

Additional Refinish Time for Repaired Panels

Compare Basic Refinish Procedures for Repaired vs. New Panels

16 MORE STEPS: 39 repaired panel procedures vs. 23 new panel procedures.***

- Ask your paint company for its standard operating procedures.
- Operations listed may or may not be included in refinish times provided.
Please refer to your information provider to confirm included/not-included operations.

Repaired Panel*

1. Apply pin-hole eliminator to body plastic.
2. Sand pin-hole eliminator.
3. Featheredge damaged area for primer.
4. Mask/bag car for etch & two-part fill primer.
5. Wax and grease removal.
6. Blow off and tack panel for dust.
7. Mix etch primer (for bare metal areas).
8. Apply etch primer for adhesion.
9. Clean up etch primer spray gun.
10. Apply two-part fill primer to repaired area.
11. Bake Primer for cure.
12. Clean up two-part fill primer spray gun.
13. Guide coat primed area.
14. Block-sand repaired area.
15. Possible 2nd - 3rd prime/gun clean up.
16. Possible 2nd - 3rd block-sand repair.
17. Unmask for paint prep.
18. Clean panel/edges/vehicle for refinish.
19. Sand and prep panel.
20. Mask and bag for sealer and paint.
21. Mix sealer.
22. Mix color (minimum amounts required).
23. Tint color to achieve acceptable blend.
24. Spray out test panel (2-stage) and let-down panel (3-stage).
25. Blow off and tack panel for dust.
26. Apply sealer.
27. Clean up sealer spray gun.
28. Apply wet-bed (eliminates scratches in blend).
29. Apply base-coat to affected area.
30. Blow off and tack panel for dust.
31. Clean up base coat spray gun.
32. Mix clear coat.
33. Apply two coats of clear.***
34. Clean up clear spray gun.
35. Bake according to paint manufacturer specifications.***
36. Cool down process.
37. Denib and polish.
38. Finish wet sand and blush
39. Unmask for reassembly.

vs.

New Panel*

1. Clean panel/edges/vehicle for refinish.
2. Sand and prep panel.
3. Mask/bag for sealer and paint.
4. Mix sealer.
5. Mix color (minimum amounts required).
6. Tint color to achieve acceptable blend..
7. Spray out test panel (2-stage) and let-down panel (3-stage)
8. Wax and grease removal.
9. Blow off and tack panel for dust.
10. Mix etch primer (for bare metal areas).
11. Apply etch primer for adhesion.
12. Clean up etch primer spray gun.
13. Blow and tack panel for dust.
14. Apply sealer.
15. Clean up sealer spray gun.
16. Apply base-coat color to entire panel.
17. Clean up base coat spray gun.
18. Mix clear coat.
19. Apply two coats of clear.***
20. Clean up clear spray gun.
21. Bake according to paint manufacturer specifications.***
22. Cool down process.
23. Unmask for reassembly.

*Based on paint manufacturer requirements, industry refinish standards, technical data sheets, warranty requirements and procedure pages.

**Additional paint and materials not taken into consideration on this chart.

***Please contact your local paint representative for specific refinish procedures.



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