



OCTORAL

PANEL REPAIR

<p>STEP 1</p> 	<p>PREPARATION</p> <ul style="list-style-type: none"> Inspect small panel damage. Degrease and clean. Cleaning: <ul style="list-style-type: none"> Air blow. 	<p>STEP 2</p> 	<p>COLOUR CHECK</p> <ul style="list-style-type: none"> Option 1: Use the Valspar Spectrophotometer. Option 2: Check for identification plate colour code. Refer to Valspar Color Box. Check for the best match. Mix the formulation in the required quality and quantity. Make spray out for colour match.
<p>STEP 3</p> 	<p>SAND & ROUGH MASK</p> <ul style="list-style-type: none"> Sanding with P120-P240-P320. Clean and degrease. Rough masking application. Clean and degrease once more. Cleaning: <ul style="list-style-type: none"> Air blow and tack rag. 	<p>STEP 4</p> 	<p>ETCH PRIMER APPLICATION</p> <ul style="list-style-type: none"> Apply 1 coat of etch primer on bare metal areas. Flush off for 10 minutes. Cleaning: <ul style="list-style-type: none"> Tack rag.
<p>STEP 5</p> 	<p>SURFACER APPLICATION</p> <ul style="list-style-type: none"> Apply 2-3 coats of surfacer on the repair area. Drying: <ul style="list-style-type: none"> Infra Red or Force drying at 60°C/140°F. 	<p>STEP 6</p> 	<p>SANDING</p> <ul style="list-style-type: none"> Sand the surfacer with P400-P500 with a soft pad. Sand the rest of the panel with a grey pad P1500 or equivalent. Guide coat for each if the sanding steps, removing any imperfections.
<p>STEP 7</p> 	<p>DEGREASE & CLEAN</p> <ul style="list-style-type: none"> Final degreasing and cleaning before basecoat application. Cleaning: <ul style="list-style-type: none"> Air blow Tack rag. 	<p>STEP 8</p> 	<p>BASECOAT APPLICATION</p> <ul style="list-style-type: none"> Apply the basecoat. Flush off sufficiently. Apply the final coat at 1 bar, dropcoat to avoid mottling and for colour match. After final flash off tack rag carefully.
<p>STEP 9</p> 	<p>CLEARCOAT APPLICATION</p> <ul style="list-style-type: none"> Apply clear coat in 1,5 or 2 thin closed layers with flash off. TIP: For light metallic colours, only apply 1 coat of clear over the end of panel if possible to avoid darkening or colour change. 	<p>STEP 10</p> 	<p>DRYING</p> <ul style="list-style-type: none"> Infra Red drying has the preference as that is the most economical and fastest way or Force drying at 60°C/140°F. TIP: Points to take care of when using Infra Red: distance, half or full bake cycle, time & temperature (max 70°C/158°F). Keep enough distance between plastic parts and Infra Red to prevent deformation (check instructions Infra Red).
<p>STEP 11</p> 	<p>POLISHING</p> <ul style="list-style-type: none"> Sand with P2000 or P3000 and polish if required. 	<p>STEP 12</p> 	<p>FINISH</p> <ul style="list-style-type: none"> Hand over vehicle to happy & satisfied customer.