







Classic Car – Repair process for steel and galvanised steel





Description: Refinishing process for the restoration of classic cars
Coating of body panels that are blasted, pickled or sanded down to the bare metal

Cleaning	360-4 Glasurit® Metal cleaner			Sand damaged areas down to the bare metal		700-10 Glasurit® Degreasing and Cleansing Agent		
		1x	Wipe dry		P16 - P150, pickling or blasting		1x	Wipe dry

- The bare metal areas must be primed with 285-270 Glasurit Primer Filler PRO before applying 1006-26 Glasurit UP Spray Filler grey
- Alternatively, an increased corrosion protection can be achieved by the use of 360-100 Glasurit® PRO Active Wipes.
- If the vehicle will stand in the shop for a longer time before being refinished, the bare panels should be primed at first with Glasurit Primer Filler PRO 285-270 in order to avoid flash rust

Primer filler	285-270 Glasurit® Primer Filler PRO	929-58 Glasurit® Hardener	352-91, -216 Glasurit® Reducer						
				5 : 1 : 1	HVLP 1.3 - 1.7 mm 2.0-3.0 bar	1 10 - 20 µm	60°C 15 min.	10 Min.	Pad

If there are still welding operations to be carried out:

Primer only for the welding area	183-153 Glasurit® Shop Primer	352-50 Glasurit® Reducer				
			4:1 mixing stick	HVLP 1.4-1.7 mm 2.0-3.0 bar	1-2 20-25 µm	10 min at 20°C

Alternatively: 183-30 Glasurit® 1K Anti-corrosive Primer, red-brown

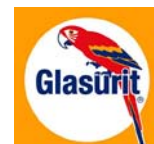
- Use only primers with welding certificate.
- After welding, before starting to apply the body filler, remove the 183-153 Glasurit Shop Primer or the 183-30 Anti-corrosive Primer, red-brown.

- After a longer waiting time, the area must be cleaned with 541-5 Glasurit Wax and Silicone Remover
- The repair process can be continued without scuff-sanding

Please refer to the EU Material Safety Data Sheet for product labelling as required by Directive 1999/45/EC and the respective national rules. The products are suitable for professional use only.





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




Classic Car – Repair process for steel and galvanised steel

Small damaged areas

Body filler	839-20/-20K Glasurit® Multi-Purpose Body Filler	948-36 Glasurit® Hardener Paste, red	 + 2-3%	 20-30 min at 20°C	 3-5 min	 P80/P150 coarse sanding








Larger damaged areas

Polyester spray filler	1006-26 Glasurit® UP Spray Filler	948-22 Glasurit® Hardener	 1400 : 50	 2.5-3.0 mm 2.0-3.0 bar	 3-5 150-300 µm	 3-4 h at 20°C 30 min at 60°	 10 min	 P150 coarse sanding P240-P320 fine sanding

Remarks: If spray filler thicknesses of > 300 µm are required, a second spray filler coat can be applied after drying of the first coat without intermediate sanding

- The primer filler must be applied within 24 hours. Otherwise, the inclusion of humidity can cause cracking in the following paint system

Clean the surface with 700-10 Glasurit® Degreasing and cleansing agent before applying 285-270

Primer filler	285-270 Glasurit® Primer Filler PRO	929-58 Glasurit® Hardener	352-91, -216 Glasurit® Reducer	 5 : 1 : 1	 HVLP 1.7-1.9 mm 2.0-3.0 bar	 ½+1 50 – 70 µm	 60°C 35 min.	 10 min	 P 400 – P 500	 P 800

Further paint system according to CC T S – Repair process for standard topcoats or
CC T P – Repair process for premium topcoats

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