

G. Metal Finishing Work, Filling and Cleanliness

Please note that adequate metal finishing can save much time spent on filling. On all paint jobs, cleanliness is of the utmost importance. During sanding, water should not be allowed to dry on, and there must be no sand marks on the car body. It is therefore advisable to clean the surface to be painted with gasoline and a clean cloth between the various finishing processes. Instead of gasoline, MB Synthetic Resin Thinner can be used for cleaning. Before spraying on top of enamel coats, carefully remove all residue of polishing agents, particularly of those containing silicones. Always use clean cloths to make sure that silicone residues are not transferred to other parts of the body.

Silicone polishers should never be kept or used in paint shops since minute traces of silicone in the air or on the car panels may produce fish-eyes in the synthetic enamel!

The spray booths should always be under pressure and the compressed air must be completely clean.

Note: Nitro-cellulose spray may ignite if it combines with synthetic resin spray. For this reason it is imperative carefully to clean the spraying booths whenever a changeover is made from nitro-cellulose lacquers to synthetic resin enamels.

H. Metal Sheen Enamels

Metal sheen enamel finishes are difficult to touch up. Touching-up requires a high degree of skill. When larger areas are sprayed, it should be remembered that the color shade is largely dependent on the method of applying the enamel, since the metal bronze will show poor flow-out if sprayed on irregularly. For this reason, color matching should be attempted not by mixing the enamels, but by varying the spraying technique. Full wet coats produce darker shades and moist coats produce lighter shades.

Synthetic resin metal sheen enamels can be air-dried or dried at a temperature of 80° C.

I. Bodywork Protection During Spraying Operations

The parts of the car body which are not to be refinished should be protected by crepe paper masking tape or by stripping lacquer. If the finish is to be dried at temperatures above 80° C, all parts likely to be affected by high temperatures should be protected or removed; this applies in particular to laminated glass (windshield glass) and to plastic lighting assemblies (brake light, flash direction signal, and license plate light). Plastic license plates should always be removed.

Note: At drying temperatures above 100° C even masked plastic parts may be destroyed.

K. Paint Shop Equipment

Before starting on a paint job, thoroughly stir the paint in order to avoid differences in color shades, unsatisfactory drying or similar flaws. We recommend nozzles with a diameter of 0.8 mm for the