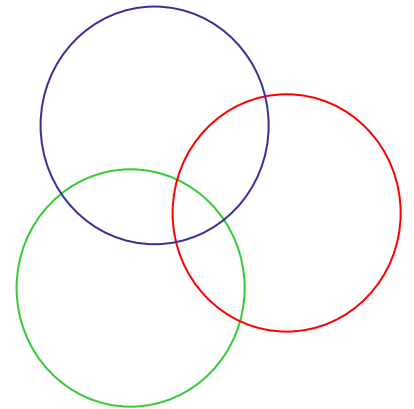


# MATRIX

## SYSTEM

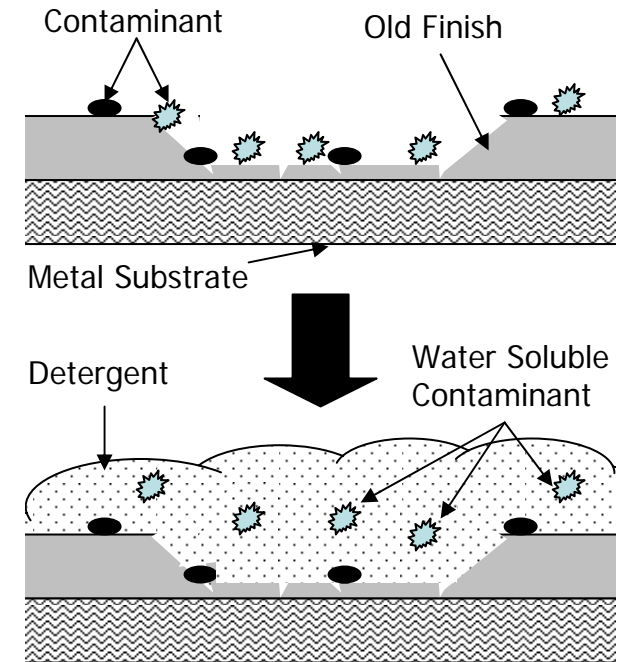
### AUTOMOTIVE FINISHES

Painting Steps



# Figure 1

## Detergent Wash

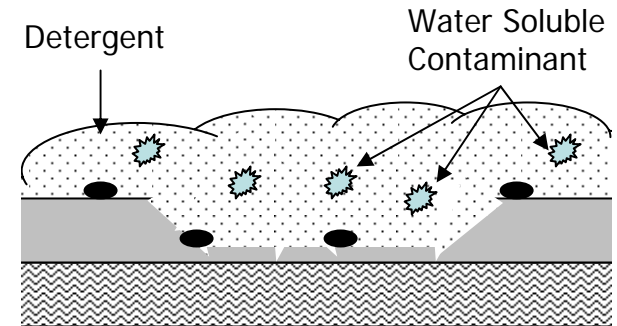


Step 1 Before any sanding has begun, completely wash the vehicle with hot soapy water to remove contaminants soluble in water such as dirt, road grime, bird droppings, etc

Note: Sanding does not remove surface contamination, sanding without properly cleaning first will only serve to push contaminants below the surface and into the sand scratches making removal difficult

## Figure 2

### Detergent Scuff

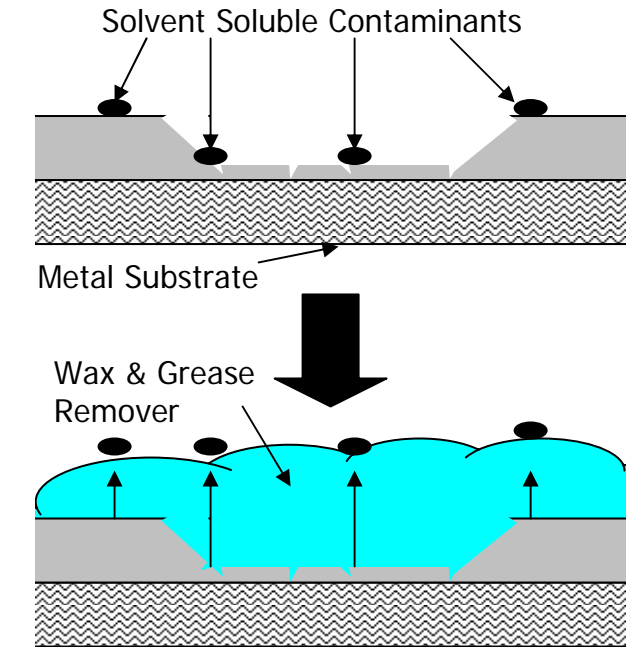


### Step 2 Removing high tech wax and paint sealant

- Use a 1:1 mixture of Mr. Clean® or equivalent cleaner and hot water
- Scrub the surface with a grey nylon scuff pad
- Rinse well/dry

