



Section 12

Polishing



Polishing:

Stage 1 - Inclusion Removal and Preparation

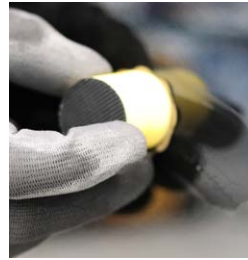


Clean the panel before commencing denibbing.



Small particle inclusion removal:

Use the denib block and small abrasive disc.
Use Bodyshine to help lubricate the abrasive for consistent scratch profile.
Work in gentle linear movements.



Check to ensure inclusions have all been successfully removed.



Larger more general particle inclusion removal:

Use a P1200 or P1500 Film disc preferably on a 125mm DA sander followed by a P2000 Blend & Finishing Pad, which should be lubricated with Bodyshine or Spirit Wipe. This will aid the cut and prolong the life of the disc.

The Blend & Finish disc helps reduce the scratch profile left by the P1200 or P1500 disc, and will impart some degree of gloss into the area helping reduce the machine polishing process time.

Polishing:

Stage 2 - Machine Polishing



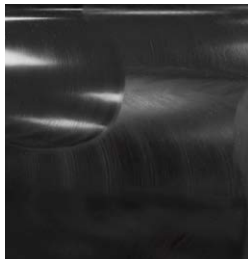
Apply a small 'finger nail' amount of polish to the area.



Apply polish to the whole mop head to 'condition' the sponge. This helps reduce initial heat build up and aggressive scratching.



Use medium pressure and consistent strokes across the area. Start machine with the pad touching the panel and keep the head moving to break down the polish.



Continue to polish until you are happy that all scratches have been removed. The polish will have broken down to a finer film. Leave some residue polish on the panel and install the black polishing head. Work this to help bring the panel gloss level up to an acceptable lustre. Polish panels in sections for thorough coverage. Use either Bodyshine or solvent panel wipe as the lubricant to check for scratches.

Final Check: Clean with a microfiber cloth and some lubricant to ensure all scratches have been fully removed.

Use either Bodyshine or D837 Solvent Panel Wipe as a lubricant to check for any missed fine scratches.

Polishing:

Paint – After Care of New Paintwork

When you trust your vehicle to a PPG designated repair bodyshop you can be sure that the work undertaken is carried out by a fully trained technician.

Paint materials of the highest quality will have been used to ensure an excellent colour match is achieved combined with superb product quality and durability.

To keep the new paintwork in excellent condition, there are a number of recommended steps to take: -

- Do not apply any decals/stickers to the paintwork for 3-5 days after painting.
- Avoid commercial car washes for the first 30 days.
- Do not wax or polish for the first 30 days.
- Never wipe with a dry or harsh cloth. A clean microfibre cloth is advised.
- Wash in a shaded area, never in direct sunlight.
- When washing, loosen the grit first by using a hosepipe or jet wash (taking care not to get too close with a jet wash) so as not to scratch the finish.
- Start on the roof of the vehicle and work down to minimise any scratching from grit on the car.
- Wash with a proprietary car shampoo and rinse with cool water. Dry with a leather or synthetic chamois.
- Any deposits of tree sap, bird droppings or automotive fluids (including petrol) need to be washed off immediately with cool water. Bird droppings can be very aggressive.
- Regular washing and waxing will keep your new paintwork in top condition.
- Avoid parking in particularly harsh environments - near sources of heavy smoke, close to railway lines, sources of industrial fallout or very close proximity to the sea.

Polishing:

Decals

Recommended process for applying decals and plastic folio on fresh paintwork.:

The recommendation can be different from case to case. The reason is linked to the total film build and paint system used.

When applying decals on fresh paintwork, the following guidelines should be followed to prevent bubbles appearing within the decal at a later stage and to reduce the risk of poor adhesion.

After decal removal, there will always be a need for a polishing process. The most important aspect is the right bake time and for whichever paint system is used, the bake time and temperature should be the same as advised on the PPG Technical Data Sheets.

Also, it has to be taken into consideration that a total UHS film build normally takes a minimum of 7 days at 20°C before it becomes 100% hardened.

A general recommendation for decal application is as follows:

- The drying process for all paint layers (suggested - oven drying).
- Final topcoat drying – 60 minutes at 60°C object temperature.
- Plastic folio can only be applied over a newly painted substrate if it's been more than 7 days since application. The vehicle must sit in dry conditions and at room temperature (indoors at 20°C).

The decal supplier's recommendations for application and use should be followed.

Contact

If you have any questions, please contact PPG Customer Services.
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Core Product Overview

Product Description		Hardeners	Thinners	Mix Ratio	Technical Data Sheet
D8407	DELTRON® Waterborne Flatting Paste	n/a	n/a	Ready for Use	RLD243V
D8401	Deltron Waterborne Pre-Cleaner	n/a	n/a	Ready for Use	RLD63V
D837	Deltron Spirit Wipe	n/a	n/a	Ready for Use	RLD63V
D846	Deltron Anti Static Agent for Plastics	n/a	n/a	Ready for Use	RLD63V
D8434	Deltron Plastic Substrate Cleaner	n/a	n/a	1 : 1	RLD241V
D8092	Deltron Chromate Free Wash Etch Primer	D8293	n/a	1 : 1	RLD261V
D820	Deltron Plastics Primer	n/a	n/a	Ready for Use	RLD165V
D8416 / D8421 / D8424 / D8426	Deltron 1K Aerosol Primer	n/a	n/a	Ready for Use	RLD180V
D8501 / D8505 / D8507	Deltron DP4000 2K Primer	D8302 / D8238	D8715 / D8740 (Plastic Parts)	4 : 1 : 2 / 2 : 1 : 0.5	RLD282V
D8521 / D8525 / D8527	Deltron DP5000 2K Primer	D8302	D8718 / D8719	7 : 1 : 1-2	RLD301V
D8561 / D8565 / D8567	Deltron DP7000 Air Dry Primer	D8270	D8727 / D8728	3 : 1 : 0.5 (spray) 3 : 1 (roll)	RLD311V
D8080	GRS UV-Cured Primer Surfacer	n/a	n/a	Ready for Use	RLD164V
T510	ENVIROBASE® High Performance Waterborne Engine Bay Converter	D8260	T494	70 parts colour 15 parts D8260 15-25 parts T494	RLD234V
T4xx (Standard App. Process)	Envirobase High Performance Basecoat	n/a	T494	1 part colour : 10-30%	RLD213V
T4xx (OneVisit™ App. Process)	Envirobase High Performance Basecoat	n/a	T4900/T4910	1 part colour : 5-20%	RLD490V
D8131	Deltron UHS Clearcoat	D8254	n/a	2 : 1	RLD402V
D8177	Deltron Progress Rapid Performance Clearcoat	D8307 / D8308	D8757 / D8758	2 : 1 : 0.6	RLD403V
D8122	Deltron Ceramiclear	D8302	D8714 / D8718 / D8719	3 : 1 : 0.5	RLD285V
D8115 / D8117	Deltron Matt & Semi-Gloss Clearcoat	D8302	D8718 / D8719	5 : 1 : 3.5	RLD265V
D8430	Deltron Spot Blender	n/a	n/a	Ready for Use	RLD299V
D8731	Deltron Spot Blender Aerosol	n/a	n/a	Ready for Use	RLD299V