



# AUTOMOTIVE REPAIR PROCESS GUIDE

INDASA provides on a daily basis:

- ▶ High performance abrasive systems and Innovative refinishing solutions
- ▶ Consistency through a compliant repair process
- ▶ Commercial advantage through best working practice
- ▶ Structured programme for enhanced bodyshop profitability

## INDASA ACADEMY

The INDASA ACADEMY represents the commitment and delivery of technical expertise and instruction. Training programmes are tailored to develop the customer's skill base and optimise performance efficiencies in the workplace.

PANEL REPAIR

### 1 Clean panel prior to repair.



**METHOD**  
Remove all dust, dirt and traffic film residue from panel leaving a clean/dry repair area.

**PRODUCT**  
Panel wipe cloth  
Degreaser

### 2 Sand the repair area to prepare for the application of body filler.



**METHOD**  
Machine sand the repair area to a clean, bare metal surface or prepare the OE paint finish if using multi-substrate body filler.

**PRODUCT**  
Rhynogrip HT Line Ultravent disc Grit P80 – P220

**EQUIPMENT**  
Orbital palm sander with 5mm orbit  
Dust extraction

### 3 Prepare the body filler and apply to the repair area.



**METHOD**  
Body filler to be catalysed as per manufacturer's recommended guidelines. Please follow recommended guidelines for cure time and if IR compatible.

### 4 Shape the filler to match the required panel contour.



**METHOD**  
Apply Dry Guide Coat to the filler area then hand sand with dust extraction block to achieve the required shape of repair.

**PRODUCT**  
Rhynogrip HT Line strip Grit P120 – P220  
Dry Guide Coat

**EQUIPMENT**  
Dust extraction block  
Dust extraction

### 5 Machine sand the surrounding areas to achieve a feathered edge.



**METHOD**  
Machine sand the repair area to remove all scratches, leaving a feather edge into the surrounding paintwork.

**PRODUCT**  
Rhynogrip HT Line Ultravent disc Grit P220– P320 (feather edge)

**EQUIPMENT**  
Orbital palm sander with 5mm orbit  
Dust extraction

PREPARATION FOR PRIMER

### 1 Clean the repair and surrounding area.



**METHOD**  
Remove all dust and dirt from panel leaving a clean/dry repair area.

**PRODUCT**  
Panel wipe cloth  
Degreaser

### 2 Protection masking for the panel and repair area.



**METHOD**  
Apply masking tape to the edge of the repair area to protect any adjacent panels.

**PRODUCT**  
Masking tape MTE RED  
Masking Foam Cover Roll

### 3 Thoroughly clean the repair area prior to primer application.



**METHOD**  
Remove all dust/dirt particles from repair area leaving a clean/dry panel surface for priming.

**PRODUCT**  
Low tack cloth

### 4 Apply primer to the repair area.



**METHOD**  
Primer to be catalysed as per manufacturer's recommended guidelines. Please follow recommended guidelines for cure time and if IR compatible.

PREPARATION FOR TOPCOAT

### 1 Apply protection masking to surrounding area.



**METHOD**  
Apply masking tape to the edge of the repair area to protect any adjacent panels.

**PRODUCT**  
Masking tape MTE RED

### 2 Block sand the primed area.



**METHOD**  
Apply Dry Guide Coat then hand sand the repair area, leaving a smooth, primed surface finish.

**PRODUCT**  
Rhynogrip HT Line strip Grit P320 (size to suit)  
Double sided sponges Auto (SF)  
Dry Guide Coat

**EQUIPMENT**  
Dust extraction block  
Dust extraction

### 3 Reapply Dry Guide Coat and machine sand the primed area.



**METHOD**  
Machine sand the primed area to a smooth finish.

**PRODUCT**  
Rhynogrip HT Line Ultravent disc Grit P500

**EQUIPMENT**  
Orbital palm sander with 2,5 mm orbit  
Softform adaptor pad  
Dust extraction

### 4 Prepare the surrounding blend area.



**METHOD**  
Machine sand the area to be blended for clear coat. Hand sand any edges and awkward areas.

**PRODUCT**  
Rhynogrip HT Line Ultravent disc Grit P800-P1000 (size to suit)  
Double sided sponges Auto (UF)

**EQUIPMENT**  
Orbital palm sander with 2,5mm orbit  
Softform adaptor pad  
Dust extraction

### 5 Mask before paint.



**METHOD**  
Mask and protect the car before it goes into the spray booth to apply topcoat.

**PRODUCT**  
Trim masking tape  
MTE RED Masking tape  
Masking Foam Cover Roll

### 6 Thoroughly inspect, clean the panel repair area and apply the topcoat.



**METHOD**  
Remove all dust/dirt particles from repair area leaving a clean/dry panel surface for painting. Before spraying degrease as per manufacturer's guidelines and tack wipe the entire area to be painted.

**PRODUCT**  
Low tack cloth

PAINT RECTIFICATION AND POLISH

### 1 Remove any paint imperfections (nibs) from the paint surface.



**METHOD**  
For small areas denib by hand. Machine sand large areas.

**PRODUCT**  
Rhynostick MFS daisy discs  
Rhynogrip Film Line disc Grit P1500 (size to suit)

**EQUIPMENT**  
Orbital palm sander with 2,5 mm orbit  
Softform adaptor pad  
Dust extraction

### 2 Prepare the surface area for compounding.



**METHOD**  
Machine sand the area to remove all traces of sanding marks in the surface.

**PRODUCT**  
Rhynocell disc. Grit MF3000 (size to suit)

**EQUIPMENT**  
Orbital palm sander with 2,5 mm orbit  
Dust extraction

### 3 Machine compound the repair area.



**METHOD**  
Low speed polisher with compound to remove all traces of sanding marks and to leave gloss finish.

**PRODUCT**  
Autogloss Compound Plus  
Autogloss Mop (white)

**EQUIPMENT**  
E-Series electric rotary polisher

### 4 Polish the panel to a showroom gloss finish.



**METHOD**  
Low speed polisher with liquid polish to remove swirl marks and to produce high gloss finish.

**PRODUCT**  
Autogloss High-Gloss Plus  
Autogloss Mop (black)

**EQUIPMENT**  
E-Series electric orbital polisher

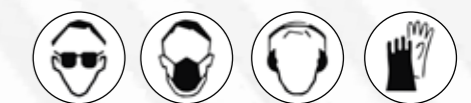
### 5 Remove all residue to a flawless finish.



**METHOD**  
Clean the surface to a high gloss finish.

**PRODUCT**  
Microfibre cloth (blue)

Health and safety compliance is required for all processes.



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