# Figure 3

## Solvent Clean

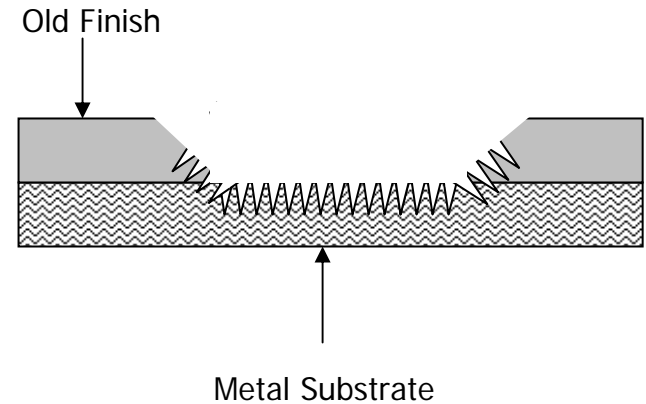


Step 3 Solvent clean with MX-9000 surface cleaner to remove solvent soluble contaminates such as wax, tar, silicone, grease, etc...

Note: Surface cleaners must be used liberally to work effectively, Contaminates broken loose by the cleaner float to the top of the wet film and must be wiped clean with a lint free wiping cloth while the panel remains wet

# Figure 4

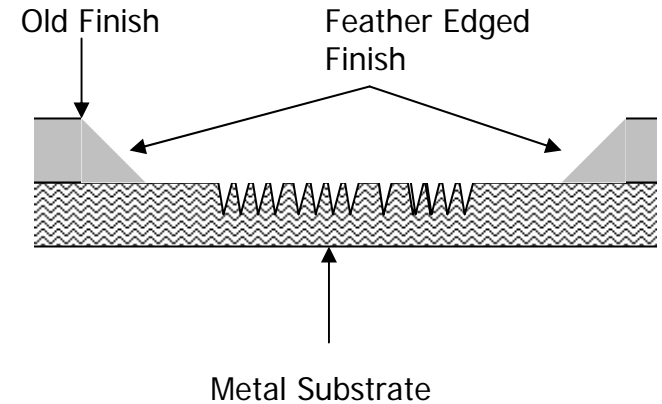
## Grinding



Step 4 Remove rust or otherwise prepare the metal surface for repair by using a 24 to 36 grit grinding disc

# Figure 5

## Rough Featheredging

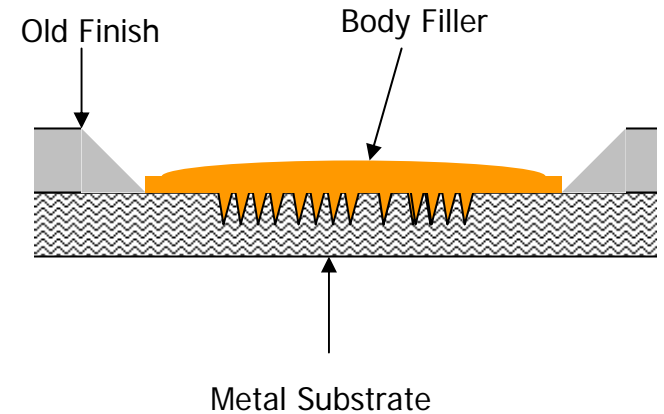


Step 5 Sand the old finish along the edge of the damaged area with a dual action or random orbital sander using 80 grit sandpaper until a gradual tapered edge has been exposed through each layer of undercoat, colorcoat, clearcoat

