

# Audurra Plastic Repair process.



**01**  
STEP

Clean and pre-treat the repair area using Audurra Plastic Repair Cleaner.



**02**  
STEP

**Pretreatment of the damaged areas**

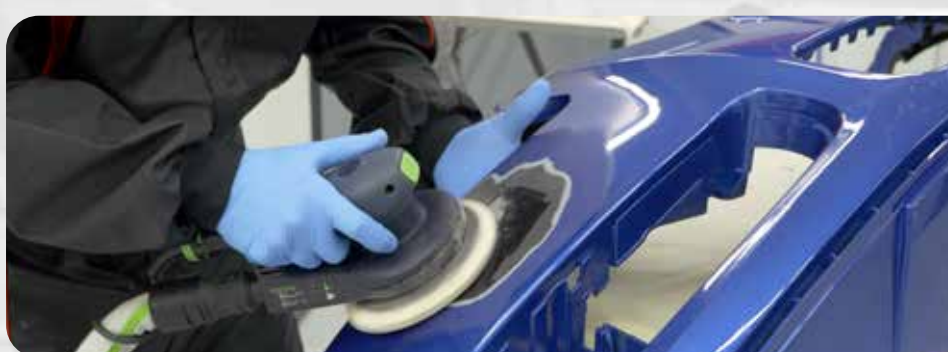
Drill 4-6mm hole at the end of any cracks to prevent the crack spreading and increase the bonding area.



**03**  
STEP

**Crack preparation**

Sand a groove into the front face edges of the repair area to widen the bonding surface.



**04**  
STEP

**Sanding**

Sand both faces with Audurra P150-180 sanding disk. Don't forget to also sand the back of the damaged area. Clean both sides of repair with Audurra Plastic Repair Cleaner.



**05**  
STEP

**Prepare fibre mesh**

Adjust the mesh to the desired size and cut a piece of fibre mesh larger than the damage.



**06**  
STEP

**Primer application**

Spray a thin coat of Audurra Plastic Repair Primer onto both sides (front and back). Flash off time is 10 min at room temperature.



**07**  
STEP

**Preparation of the cartridge**

Open the cartridge and squeeze out a small amount of material until both adhesive components run equally. Apply the mixing nozzle and discard the first 5 cm of the mixed adhesive.



**08**  
STEP

**Application back**

Apply Audurra Plastic Repair adhesive to the back of the repair area. Place the Audurra Reinforcing Fabric into the damaged area and press it down into the adhesive with a spreader. Select color and curing time as recommended in Technical data sheet.



**09**  
STEP

**Application Front**

Apply Audurra Plastic Repair adhesive to the front of the repair. Smooth out with a spreader.



**10**  
STEP

**Curing**

I.R. lamp can be used to accelerated curing process. Maximum 50°C and minimum 5 minutes.



**11**  
STEP

**Surface Preparation (1/2)**

Sand and shape the repair area with P150 to start and use finer grades to refine the surface.



**12**  
STEP

**Surface Preparation (2/2)**

Plastic stopper can be used to finalise the repair to start your Axalta refinish process.