                                                                                             |
| 9     | Apply a pre-treatment primer                                         | <a href="#">Vehicle: Parts and consumables for the repair</a> (04B, Consumables - Products)                                                                               |
| 10    | Remove solvent                                                       |                                                                                                                                                                           |
| 11    | Apply a bi component primer                                          | <a href="#">Vehicle: Parts and consumables for the repair</a> (04B, Consumables - Products)                                                                               |
| 12    | Remove solvent/dry                                                   |                                                                                                                                                                           |

|    |                                            |                                                                                                                                                                           |
|----|--------------------------------------------|---------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
| 13 | Sand the primer                            | P400 to P500dry / P400 to P800with water                                                                                                                                  |
| 14 | Sand the whole component                   | P500 to P600dry / P800 to P1000with water                                                                                                                                 |
| 15 | Wipe / blow                                |                                                                                                                                                                           |
| 16 | Degrease                                   | Lint-free cloth soaked in surface cleaner <a href="#">Vehicle: Parts and consumables for the repair</a> (04B, Consumables - Products).<br>Wipe with a dry lint-free cloth |
| 17 | Masking                                    | <a href="#">(see 99A, Special notes on masking, Masking: Description)</a>                                                                                                 |
| 18 | Blow / rub with the abrasive finishing pad |                                                                                                                                                                           |
| 19 | Apply the finishing paint                  |                                                                                                                                                                           |

### 3. UNKNOWN SUBSTRATES



Note:

Carry out a lifting test with a solvent thinner[Vehicle: Parts and consumables for the repair](#) (04B, Consumables - Products)

### 1- REACTION TO THE TEST

| Steps | Description                  | Special notes                                                                                |
|-------|------------------------------|----------------------------------------------------------------------------------------------|
| 1     | Strip the damaged undercoats | <a href="#">Tools for scraping rigid adhesives and paint: Use</a> (40A, General information) |
| 2     | ( see repaired components)   |                                                                                              |

| Step | Description           | Special notes |
|------|-----------------------|---------------|
| 1    | ( see new components) |               |

#### 4. NEW COMPONENTS



Note:

Do not damage the cataphoretic coating.

| Steps | Description                                                                                      | Special notes                                                                                                                                                             |
|-------|--------------------------------------------------------------------------------------------------|---------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
| 1     | Wipe / blow                                                                                      |                                                                                                                                                                           |
| 2     | Degrease                                                                                         | Lint-free cloth soaked in surface cleaner <a href="#">Vehicle: Parts and consumables for the repair</a> (04B, Consumables - Products).<br>Wipe with a dry lint-free cloth |
| 3     | Sand the interior of the component                                                               | Red pad                                                                                                                                                                   |
| 4     | Sand the exterior of the component                                                               | P240 dry                                                                                                                                                                  |
| 5     | Wipe / Blow                                                                                      |                                                                                                                                                                           |
| 6     | Degrease                                                                                         | Lint-free cloth soaked in surface cleaner <a href="#">Vehicle: Parts and consumables for the repair</a> (04B, Consumables - Products).<br>Wipe with a dry lint-free cloth |
| 7     | Masking                                                                                          | Masking paper                                                                                                                                                             |
| 8     | Apply a pre-treatment primer if there was elimination of the cataphoretic coating during sanding | <a href="#">Vehicle: Parts and consumables for the repair</a> (04B, Consumables - Products)                                                                               |
| 9     | Remove solvent                                                                                   |                                                                                                                                                                           |
| 10    | Apply a mono or bi component primer on the whole of the component                                | <a href="#">Vehicle: Parts and consumables for the repair</a> (04B, Consumables - Products)                                                                               |
| 11    | Remove solvent/dry                                                                               |                                                                                                                                                                           |
| 12    | Sand the primer                                                                                  | According to the PRODUCT TECHNICAL SHEET                                                                                                                                  |