

STANDARD OPERATING PROCEDURE

Small Damage Repair

Repair on a Single Metal Panel

Clean	1	Wash with warm water & soap (silicone & oil free).	
	2	Clean metal substrates, with solvent-borne degreaser, SCAT #6311 or Speedi SCAT #6321.	
	3	Clean with waterborne degreaser, Aqua SCAT 2 #1394.	
Repair	4	Repair damage as necessary.	
Sand	5	Sand with 220 grit on palm sander. Sand 1-2" out from repair area. Keep repair area as small as possible.	
	6	Scuff surrounding area with red scuff pad. Keep repair area as small as possible for blend.	
Clean	7	Blow off vehicle. Clean with waterborne degreaser, Aqua SCAT 2 #1394.	
Mask	8	Mask vehicle for priming. Allow enough room to avoid creating a hard primer edge.	
Clean	9	Blow off vehicle. Clean with waterborne degreaser, Aqua SCAT 2 #1394.	
Prime	10	On Bare Metal: Tack off. Apply corrosion protection. For finishing repaired steel, see SOP 111.	
	11	Select Transtar primer surfacer & Star Shade value for improved hiding. For selection of primer by substrate, see SOP 021. Mix per TDS.	
	12	Tack off. Apply primer using <i>Outside-in method</i> . Keep prime area as small as possible.	
13	After Primer has Cured: Apply Low Spot Finder Guide Coat #9183 to surface. Block sand with 240-320 grit. Inspect surface for defects. Repair or reprime as necessary.		
Sand	14	Finish sanding repair area with 400-600 grit on palm sander.	
	15	Prepare blend area with 800-1000 grit wet / dry or with gray/green scuff pad and Scuff & Prep Paste #6338. Dull shiny areas for blend.	
	16	Blow off vehicle. Clean with waterborne degreaser, Aqua SCAT 2 #1394.	
Mask	17	Mask vehicle for topcoat. Allow enough room to avoid creating a hard edge.	
Clean	18	Blow off vehicle. Clean with waterborne degreaser, Aqua SCAT 2 #1394.	
Topcoat	19	Tack off. Apply topcoat per Transtar SOP 509. For blending, see SOP 513/4.	

SUGGESTED MATERIALS FOR JOB

- Soap & water ● Transtar Solvent-borne Degreaser, #6311/#6321 ● Transtar Waterborne degreaser, #1394 ● Lint-free Towels
- Sandpaper – various grits ● Sanding blocks ● Palm Sander ● Scuff pads ● Transtar Guide Coat, #9183 ● Masking material
- Tack rags ● Transtar Adhesion Promoter, #1031/1021 ● Transtar Corrosion Protection Primer ● Transtar Primer Surfacer

* Always refer to Transtar Technical Data Sheet (TDS) for specific product application, suitable substrates & other product information.