

Hail Damage Repair

FOR PROFESSIONAL USE ONLY

Description

This Bulletin describes the optimum repair system for substrate damages caused by hail.

Process Steps

Dent removal should be executed to such an extent that the maximum film build of body filler does not exceed 500 µm. Polysurfacer application should not be over 300 µm.



Remove surface contamination using the appropriate surface cleaner.
 Next, clean the surface with warm water and detergent, rinse sufficiently with clean water.



P80/P120 Remove the existing finish.
 P220 Sand a larger featheredge with P220 grit.



Remove surface contamination using the appropriate surface cleaner.



Apply a single coat of Primer Surfacer EP

Important:

- Apply a maximum layer thickness of 25 µm.
- To avoid lifting do not apply Primer Surfacer EP too wet. See TDS S2.04.3



Recommended:
 5 minutes low power 10 minutes high power 50-70 cm distance

Allow 5 minutes flash-off prior to infra red curing
 Temperature should not exceed 100°C.



Optional:
 45 minutes at 60°C or 16 hours at 20°C



P220-P320 Abrade the Primer Surfacer EP.
 ➤ Do not sand through the Primer Surfacer EP.
 ➤ Apply the appropriate polyester bodyfiller or Polysurfacer

Important: In case of using Polysurfacer, first apply a thin coat to avoid lifting and flash off for at least 5 minutes, before applying the next coat. See TDS S3.05.01

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Process steps (continued)

After drying, sand the polyester bodyfiller or Polysurfacer with P120-P220 grit.

Important:

- After sanding, the maximum film build of body filler should not exceed 500 µm.
- Polysurfacer application should not be over 300 µm.



Important: Sikkens Polysurfacer should not be applied to bare metal.

Therefore it is advised to proceed with a single coat of Primer Surfacer EP and dry as described before.

Apply Primer Surfacer EP



Note: It is advised when Autowave 2.0 is used as a topcoat it should be preceded with Colorbuild Plus Primer Surfacer Sanding or Non Sanding.

Recommended:

15 minutes Low power, 50 – 70 cm distance.
 Temperature should not exceed 90°C.



Optional:

45 minutes at 60°C or 16 hours at 20°C



After drying sand the Primer Surfacer EP with P320-P400/P500 grit.



Remove surface contamination using the appropriate surface cleaner



Apply required topcoat according to the respective TDS



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Akzo Nobel Pty Ltd T/A Akzo Nobel Car Refinishes Australia
Address: Unit 3/344 Lorimer Street, Port Melbourne, VICTORIA, 3207
Tel: +61 3 9644 1711

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Head Office

AkzoNobel Car Refinishes B.V., PO Box 3 2170 BA Sassenheim, The Netherlands. www.sikkenscr.com