

## Vehicles damaged by hail

### B 1.1

#### Process description

This refinishing process is particularly suitable for repairing vehicles damaged by hail.

The process is designed to enable professional refinishers to maintain the quality standards of high-grade automotive finishes with outstanding efficiency

#### Substrates

- Galvanized steel
- Aluminum
- Steel
- R-M fillers
- Automotive OEM finishes, fully cured and solvent-resistant
- Electro-coated surfaces

#### Products required

- PK 700 / PK 900 / PK 2000
- STOP UNI
- AKROFILL
- STOP FILLER II
- PERFECTFILLER GREY / WHITE / BLACK
- PROFILLER GREY / WHITE / BLACK
- R-M topcoat

#### Safety instructions

It cannot be ruled out that these products contain particles < 0.1 µm.

The products are suitable for professional use only.

For the use of these products please adhere to the actual safety recommendations and the personal protective equipment.

#### Pre-treatment

	Degreasing PK 700 or PK 900
	Sanding P80 / P150
	Degreasing PK 700






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#### Putty

	STOP UNI Hardener	100 g 3 g
	Coat:	2 – 3
	20°C 60°C	20 min. 10 min.
	(short wave) (medium wave)	4 min. 50 % 6 min.
	Dry with P80, P150, P240, then degrease with PK 1000	

#### Sealer






	AKROFILL D 501 FR 500 / R 2100 / R 2200 / R 2300	100% by vol. 25% by vol. 25% by vol.
	Spraycoats: Film thickness:	1 20 – 25 µm
	60°C	20 min.
	(short wave)	11 min.

Alternative: LIGHT FILLER GREY P 2530 observing the minimum film thickness of 60 µm.






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#### Spray Filler

	STOP FILLER II STOP FILLER Hardener	100% by vol. 5% by vol.
	Spraycoats: Film thickness:	3 – 5 150 – 300 µm
	20°C 60°C	3 – 4 hours 30 min.
	(short wave) (medium wave)	10 Min. 50 % 15 – 20 min.
	Dry with P150, P240, then degrease with PK 1000. Prime sand through with EUROFILL or AM 850 / 880 PRIMEFILL	

#### Filler

	PERFECTFILLER GREY D 70 / D80 FR 500 / R 2100 / R 2200 / R 2300 You may use PROFILLER GREY / WHITE / BLACK or PERFECTFILLER WHITE / BLACK instead of PERFECTFILLER GREY	100% by vol. 25% by vol. 25% by vol.	
	Spraycoats: Film thickness:	2 50 – 70 µm	3 80 – 120 µm
	20°C 60°C	3 hours 20 min.	
	(short wave)	9 min.	
	Dry-sand with P400, then degrease with PK 2000.		

#### Topcoat

	ONYX HD, UNO HD CP, UNO HD CP PLUS Apply in accordance with the Technical Data Sheet
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