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Process Steps		Products		
1	 Degrease the entire panel <ul style="list-style-type: none"> Wash panel prior to repair. After degreasing allow surface to flash-off for 5 minutes <i>Degreasing supports good adhesion and prevents blistering and cratering</i>	nax Pro LV Universal Degreaser		
2	 Remove scratch with P240 then feather with P320 grit dry. <ul style="list-style-type: none"> Blow off dust after sanding <i>Proper sanding will prevent later visible sanding scratches and contour mapping</i>	P240 P320		
3	 Degrease the area to be primed <ul style="list-style-type: none"> After degreasing allow surface to flash-off for 5 minutes <i>Degreasing supports good adhesion and prevents blistering and cratering</i>	nax Pro LV Universal Degreaser		
→ Go to Primer Surfacer Application				

Dent - Surface preparation

Process Steps		Products		
1	 Degrease the entire panel <ul style="list-style-type: none"> Wash panel prior to repair. After degreasing allow surface to flash-off for 5 minutes <i>Degreasing supports good adhesion and prevents blistering and cratering</i>	nnax Pro LV Universal Degreaser		
2	 1. Remove coating at the dent with P120 grit dry. 2. Feather edge with P240 grit dry. <ul style="list-style-type: none"> Blow off dust after sanding <i>Proper sanding will prevent later visible sanding scratches and contour mapping</i>	P120 P240		
3	 Degrease the area of bodyfiller application <ul style="list-style-type: none"> After degreasing allow surface to flash-off for 5 minutes <i>Degreasing supports good adhesion and prevents blistering and cratering</i>	nax Pro LV Universal Degreaser		
4	 To achieve the highest quality Apply 1 coat of epoxy primer on open bare metal area <ul style="list-style-type: none"> Flash-off for 10 minutes at 20°C prior to surfacer application <i>Provides corrosion protection and adhesion to substrate and to subsequent layers</i>	nax Pro LV1101 DTM Epoxy Spot Sealer or nax Pro LV3200 Epoxy Primer Surfacer		
5	 Apply polyester bodyfiller/putty <ul style="list-style-type: none"> Allow bodyfiller to dry for 15 minutes prior to sanding <i>Proper application saves product and helps easy and faster sanding</i>	nax Pro LV2000 Lightweight Filling Putty nax Pro Multifunctional Lightweight Bodyfiller		
6	 Level down the polyester body filler with hand block P120 → P240 grit dry <ul style="list-style-type: none"> Blow off dust after sanding <i>Correct block sanding will ensure a flat and smooth surface</i>	P120 P240		
7	 Finish sanding with P320 grit dry Check for pinholes and fill with knifing filler <ul style="list-style-type: none"> Blow off dust after sanding <i>Using spot filler before surfacer will prevent pinholes after topcoat application</i>	P320 nax Pro LV Spot Filler		
9	 Degrease the area to be primed <ul style="list-style-type: none"> After degreasing allow surface to flash-off for 5 minutes <i>Degreasing supports good adhesion and prevents blistering and cratering</i>	nax Pro LV Universal Degreaser		
→ Go to Primer Surfacer Application				

Primer Surfacer Application

Process Steps		Products		
1	 Apply 2-3 coats of surfacer <div> Curing time: 2800HP: 30 min.@20°C / 2600 Premium: 2hrs@20°C </div> <ul style="list-style-type: none"> Flash off for 5-10 between coats <i>Light first coat prevents lifting and cracking of the system</i>	nax 2800 HP Velocity Primer or nax 2600 Premium Primer		
2	 Finish primer surfacer with: P500 and blend area with P800 dry <ul style="list-style-type: none"> Blow dust off after sanding <i>Proper sanding will ensure a flat and smooth surface and support high gloss finish</i>	P500		
3	 Degrease the entire panel <ul style="list-style-type: none"> After degreasing allow surface to flash-off for 5 minutes <i>Degreasing supports good adhesion and prevents blistering and cratering</i>	nax Pro LV Universal Degreaser		

For detailed product information always refer to TDS