



PD-0130 METAL PARTS PREP – LKQ* PAINTED PARTS

CAUTION: WEAR THE PROPER SAFETY PROTECTION DURING THIS PROCESS. REFER TO SPECIFIC PRODUCT DATA SHEET FOR APPLICATION AND PRODUCT DETAILS.

A technician should review a work order to ensure that all parts to be painted are present and repairs are understood.

Inspect the part for imperfections and damage. If damaged, refer to PD-0100 Light Body Repair or any related process documents for the repair procedures.

Test the coating by rubbing a small area with a urethane grade solvent on a clean towel. If the coating softens or wipes off, remove the coating by sanding with appropriate coarse grade sand paper or other stripping media or chemicals to remove the unstable coating. Refer to PD-115S Bare Steel or PD-0115A Bare Aluminum process documents for bare metal repair instructions. If the coating is stable, proceed to the next process below.

Stable Paint Process:

Wash the part with car wash specific soap and water, rinse & dry thoroughly. Inspect the part and repair any damage. Follow all process documents associated with the repair process. Clean the entire part thoroughly with a regionally approved surface cleaner and clean towel. Dry thoroughly.

Sand paint with P320 grade paper using a DA sander and an interface pad. Scuff all edges, body lines, and recessed areas with a red general-purpose scuff pad or equivalent to remove all gloss.

Re-clean the sanded surface with appropriate surface cleaner.

If bare metal is exposed, apply an Etch Primer or Epoxy Primer before a Primer Surfacer. Some Epoxy Primers have sanding capabilities that may be used throughout the repair process.

For imperfections such as scratches or chips left in the original painted surface, apply 2-3 coats of Primer Surfacer to the affected areas.

Sand the Primer Surfacer. Refer to the Product Data Sheet for detailed instructions. Re-clean the part with an appropriate surface cleaner. Dry thoroughly.

Use the recommended G1-G7 or SG01-SG07 gray Primer Surfacer or Primer-Sealer recommended for the basecoat color or single stage color.

***LKQ is a used part of Like Kind or Quality.**