



Refinish

DuPont Aerosol Repair Process

Description

The DuPont™ Aerosol Paint Repair Process is a cosmetic repair process for small damage. It integrates DuPont's innovative products and techniques to enable fast turn around time on repairs within single panels.

The goal of each step in the process is to contain the size of the repair. The recommendations are specific to the type of damage and the location of the damage recognizing the unique challenges for a variety of situations.

The DuPont™ Aerosol Paint Repair Process features clear coat blending: it is not a warranty repair process and it is not suited to restoring OEM finishes to pre-accident condition. Use the ChromaSystem™ Non-Stop Process for fast lane warranty repairs or repairs to restore finishes to their pre-accident condition.

General Information



Product List

DuPont™ Sontara® PS-3970S™ Solvent Cleaner Pre-saturated Wipes
A-4115S™ 1K Self Etching Primer
A-4220S™, A-4240S™ and A-4260S™ Quick Prime™ SprayBase™ Touch-up Paint
A-7480S™ Trim and Jamb Clear
A-19301S™ ChromaSystem Blender
2250S™ Premium High-Flow Putty
2270S™ Flexible Putty
A-2320S™ Plas-Stick® Surface Cleaner
A-2330S™ Plas-Stick® Plastic Primer
DuPont™ Sontara® wipe PS-3909S™
DuPont™ Sontara® Final Tack tack cloths (E-4145)
DuPont™ Sontara® Solvent Wash and Dry Cloth Wipes (E-4143)

Tools

Spray Cards



Mix Ratio/Viscosity

Some repairs may require the use of putty which needs to be mixed according to product requirements. Refer to the Product Data Sheets of individual products for detailed information on product mix ratios.

Process

Step 1. Assess Repair

The most important step in the Aerosol Paint Repair Process is to assess the damage. The primary considerations for a successful small repair are location and size;

- A small repair can be completed successfully if
 - the damage is not in the immediate vicinity of an adjacent like colored panel
 - the repair is on a vertical surface.
- Small repairs on horizontal surfaces such as hoods or near the top of fenders and the top of doors are difficult to achieve quickly and reliably due to their location.
- The repair area should not exceed more than one square foot.

Consider more durable, traditional repairs over areas larger than one square foot.



Refinish

DuPont Aerosol Repair Process



Step 2. Clean the surface

- Clean painted surfaces thoroughly with mild soap and water.
- Buff panel with polishing compound to remove oxidized layer of the paint finish
- For substrates painted with an OEM finish, wipe surface using DuPont™ Sontara® wipe PS-3970S™
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Step 3. Identify the Color Formula

Follow the DuPont™ Color Retrieval process in the ChromaSystem™ Technical Manual to find the best color formula for the repair;

- 1 Identify the manufacturer's paint code on the vehicle.
- 2 Record the VIN number and the make, model and year of the vehicle
- 3 Order SprayBase™ from your DuPont Jobber providing the vehicle information

Step 4. Mask

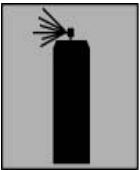
Mask area to be primed

Step 5: Sand and Fill

This step of the process is the most critical in containing the size of the repair. Keep the following tips in mind:

- Keep the sanded area to an absolute minimum.
- Do not sand through layers of clear coat, basecoat and primer if the damage does not extend through to the layer.
- Use a detail sander.
- Most damage in these repairs should not require filling.
 - Where filling is required, sand the repair area with 220 grit paper
 - Clean sanding sludge with PS-3970S™
 - Apply 2250S™ Premium High Flow Putty and sand with 320-grit paper
 - Wipe surface with Sontara® PS-3970S™ and proceed to the priming stage.

Step 6. Prime



Prime bare metal with A-4115S™. Shake the aerosol for 2 minutes after the mixing marble inside is heard and spray to test application. Apply 2 coats with a 5 minutes flash between coats to a maximum of 1 mil dry film thickness. Allow to dry 15 minutes before applying DuPont™ QuickPrime™.

