

COLORTEC

The Automotive Paint Specialist

Dent Repair Notes



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REPAIRING DENTS IN CAR PANELS

- Sand back repair area with 150grit paper
- Use a Nikki/Filler to fill the dent
- Nikki to hardener ratio is 10:1
- Using 36grit paper, sand back with an orbital sander down to bare metal
- Clean up with wax & grease remover. (wipe on with a rag, wipe off with a clean rag) *DO NOT USE THINNERS*
- Sand area with 120grit paper to smooth areas, and smooth out the edges of the repair
- Mix up filler (this can be done on an onion board or a piece of sheet metal or glass). Mix the hardener fully into the filler
- Apply the filler and fill over the dent with a plastic or metal applicator. Also Feather the edges (smooth) this makes it easier to sand
- Use a cheese file on larger repairs, use before filler sets properly (when it's cheesy). If it goes off too quickly it will be too hard to file. Max depth of a repair is 20mm when using filler
- For plastic bumper bars the procedure is the same, but use a plastic filler.
- Use 80grit paper with a block to sand filler down. The bigger the repair the bigger the block. Be sure to rub down to the required shaped of the panel.
- Feel the repair with your whole hand held flat to make sure the repair is ok.
- Use 120grit, or go straight to 240grit, this will smooth out the filler and remove grooves from the 80grit

TIP

Using better quality filler has the advantage of being easier to sand and is able to stick to 2K Primer. Normal filler will only adhere to bare metal so it requires more sanding.

TIP

Too much hardener and the filler will go off too quickly.

REPAIRING A SCRATCH IN

PAINTWORK

- Sand down the scratch to bare metal and feather (smooth) the edges out. Do not leave any hint of the scratch
- Use Maroon Scotch Brite Pad to finish off
- Mask up areas not to be painted
- Spray 2-3 even coats of 2 in 1 Primer Filler mixed at a ratio of 2:1 with Multi Thinners
- Using a 1.4 to 1.8 spray gun, apply 3 coats, waiting about 10 mins between coats. Waiting 10 mins between coats will prevent pinholes and sink back
- Use a black spray can to apply a guide coat, a light spray to cover the area that needs to be sanded. Let dry for 1-3 hours
- Rub down with water, using 600grit wet – dry paper or 320 dry. Sand back guide coat.
- Using Grey Scotch Brite, rub down the rest of the panel to remove the original gloss. Then Clean the area with wax & grease remover

SPRAY PAINTING

- Mix acrylic paint using a measuring cup at a ratio of paint to thinners of 1:1 ½ (Using Acrylic thinner will give a better result, but multi thinners are ok)
- Be sure the area is clean and had been wiped using a tack rag
- Pulling the trigger on the spray gun half way releases air only, releasing it all the way releases the paint
- Before applying the paint, make sure you are happy with how the gun is spraying.

TIP

You want the span of the spray paint, when it comes out of the gun to be about one hand span when it is one hand span away from the gun.

- Apply 3 coats of colour and cover the repair

TIP

If you have a repair in the middle of the panel, cover that part with pain and then blend the paint around it. If you spray all the way to the edge of the panel you may see a difference in colour.

- Using the same technique as the colour, mix clear at 1:1 and apply 3-4 coats of clear within 1 hour. Clear only needs to go on top of metallic colours not solid colours
- After a couple of days you are ready to buff the clear

BUFFING

- After leaving the clear for a couple of days, run the clear back with 1200 or 1500grit paper.

Tip

Use the palm of your hand to sand the clear. If you use your fingers you could create waves in the clear

Use 1 sheet of paper per panel.

- Using a buffing compound, dab small amounts of compound on the panel using a paint brush
- Buff with a lamb's wool pad at a medium speed. Watch the edges so the pad does not catch.
- Polish the panel using a polishing cloth and some Auto Polish

TIPS

- Gravity feed spray guns are easier to use
- 2mm nozzle for Acrylic Paint, 1.4mm for 2 pack and Enamel
- 3.5mm nozzle for spray putty
- 12cfm compressor is a good size for doing resprays. Smaller units are okay for smaller jobs
- Compressor pressure is good at 40psi
- When spraying overlap each pass about halfway
- Hold the spray gun about 20cm for the job at all times
- When starting out screw the fluid nozzle in to restrict paint flow
- Paint in the shade, not in the sun
- Acrylic thinners give a better gloss than Multi thinners

NOTES

This image shows a single page of white paper with horizontal blue ruling lines. The lines are evenly spaced and run across the width of the page. There are no margins, text, or other markings on the paper.