Note: No less than ¼" tapered featheredge should be visible for each coat

# Figure 6

## Body Filler Application

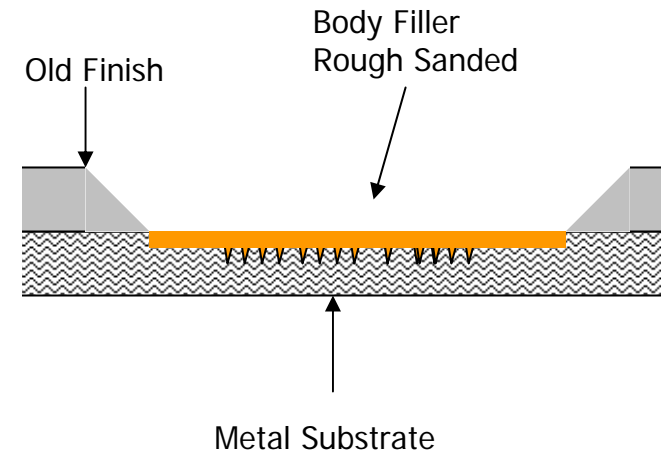


Step 6 Apply body filler to the repair area to fill imperfections and restore the original contour of the repaired panel

- Use a plastic spreader with firm pressure when applying filler
- The best results are obtained when applying thin coats

# Figure 7

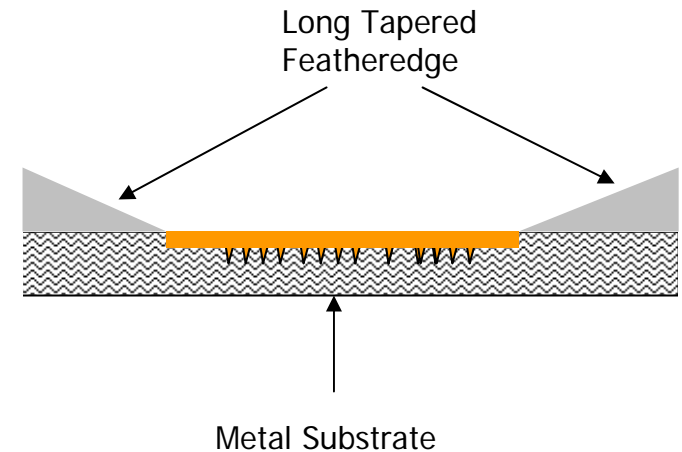
## Rough Sanding Body Filler



Step 7 Remove excess body filler and rough sand with 40 to 80 grit sandpaper to restore the original contour of the panel

# Figure 8

## Finish Sanding/Feather edging

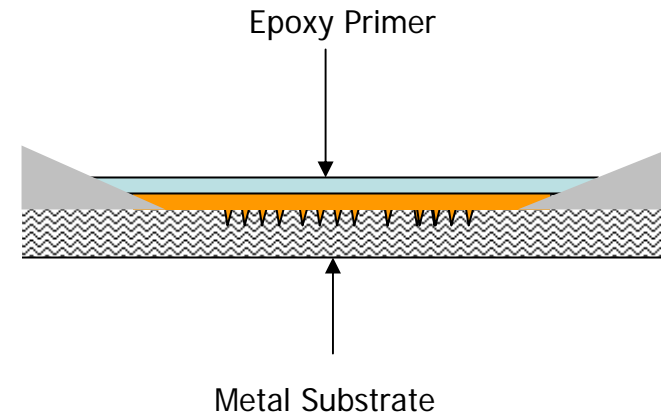


Step 8 Finish sand the body filler and feather edge the old finish 1/2" minimum with 180 grit or finer sandpaper to remove all the rough sanding operation scratches, once completed clean with compressed air and solvent clean with MX-9000

Notes: Be sure to sand beyond the feather edge with the sandpaper grit that will be used for finish sanding