Prime with DuPont™ QuickPrime™ A-4220S™, A-4240S™ or A-4260S™ in ValueShade™. Shake the aerosol for 2 minutes after the mixing marble inside is heard and spray to test application. Apply 2 to 3 coats with a 1-minute flash between coats.

Use a stencil with an appropriate size hole to help contain application of primer. Spray cards make good stock for stencils. We suggest a 2 inch hole would meet most needs. Hold the stencil close to the surface over the repair area during application of the primer to help limit the size of the repair.

Flexible parts with base plastic may need special cleaning and use of adhesion promoter before application of DuPont™ QuickPrime™. Clean bare plastic with a clean DuPont™ Sontara® Solvent Wash & Dry Cloth and A-2320S™. (Do not use A2320S™ on ABS or Lexan) Dry immediately with a clean dry wipe. Apply 1 coat of A2330S™. Allow to dry 30 minutes before applying primer surfacer.



Refinish

DuPont Aerosol Repair Process

Step 7: Final Sand and Surface Preparation

- Finish sand with 600 grit or 800 grit on a DA.
- Prepare the blend area to blend the clear coat into the original finish by sanding the area beyond the repair with 1000 grit paper.
- Remove sanding sludge and cleaning paste residue with DuPont™ Sontara® wipe PS-3909S™ and wipe dry.

Step 8. Mask for Topcoat

Mask area for topcoat according to the needs of the topcoat protecting areas which should not be painted in the process.

Step 9. Final Wipe

Remove sanding sludge with DuPont™ Sontara® wipe PS-3909S™.

Step 10. Tack

Tack with SPS Final Tack cloth (Part E-4141).

Step 11. Apply Basecoat

Apply SprayBase™ to hiding. Shake the aerosol for 2 minutes after the mixing marble inside is heard and spray to test application. Apply 2 to 3 coats with a 5 minute flash between coats.

12. Clear Coat Application

Apply A-7480S™ Acrylic Trim and Jamb Clear. Shake the aerosol for 2 minutes after the mixing marble inside is heard and spray to test application. Apply 2 medium-wet coats with a 15 minute flash between coats. Apply blender A-19301S™ immediately to make an invisible repair.

Additional Information

Filling Small Damage

Most small damage repair will not require filling. Where filling is required for light damage, sand bare metal with 180 grit or 220 grit paper, clean with PS-3970S™, apply 2250S™ Premium High Flow Putty direct to metal and sand with 320 grit paper. Wipe surface with PS-3970S™ and proceed to the priming stage.

Flexible Parts

The following procedure applies to repairing bare plastic. Refer to the ChromaSystem™ Technical Manual for complete information.

Prime

Clean surface with A-2320S™ Plastic Prep. (Do not use A-2320S™ on ABS or Lexan®)
Prime bare plastic with 1 coat of A-2330S™. Allow to dry 30 minutes before applying primer surfacer.

Fill Small Damage

Where filling is required for superficial damage on flexible plastic parts, prepare part following the instruction in the ChromaSystem™ Technical Manual. Prime the part as indicate above. Apply 2270S™ Flexible Putty and sand with 320 grit paper. Clean surface with A-2320S™ Plastic Prep. (Do not use A-2320S™ on ABS or Lexan®)

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Refinish

DuPont Aerosol Repair Process

Physical Properties

Refer to the MSDS of the individual

VOC Regulated Areas

These directions refer to the use of products which may be restricted or require special mixing instructions in VOC regulated areas. Follow mixing usage and recommendations in the VOC Compliant Products Chart for your area.

Safety and Handling

For industrial use only by professional, trained painters. Not for sale to or use by the general public. Before using, read and follow all label and MSDS precautions. If mixed with other components, mixture will have hazards of all components.

Ready to use paint materials containing isocyanates can cause irritation of the respiratory organs and hypersensitive reactions. Asthma sufferers, those with allergies and anyone with a history of respiratory complaints must not be asked to work with products containing isocyanates.

Do not sand, flame cut, braze or weld dry coating without a NIOSH approved air purifying respirator with particulate filters or appropriate ventilation, and gloves.

Please visit: www.performancecoatings.dupont.com to view or print an addition copy of this "Technical Product Data" sheet.



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