

VEHICLE RESTORATION



PREMIUM PROCESS: Option B *For Centari Solvent Basecoat only*

see special note at step 9 for Cromax Pro application.



01

Existing paint work must be removed down to the bare metal. Sand out rust spots with P120-P180. Sandblast if necessary. If vehicle is left to stand before work is continued, then sanding and cleaning should be repeated prior to painting. After sanding, clean all areas thoroughly using 3920S with Sontara Solvent Wash & Dry Wipes E-4143, remove any contaminants. Wipe the surface dry, ensuring the final wipe is clean.

NOTE: Sanded/blasted vehicle or parts must be free of moisture and primed within 4 hours with VOC Epoxy Primer Surfacer 840R, with a minimum of 80 microns of dry film thickness to avoid flash rusting.



02

Mix and apply 2 - 3 coats of 840R at 3 parts to 1 part of 845R to 1 part of AU370 / XB387. 5-10 minute intermediate and final flash off before bake. Air dry at 20 °C for 12 -16 hours or bake at 60 - 65 °C metal temperature for 35 minutes.



03

The VOC Epoxy Primer Surfacer 840R is sanded with P180-P240, corners and edges are hand sanded, avoid sand throughs. Any sand through spots must be Primed again with 840R, dried and sanded.

Before puttying, clean with 3920S using Sontara Degreasing Cloth A-1000.



04

All uneven areas and repairs are filled first with 769R Polyester Putty Fine. Mix and apply the 769R at 100 grams to 1-2 grams with 762R. 769R can be air dried for 15-30 minutes at 20°C or short-wave IR equipment half power for 2 - 3 minutes.



05

The putty should be coarse sanded with P120-P220 and then fine sanded with P240-P360. The sanded surface is then cleaned with 3920s using a clean Sontara Degreasing Cloth A-1000. Any sanded through spots to the metal substrate must be isolated with 840R dried and sanded.

Refer to product technical datasheet (TDS) for information such as activator/reducer selection, bake cycle, gun pressure and tip size. Refer to relevant product safety data sheet (SDS) for safe handling.

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06 Optional step: If needed for additional filling & smoothing, mix and apply 799R VOC Spray Putty at 100 grams to 3.6 grams of 791R and apply between 1-5 coats with a final flash off 5-10 minutes before bake. 799R can be air dried for 2 hours at 20°C or baked at 30-35 minutes for 60-65°C.



07 Guide coat complete area before sanding of 799R Spray Putty. First sanding P 120 – 220 . Second sanding P 240 – P360. The sanded surface is then cleaned with 3920s using Sontara Solvent Wash and Dry Cloth E-4143.



08 Complete area is then surfaced with VOC Epoxy Primer Surfacer 840R. Mix and apply 2 - 3 coats of 840R at 3 parts to 1 part of 845R to 1 part of AU370 / XB387. 5-10 minute intermediate and final flash off before bake. Air dry at 20 °C for 12 -16 hours or bake at 60 - 65 °C metal temperature for 35 minutes. The surfacer is sanded with P500-600, corners and edges are hand sanded, avoid sand throughs. The sanded surface is then cleaned with 3920s using Sontara Solvent Wash and Dry Cloth E-4143.



09 Mix and apply:
Centari Cromax solvent basecoat **OR**
2K Direct gloss topcoat
Please refer to Product TDS for mixing and application guide.
Special Note: If Cromax Pro Waterborne Basecoat is being used then the VOC Epoxy Primer 840R needs to be isolated with 2 coats of NS2602/2607, dried and sanded.
Do not apply Cromax Pro basecoat directly over VOC Epoxy Primer 840R.



10 Please refer to product TDS's for clearcoat mixing and application.

Refer to product technical datasheet (TDS) for information such as activator/reducer selection, bake cycle, gun pressure and tip size. Refer to relevant product safety data sheet (SDS) for safe handling.

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Important Notes

- Read, understand and follow all information for each of the product safety and technical data sheets.
- Always use solvent and chemical resistant gloves to prevent any contact with skin and to ensure that no grease or oils contaminate the substrate.
- Use only Solvent Basecoat and 2K Solid colour over VOC Epoxy Primer 840R
- Use a guide coat when block and final sanding to ensure that all defects are removed and that no sanding scratches are present.
- When cleaning with 3920S, work in manageable areas. Wipe clean and dry before the solvent dries on the surface.
- Use 190-micron paint filters for all primers and 125-micron filters for Basecoats & topcoats.
- Observe all mixing, application, flash off times and dry film builds.
- Check and adjust gun settings as per the product TDS's.
- Do not use 799R over unsanded substrates or apply basecoat/topcoat directly over 799R to avoid absorption.
- Do not apply 799R directly to Aluminium, light alloys and zinc plated steel, substrates must be prepared as per Cromax process.
- Maximum recoat times for primers are based on the condition that painted parts are kept indoors away from direct UV sunlight and weathering.
- Maximum recoat time for the 769R and 799R is 48 hours, otherwise swelling will occur in the presence of moisture.
- Vehicle Restoration Premium Process Option A is recommended over Option B for optimum long term corrosion protection.