# Figure 9

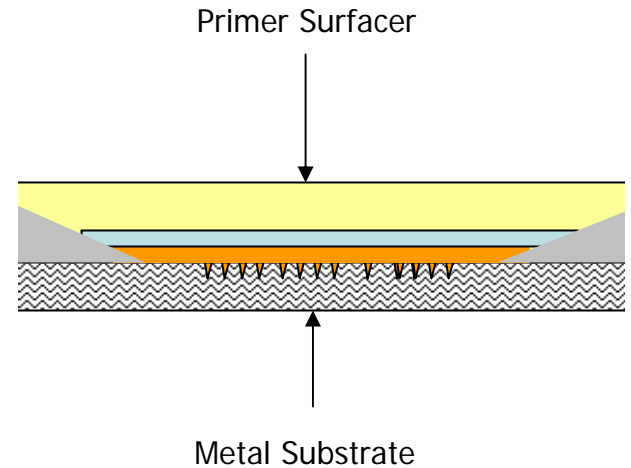
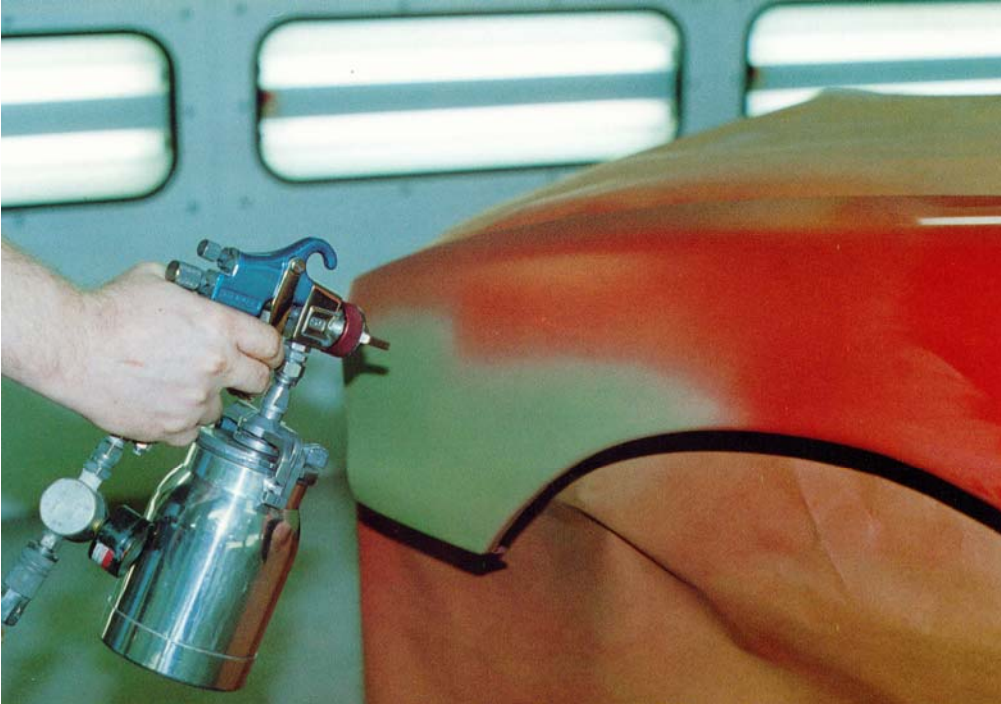
## Primer Application



Step 9 Apply an epoxy primer over the body filler, bare metal and feather edge to provide corrosion protection and adhesion for the following undercoats

