

Major Repair Process - Metal



STEP 1: Clean with **Permaloid® Silicone Remover 7010**. Sand damaged areas with **Audurra Premium Disc A**. Clean again with **Permaloid® Silicone Remover 7010**.



STEP 2: Apply putty. Sand with **Hand Block** and **Premium Strip A&B**. Use **Audurra Dry Guide Coat** during all sanding steps. Use: e.g. **Raderal® IR Premium Putty 2035**.



STEP 3: Reapply putty to fill pinholes and imperfections if needed. Sand with **Hand Block** and **Premium Strip B**. Use **Audurra Dry Guide Coat** during all sanding steps.



STEP 4: Feather edge sanding with machine sanding and **Audurra Premium Disc B** and then prepare repair area with **Disc C**. Hand sand corners and edges with **Audurra Soft Roll C**.



STEP 5: Apply a suitable Spies Hecker wash primer e.g. **Priomat® Wash Primer 4075**. Flash off. Apply a Spies Hecker high build surfacer e.g. **Permasolid® HS Performance Surfacer 5320**.



STEP 6: Apply **Audurra Dry Guide Coat**, Sand repair areas with hand block with **Premium Strip C**.



STEP 7: Hand sand corners and edges with **Audurra Soft Roll E**. Sand remaining surface with random orbital sander and **Audurra Premium Disc D**. Remove sanding dust and clean before masking.



Comment: To fulfill certain OEM requirements pre coating of bare metal before putty/polyester application may be necessary. Please refer to OEM specific guidelines. Due to the wide variety of e-coats present on the market, its quality can differ a lot. For this reason preferably scuff sand the e-coat. Follow relevant Spies Hecker product TDS's.

This Major Repair Process for Metal Parts has been performed using products from the Spies Hecker product range.



Spies Hecker – simply closer.

