Metal Department

Pressure wash vehicle before entering repair process
Spray mask entire portion of vehicle not to be worked on
Clean areas to be painted with 541-5
Grind area to be repaired with 80 grit sandpaper
Solvent clean bare metal with 360-4

Apply filler per manufacturers rec.
Initial block sand fill with 80 grit sand paper
Guide coat filler with lacquer aerosol spray
Final sand filler with 150 grit sandpaper
QC’s vehicle (manager to designate person)

Parts Cut-in Process

Check color code & paint
Confirm color with ColorMax chips
Mix color and verify color match
Clean areas to be edged with 541-5
Scuff areas to be painted with gray scuff pad

Final clean areas to be painted with 541-5
Apply one light coat of 801-1552 @ 2::1:30% & allow to flash

Yes
Apply basecoat to coverage
Apply one coat of 923-94 @ 2:1:10% 8x

No
Apply Single stage to coverage

Return parts to metal technician

Copyright © 2003, BASF Corporation
Glasurit

Paint Department

- Paint tech QC’s vehicle, checks for color match and formula
  - Yes: Verify color match with ColorMax & check formula availability
  - No: Initial feather edge surrounding paint area with 180 grit DA
  - Yes: Repaint
  - No: Feather edge with DA 320 grit

- Scuff sand beyond feather edge process with gray scuff pad
- Clean entire area to be refinished w/ 541-5
- Initial mask areas to be primed
- Blow off areas to be primed
- Mix 801-1552 Epoxy 2:1:30% 965-32/2 & 352-50

- Apply one light coat of epoxy primer, flash 15 - 30 minutes
- Mix primer 285-60 4:1:1 929-81 & 352-50
- Apply 3 coats of primer with 1.7 to 1.9 fluid tip (HVLP)
- Guide coat CURED primer with aerosol lacquer primer
- Initial block sand panel with 400 grit sandpaper

- Re-apply light guide coat with aerosol lacquer primer
- Final sand with 500 or 600 grit sandpaper
- Un-mask and blow off vehicle
- Re-mask vehicle & blow off again
- Move vehicle into spray booth, final mask and blow off if necessary

- Final wash area to be painted with 541-5 and tack
  - Yes: Sand with 400 grit DA
  - No: Seal panel with 285-95 0r 285-60 per rec. & flash

- For blending procedure see blend technical manual process!
- Move vehicle from booth, de-mask and return to appropriate dept (.metal or detail). Note, do not de-mask if sanding and buffing is required

- Apply top coat to coverage, blend if necessary & allow to flash
- Apply 2 coats of 923-94 2:1:10% with 929-8x & 352 (3 coats for nib & sand)
- Immediate bake at 145 degrees for 30 minutes
- Move vehicle from booth, de-mask and return to appropriate dept (.metal or detail). Note, do not de-mask if sanding and buffing is required

Copyright © 2003, BASF Corporation

Rev: 8-20-99
**Blending Process**

- Clean panel to be blended with 541-5
- Scuff panel with gray pad and sand fix paste and rinse with water
- Blow off panel final clean panel with 541-5 & tack
- Base coat
  - Yes: Apply one coat 923-155 929-8x & 352-91 @ 2:1:900% (uniform blender)
  - No: Apply thin coats of 22-line to coverage using blending techniques 2:1:30% w 929-8x
- Apply one coat of 923-355 @ 2:1:1 with 929-8x over entire panel
- Move vehicle from booth, de-mask and return to appropriate dept (.metal or detail)

- Base coat
  - Yes: Apply Glasurit basecoat using blending technique
  - No: Apply 2 coats 923-94 w 929-8x & 352-@ 2:1:10%
- Bake immediately at 145 degrees for 30 minutes

**New Unpainted Plastics Process**

- Check color code & paint
- Confirm color with ColorMax chips
- Mix color and verify color match
- Wash with mild detergent & water
- Scuff with gray scuff pad and 541-30
- Final clean with 541-30
- Apply one light coat of 934-0 or 285-0 (per technical recommendations) allow 15 to 20 min. flash
- Bake immediately at 145 degrees 30 minutes
- Apply one coat of 285-95 flexed with 522-111 per rec.
- Base coat
  - Yes: Apply top coat to coverage and flash approx. 15 - 20 min.
  - No: Apply Single flexes w/ 522-111 stage to coverage
- Return parts to appropriate technician

- Apply 2 coats of 923-94 @ flexed with 522-111