



PANEL REPAIR PROCEDURE



APPLICATION

STEP 1: PREPARE THE SURFACE

- Prepare the repair area according to the surface prep guidelines.
- Perform repair using primer and sand, clean and prep for sealing.

STEP 2: APPLY ADHESION PROMOTER

- Sand area for adhesion promoter application with a fine scuff pad and 2311S™ Sanding Paste or 1200-1500 grit. (If you prep the substrate with 2311S™ Sanding Paste, it is crucial to clean immediately with water and wipe dry. Do not allow the scuffing compound to dry. Residual debris from a scuffing compound can cause coating to blister.)
- Follow with First Klean™ 3900S™ Surface Cleaner, Final Klean™ 3901S™ Surface Cleaner, or 3939S™ Lacquer and Enamel Cleaner.

OR

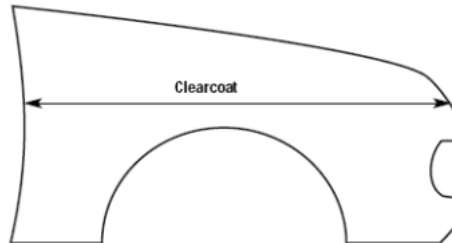
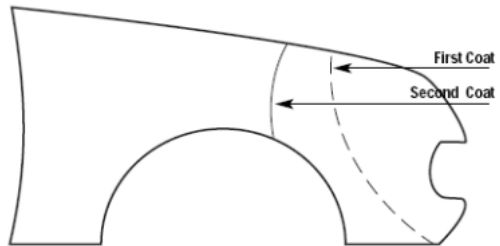
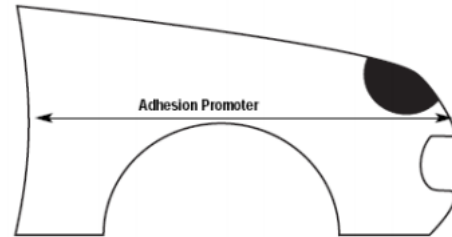
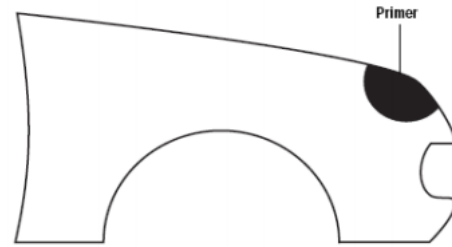
- Clean with 3909S™ Low VOC Surface Cleaner.
- Optionally, wipe entire panel from end to end using the Sontara® PS-39X5S Pre-Saturated Static Control Wipe appropriate for shop conditions.
- Apply adhesion promoter over the sanded and cleaned panel.

STEP 3: APPLY THE BASECOAT

- Apply the first coat of color beyond the repair area. Apply a second coat of color, extending it beyond the first coat.
- Continue until full hiding and color match are achieved.

STEP 4: APPLY THE CLEARCOAT

- Apply 2 coats of clear over the entire panel.





VOC REGULATED AREAS

These directions refer to the use of products which may be restricted or require special mixing instructions in VOC regulated areas. Follow mixing usage and recommendations in the VOC Compliant Products Chart for your area.

SAFETY AND HANDLING

For industrial use only by professional, trained painters. Not for sale to or use by the general public. Before using, read and follow all label and MSDS precautions. If mixed with other components, mixture will have hazards of all components.

Ready to use paint materials containing isocyanates can cause irritation of the respiratory organs and hypersensitive reactions. Asthma sufferers, those with allergies and anyone with a history of respiratory complaints must not be asked to work with products containing isocyanates.

Do not sand, flame cut, braze or weld dry coating without a NIOSH approved air purifying respirator with particulate filters or appropriate ventilation, and gloves.

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