Figure 10

## Primer Surfacer Application

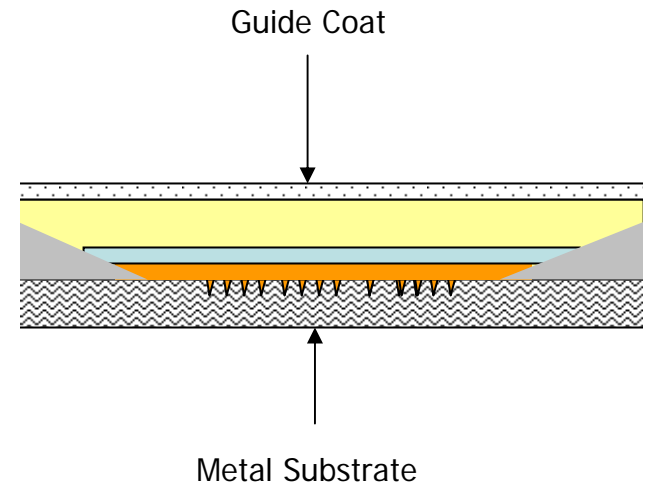
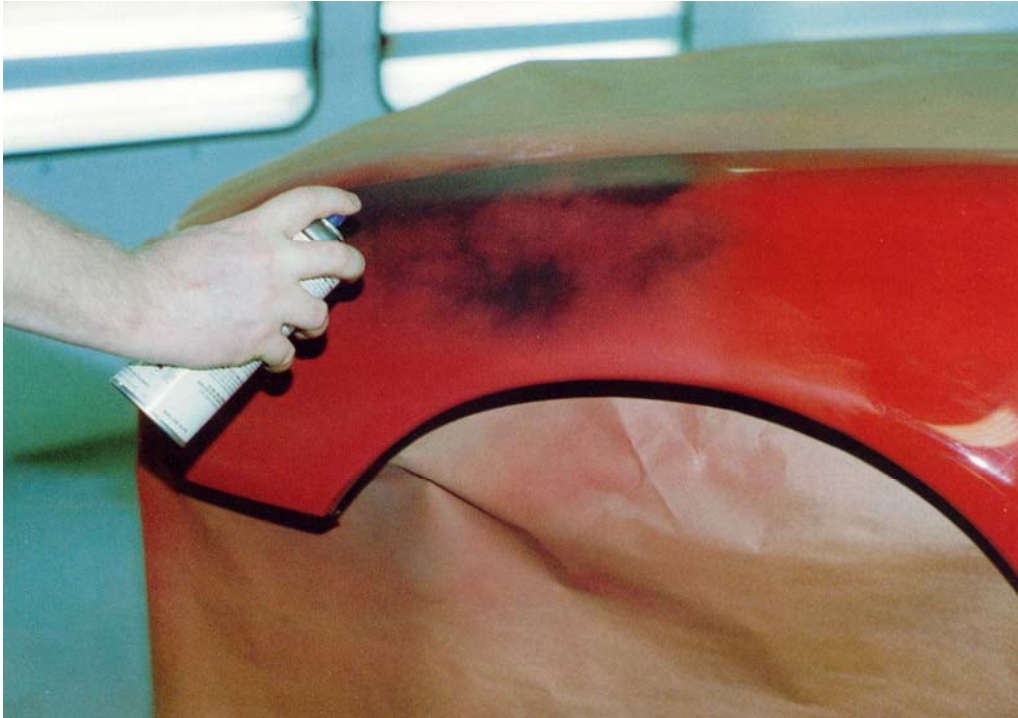


Step 10 Apply 2-3 coats of 2 component acrylic urethane primer surfacer bringing the last coat into the fine grit sanded area

Notes: Choose a color that closely resembles the topcoat color to enhance colorcoat hiding

# Figure 11

## Guide Coating



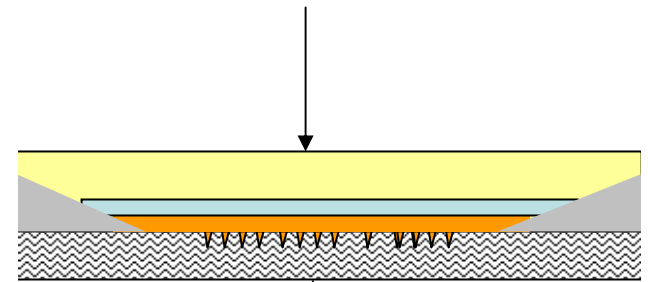
Step 11 Apply a light coat of contrasting color over the primer surfacer to help identify imperfections or otherwise high/low areas requiring further sanding or additional repairs

