

Vehicles damaged by hail

B 1.1



Process description

This refinishing process is particularly suitable for repairing vehicles damaged by hail. The process is designed to enable professional refinishers to maintain the quality standards of high-grade automotive finishes with outstanding efficiency.

Substrates

- Galvanised steel
- Aluminium
- Steel
- R-M fillers
- Automotive OEM finishes, fully cured and solvent-resistant
- Electro-coated surfaces

Products required

- PK 700 or PK 900 and PK 1000
- STOP UNI
- EUROXY CP
- STOP FILLER
- PERFECTFILLER GREY, PROFILLER, MULTIFILLER CP
- R-M topcoat

Pretreatment



Degreasing
PK 700 or PK 900

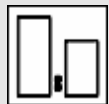


Sanding
P80 / P150



Degreasing
PK 700 or PK 1000

Putty



Mixing ratio

STOP UNI
Hardener

100 g
3 g



Application

Coats:

2 – 3



Drying

20°C
60°C

20 min.
10 min.



Infrared
drying

(short wave)
(medium wave)

4 min. at 50%
6 min.



Sanding





Dry with P80, P150, P240, then degrease with PK 1000.

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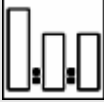




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Sealer

	Mixing ratio	EUROXY CP EUROXY CP Reactive FR 500	100 (vol.) 25 (vol.) 25 (vol.)
	Application	Spraycoats: Film thickness:	1 15 – 20 µm
	Drying	60°C	20 min.
	Infrared drying	(short wave)	11 min. at 100 %

Spray filler






	Mixing ratio	STOP FILLER STOP FILLER Hardener	100 (vol.) 5 (vol.)
	Application	Spraycoats: Film thickness:	3 200 – 300 µm
	Drying	20°C 60°C	4 hours 35 min.
	Infrared drying	(short wave) (medium wave)	8 min. at 50% 10 min.
	Sanding	Dry with P150, P240, then degrease with PK 1000.	

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Filler

	Mixing ratio	PERFECTFILLER GREY D 70 / D 80 FR 500 You may use PROFILLER or MULTIFILLER CP instead of PERFECTFILLER.	100 (vol.) 25 (vol.) 25 (vol.)
	Application	Spraycoats: Film thickness:	2 50 – 70 µm 3 80 – 120 µm
	Drying	20°C 60°C	3 hours 25 min.
	Infrared drying	(short wave) (medium wave)	2 min. at 50% + 5 min. at 100% 12 min.
	Sanding	Dry-sand with P400, then degrease with PK 2000.	

Topcoat

	ONYX HD UNO HD 420	Apply in accordance with the Technical Data Sheet.
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Please refer to the EU Material Safety Data Sheet for product labelling as required by Directive 1999/45/EC and the respective national rules. The products are suitable for professional use only.

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