

spraying of synthetic resin enamels. The drying of baking enamels requires an infra-red drying lamp bank which contains the following lamps, distributed over an area of 68×48 cm:

13 Osram-Siccatherm infra-red lamps, 250 Watts or	220—225 v
13 Philips Infra-red drying lamps, 275 Watts	

L. Preparation and Priming

Bare metal should be well sanded with a 220 paper and all rusty parts should be carefully cleaned. After cleaning with MB Synthetic Resin Surfacer put on a gray priming coat. Adjust the material to the correct degree of viscosity (see instructions for use, or Information Sheet DBA 3100).

Application: Apply an undercoat, and then 1—2 cross coats.

Drying: About 30—40 minutes with the lamps at a distance of 35 cm.

When the coat has cooled off, sand first with 360 paper and then with 400 paper. Surface irregularities are filled with red-brown MB Synthetic Baking Filler. Before applying the filler, sand with 280 paper, dry and clean. It is advisable to apply the filler in a number of layers rather than in one thick coat in order to prevent pores and sagging. Dry each filler layer for about 5 minutes at a lamp distance of 35 cm and bake the complete filler coat for 10 minutes before sanding. Use 280 paper for the final sanding of the cold filler coat. After cleaning, again apply $1\frac{1}{2}$ cross coats of synthetic resin surfacer, dry and sand.

M. Finish-Coating Large Areas

The synthetic resin baking enamel should only be applied to an absolutely clean and completely smooth, mat-sanded surface. If the cover is unsatisfactory (e.g. in the case of red, ivory, or dark blue), it may be necessary to apply two finish coats. In this case, the first coat should be lightly sanded with 600 paper when cold.

The following instructions should be observed:

a) Black Finish

The repair area is sanded as usual with 600 paper and sprayed with baking enamel; apply a fog coat to the edge of the wet enamel, using a diluted enamel (proportion 1 part of baking enamel to 3 parts of baking enamel thinner). Even after this operation a narrow strip of the feather-edged enamel should remain visible. After that bake with infra-red drying lamps and polish as usual when the coat is cold.

b) Colored Finish

Sand the repair area with 400 paper. Contrary to the method used on the black finish, the whole sanded repair area is sprayed with baking enamel. Apply a wet coat of thinned enamel to the edges of the wet enamel and the adjacent non-sanded coat (proportion 1 part of baking enamel to 3 parts of baking enamel thinner). Bake in accordance with instructions and take care not to sand the finished coat excessively. Because of the danger of graying and in order to avoid halos it is necessary to use particular care in the baking of colored baking enamels.

See our new leaflet "Care and Repair of Body Finishes" for further details about touching-up and refinishing jobs. This brochure also contains details about enamel viscosity and sources of supply as well as our Information Sheets DBA-3100, DBA-3101, and DBA-3102.

N. Refinishing Large Panels

The priming and preparation of large panels requires the same amount of care as touching-up work. Large panels are dried in a drying oven. When 80° C enamel is used, it is particularly important to observe the prescribed temperatures. At all parts of the car the temperature should be between 85° C and 95° C. On no account should the temperature be higher than 95° C in order to avoid damage to parts of the car body. Remember that the minimum temperature of 80° C at the refinished part of the car will only be reached after a certain time-lag.

Air-drying enamels are dried at room temperature. It should be noted, however, that increased room temperatures (up to 70° C) accelerate the drying process and that room temperatures below 18° C considerably delay the drying process.

Drying Temperatures and Drying Times

Type of enamel	Drying temperature	Drying time
80° C Synthetic resin enamel	min. 80° C	60 min.
Air-drying synthetic resin enamel	Room temperature	24 hours
	(out-of-dust after 1½ hours) or 60°—70° C	1½ hours

Note: For further details please consult our Information Sheet DBA 3100 and the instructions published by the enamel manufacturers.