# Figure 12

## Block Sanding



Sand the primer surfacer so it is level and smooth with the adjacent areas



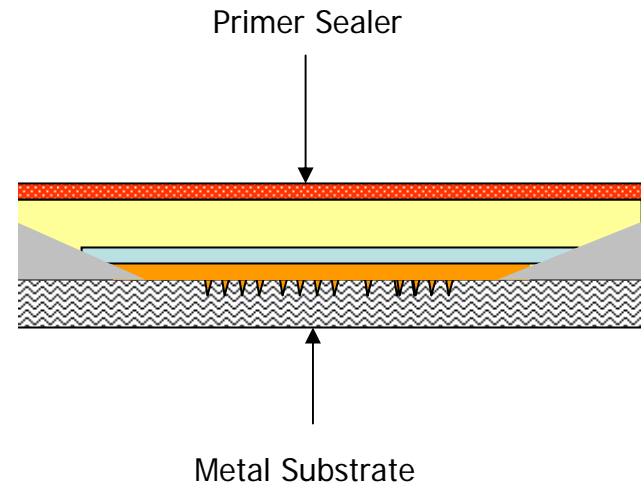
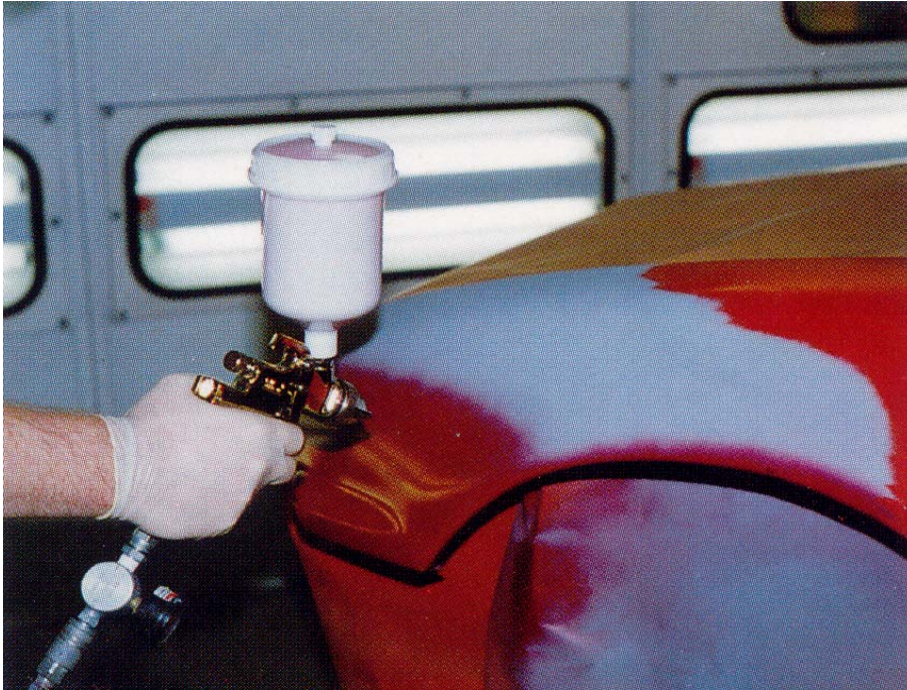
Metal Substrate

Step 12 Sand the Primer Surfacer level and smooth using a sanding block to minimize surface undulations caused by sanding with uneven pressure by hand

Notes: Avoid sanding through the primer surfacer exposing the substrate whenever possible. Re-apply primer as needed and final sand to 400 grit or finer sandpaper prior to topcoat application

