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Process Steps		Products	
1	 <p><b>Degrease the entire panel</b></p> <ul style="list-style-type: none"> <li>Wash panel prior to repair.</li> <li>After degreasing allow surface to flash-off for 5 minutes</li> </ul> <p><i>Degreasing supports good adhesion and prevents blistering and cratering</i></p>	nax Pro LV Universal Degreaser	 
2	 <p><b>1. Remove coating at the damaged area with P120 grit dry.</b></p> <p><b>2. Feather edge with P240 grit dry.</b></p> <ul style="list-style-type: none"> <li>Blow off dust after sanding</li> </ul> <p><i>Proper sanding will prevent later visible sanding scratches and contour mapping</i></p>	P120 P240	 
3	 <p><b>Degrease the area of bodyfiller application</b></p> <ul style="list-style-type: none"> <li>After degreasing allow surface to flash-off for 5 minutes</li> </ul> <p><i>Degreasing supports good adhesion and prevents blistering and cratering</i></p>	nax Pro LV Universal Degreaser	 
4	 <p><b>For best adhesion apply 1 coat of plastic adhesion primer</b></p> <p>Recoating time: After 15 minutes flash of and within 24 hour</p> <ul style="list-style-type: none"> <li>In case of exceeding recoating time, surface must be primed again</li> </ul> <p><i>Use of plastic primer prevents long term adhesion failure</i></p>	nax Pro LV1001 Plastic Primer 1K or nax Plastic Primer 1K	 
5	 <p><b>Apply polyester bodyfiller/putty</b></p> <ul style="list-style-type: none"> <li>Allow bodyfiller to dry for 15 minutes prior to sanding</li> </ul> <p><i>Proper application saves product and helps easy and faster sanding</i></p>	nax Pro LV2000 Lightweight Filling Putty nax Pro Multifunctional Lightweight Bodyfiller	 
6	 <p><b>Level down the polyester body filler with hand block</b></p> <p><b>P120 → P240 grit dry</b></p> <ul style="list-style-type: none"> <li>Blow off dust after sanding</li> </ul> <p><i>Correct block sanding will ensure a flat and smooth surface</i></p>	P120 P240	 
7	 <p><b>Finish sanding with P320 grit dry</b></p> <p><b>Check for pinholes and fill with spot putty</b></p> <ul style="list-style-type: none"> <li>Blow off dust after sanding</li> </ul> <p><i>Using spot filler before surfacer will prevent shrinking after topcoat application</i></p>	P320 nax Pro LV Spot Filler	 
8	 <p><b>Degrease the area to be primed</b></p> <ul style="list-style-type: none"> <li>After degreasing allow surface to flash-off for 5 minutes</li> </ul> <p><i>Degreasing supports good adhesion and prevents blistering and cratering</i></p>	nax Pro LV Universal Degreaser	 

## Primer / Surfacer Application

Process Steps		Products	
8	 <p><b>Apply 1 coat of plastic adhesion primer</b></p> <p>Recoating time: After 15 minutes flash of and within 24 hour</p> <ul style="list-style-type: none"> <li>In case of exceeding recoating time, surface must be primed again</li> </ul> <p><i>Use of plastic primer prevents long term adhesion failure</i></p>	nax Pro LV1001 Plastic Primer 1K or nax Plastic Primer 1K	 
9	 <p><b>Apply 2-3 coats of surfacer</b></p> <p>Curing time: 2800HP: 30 min.@20°C / 2600 Premium: 2hrs@20°C</p> <ul style="list-style-type: none"> <li>Flash off for 5-10 between coats</li> </ul> <p><i>Light first coat prevents lifting and cracking of the system</i></p>	nax 2800 HP Velocity Primer or nax 2600 Premium Primer	 
10	 <p><b>Finish primer surfacer with: P400</b></p> <ul style="list-style-type: none"> <li>Blow dust off after sanding</li> </ul> <p><i>Proper sanding will ensure a flat and smooth surface and support high gloss finish</i></p>	P500	 
11	 <p><b>Degrease the entire panel</b></p> <ul style="list-style-type: none"> <li>After degreasing allow surface to flash-off for 5 minutes</li> </ul> <p><i>Degreasing supports good adhesion and prevents blistering and cratering</i></p>	nax Pro LV Universal Degreaser	 

For detailed product information always refer to TDS