













Surface preparation

Process Steps		Products
1	 <p>Degrease the entire panel</p> <ul style="list-style-type: none"> ▶ Make sure vehicle is washed prior to repair. ▶ After degreasing allow surface to flash-off for 5 minutes <p><i>Degreasing supports good adhesion and prevents blistering and cratering</i></p>	<p>nax Pro LV Universal Degreaser</p>  
2	 <p>Clean edges around the welding with P120 grit dry.</p> <p>Feather edge with P240 grit dry.</p> <ul style="list-style-type: none"> ▶ Blow off dust after sanding <p><i>Proper sanding will prevent later visible sanding scratches and contour mapping</i></p>	<p>P120 P240</p>  
3	 <p>Degrease the repair area</p> <ul style="list-style-type: none"> ▶ After degreasing allow surface to flash-off for 5 minutes <p><i>Degreasing supports good adhesion and prevents blistering and cratering</i></p>	<p>nax Pro LV Universal Degreaser</p>  
4	 <p>To achieve the highest quality</p> <p>Apply 1 coat of primer to seal of the welded and bare metal areas</p> <ul style="list-style-type: none"> ▶ Flash-off for 30 minutes prior to application of polyester bodyfiller <p><i>Provides corrosion protection and adhesion to substrate and to subsequent layers</i></p>	<p>nax Pro LV1101 DTM Epoxy Spot Sealer or nax Pro LV3200 Epoxy Primer Surfacer</p>  
5	 <p>Apply polyester bodyfiller/putty</p> <ul style="list-style-type: none"> ▶ Allow bodyfiller to dry completely prior to sanding <p><i>Proper application saves product and helps easy and faster sanding</i></p>	<p>nax Pro LV2000 Lightweight Filling Putty nax Pro Multifunctional Lightweight Bodyfiller</p>  
6	 <p>Level down the polyester body filler with hand block</p> <p>P120 → P240 grit dry</p> <ul style="list-style-type: none"> ▶ Blow off dust after sanding 	<p>P120 P240</p>  
7	 <p>Feather edge with P320 grit dry</p> <p>Check for pinholes and fill with knifing filler</p> <ul style="list-style-type: none"> ▶ Blow off dust after sanding <p><i>Using spot filler before surfacer will prevent shrinking after topcoat application</i></p>	<p>P320</p> <p>nax Pro LV Spot Filler</p>  
8	 <p>Degrease the area to be primed</p> <ul style="list-style-type: none"> ▶ After degreasing allow surface to flash-off for 5 minutes <p><i>Degreasing supports good adhesion and prevents blistering and cratering</i></p>	<p>nax Pro LV Universal Degreaser</p>  

Primer / Surfacer Application

Process Steps		Products
9	 <p>To achieve the highest quality</p> <p>Apply 1 coat of epoxy primer on open bare metal area</p> <ul style="list-style-type: none"> ▶ Flash-off for 15 minutes prior to surfacer application <p><i>Provides corrosion protection and adhesion to substrate and to subsequent layers</i></p>	<p>nax Pro LV1101 DTM Epoxy Spot Sealer or nax Pro LV3200 Epoxy Primer Surfacer</p>  
10	 <p>Apply 2-3 coats of surfacer</p> <p>Curing time: 2800HP: 30 min.@20°C / 2600 Premium: 2hrs@20°C</p> <ul style="list-style-type: none"> ▶ Flash off for 5-10 between coats and 10 min. before baking <p><i>Light first coat prevents lifting and cracking of the system</i></p>	<p>nax 2800 HP Velocity Primer or nax 2600 Premium Primer</p>  
11	 <p>Finish primer surfacer with: P500 and blend area with P800 dry</p> <ul style="list-style-type: none"> ▶ Blow dust off after sanding <p><i>Proper sanding will ensure a flat and smooth surface and support high gloss finish</i></p>	<p>P500 P800</p>  
12	 <p>Degrease the entire panel</p> <ul style="list-style-type: none"> ▶ After degreasing allow surface to flash-off for 5 minutes <p><i>Degreasing supports good adhesion and prevents blistering and cratering</i></p>	<p>nax Pro LV Universal Degreaser</p>  
→	Note: Proceed to wet on wet surfacer application when required (see Topcoat Application SOP)	

For detailed product information always refer to TDS