# Figure 13

## Sealing

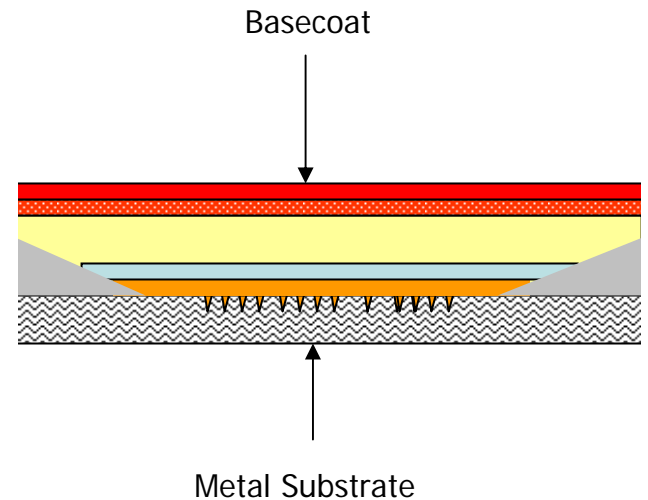
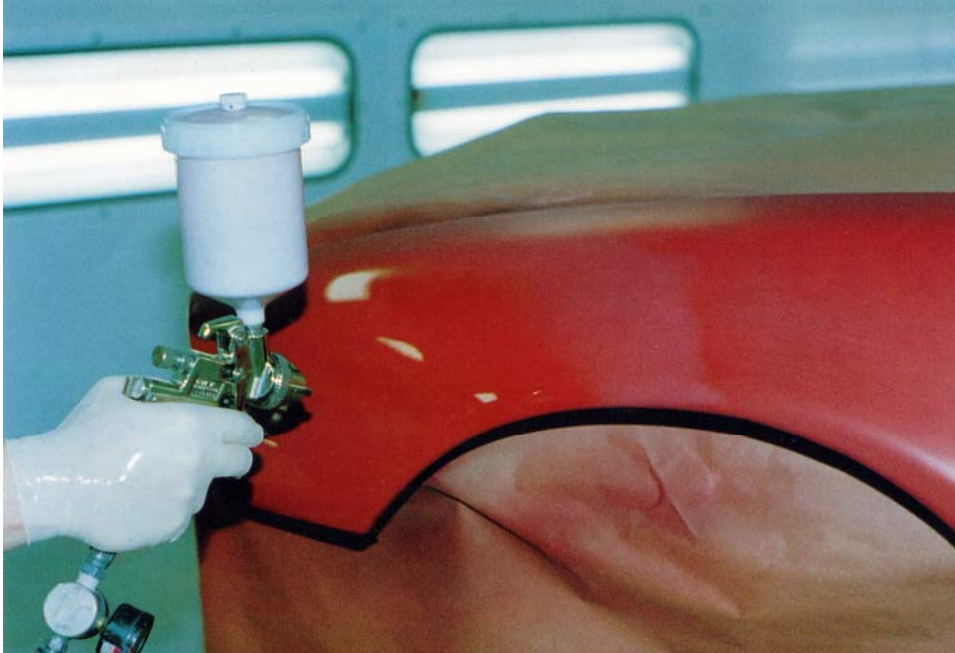


Step 13 Apply a primer sealer to the repaired areas prior to topcoating to promote color uniformity, enhanced adhesion, enhanced gloss retention, in addition to filling minor sand scratches and creating a barrier between the topcoats and undercoats minimizing solvent permeation

Notes: Tint sealer whenever possible to match the topcoat color to further enhance topcoat hiding

# Figure 14

## Color Application

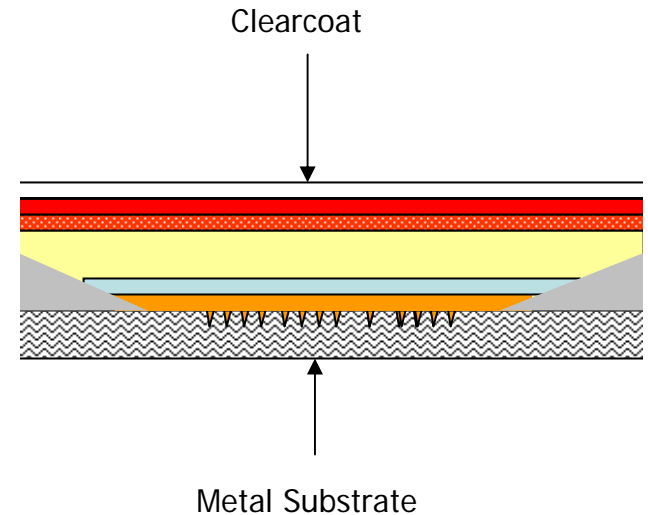


Step 14 Apply color per manufacturers recommendations, using recommended cap and tip sizes in addition to temperature correct reducers

Notes: Apply the color in full wet coats. Follow recommended flash times, if spraying basecoat lightly tacking between coats until hiding is achieved is recommended. Avoid rushing flash times whenever possible to minimize problems

# Figure 15

## Clearcoat Application



Step 15 Apply clearcoat per manufacturers recommendations, using recommended cap and tip sizes in addition to temperature correct reducers and activators

Notes: Apply the clearcoat in full or medium wet coats. Follow recommended flash times, avoid rushing flash times whenever possible to minimize problems