

Car-body Panel

Scratch - Surface preparation

			ce preparation	
		Process Steps	Products	
1		 Degrease the entire panel Wash panel prior to repair. After degreasing allow surface to flash-off for 5 minutes Degreasing supports good adhesion and prevents blistering and cratering 	nax Pro LV Universal Degreaser	
2		 Remove scratch with P240 then feather with P320 grit dry. Blow off dust after sanding Proper sanding will prevent later visible sanding scratches and contour mapping 	P240 P320	
3		 Degrease the area to be primed After degreasing allow surface to flash-off for 5 minutes Degreasing supports good adhesion and prevents blistering and cratering 	nax Pro LV Universal Degreaser	
\rightarrow	Go to Primer	Surfacer Application		
		Dent - Surface	preparation	
		Process Steps	Products	
1		 Degrease the entire panel Wash panel prior to repair. After degreasing allow surface to flash-off for 5 minutes Degreasing supports good adhesion and prevents blistering and cratering 	nnax Pro LV Universal Degreaser	
2		 Remove coating at the dent with P120 grit dry. Feather edge with P240 grit dry. Blow off dust after sanding Proper sanding will prevent later visible sanding scratches and contour mapping 	P120 P240	
3		 Degrease the area of bodyfiller application After degreasing allow surface to flash-off for 5 minutes Degreasing supports good adhesion and prevents blistering and cratering 	nax Pro LV Universal Degreaser	
4		To achieve the highest quality Apply 1 coat of epoxy primer on open bare metal area Flash-off for 10 minutes at 20°C prior to surfacer application Provides corrosion protection and adhesion to substrate and to subsequent layers	nax Pro LV1101 DTM Epoxy Spot Sealer or nax Pro LV3200 Epoxy Primer Surfacer	
5		 Apply polyester bodyfiller/putty Allow bodyfiller to dry for 15 minutes prior to sanding Proper application saves product and helps easy and faster sanding 	nax Pro LV2000 Lightweight Filling Putty nax Pro Multifunctional Lightweight Bodyfiller	
6	e	Level down the polyester body filler with hand block P120 → P240 grit dry ► Blow off dust after sanding Correct block sanding will ensure a flat and smooth surface	P120 P240	
7		Finish sanding with P320 grit dry Check for pinholes and fill with knifing filler ▶ Blow off dust after sanding Using spot filler before surfacer will prevent pinholes after topcoat application	P320 nax Pro LV Spot Filler	
9		 Degrease the area to be primed After degreasing allow surface to flash-off for 5 minutes Degreasing supports good adhesion and prevents blistering and cratering 	nax Pro LV Universal Degreaser	

Primer Surfacer Application

	Process Steps
Apply 2-3 coats of surfacer	
Curing time:	2800HP: 30 min.@20

20°C / 2600 Premium: 2hrs@20°C

Products





3

Flash off for 5-10 between coats

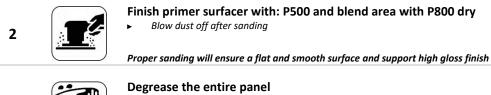
Light first coat prevents lifting and cracking of the system

or nax 2600 Premium Primer

P500

nax 2800 HP Velocity Primer





After degreasing allow surface to flash-off for 5 minutes

Degreasing supports good adhesion and prevents blistering and cratering

For detailed product information always refer to TDS

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