

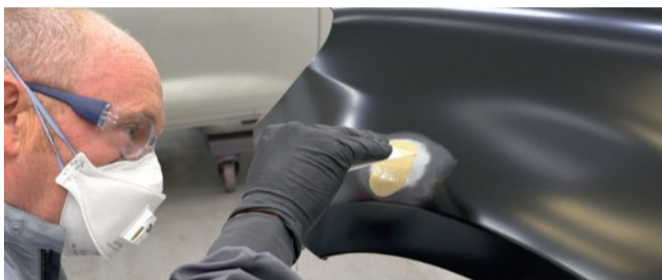
New Part Sanding Process - Metal



STEP 1: Clean and inspect panel. Use Permaloid® Silicone Remover 7010 and Audurra Degreasing Cloth.



STEP 2: If required, sand with Audurra Premium Sanding Disc C to remove imperfections. If putty needs to be applied, sand these areas with Audurra Premium Sanding Disc B. If there are no imperfections or damage, go to step 5.



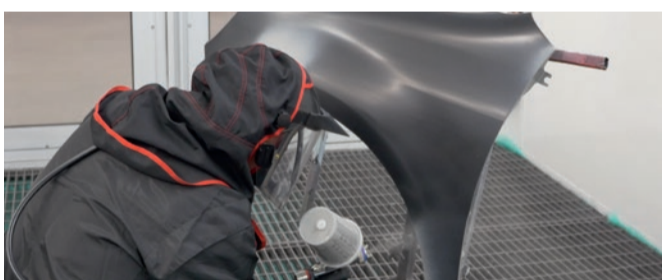
STEP 3: Clean and apply putty if needed. Use: e.g. Raderal® IR Premium Putty 2035.



STEP 4: Sand putty with Hand Block and Audurra Premium Sanding Strip B, and then with Audurra Premium Strip C. Use Audurra Dry Guide Coat during all sanding steps. Resand damaged areas with Audurra Premium Disc C.



STEP 5: Scuff sand entire panel with Audurra Fleece Pad very fine (red)*.



STEP 6: Clean panel and apply Permasolid® HS Vario Primer Surfacer 5340 to full panel. Dry.



STEP 7: Hand block putty areas with Audurra Premium Strip C, when needed. Use Audurra Dry Guide Coat between sanding steps. If there are no imperfections or damage go to step 8.



STEP 8: Sand edges and corners with Audurra Soft Roll E, then sand remaining surface with orbital sanding machine and Audurra Premium Disc D. Remove sanding dust and clean panel.



*Due to the wide variety of electrocoats 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 New Panel Sanding Process for Metal has been performed using products from the Spies Hecker product range.



Spies Hecker – simply closer.

