

# Minor Repair Process - Metal

## Speed-TEC System



**STEP 1:** Clean and inspect damage. Use Permaloid® Silicone Remover 7010 and Audurra Degreasing Cloth.



**STEP 2:** Sand with Audurra Premium Sanding Disc B/C to remove existing paintwork. If putty needs to be applied, sand damaged area with Audurra Premium Sanding Disc B.



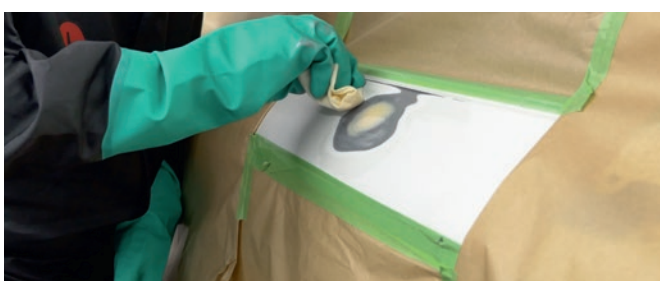
**STEP 3:** Clean and apply putty if needed. Use e.g. Raderal® IR Premium Putty 2035.



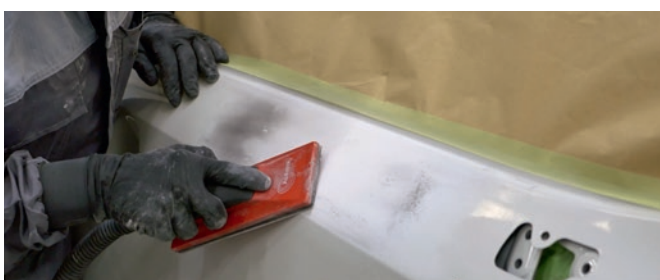
**STEP 4:** Sand putty with Hand Block and Audurra Premium Sanding Strip B then Audurra Premium Strip C. Use Audurra Dry Guide Coat during all sanding steps.



**STEP 5:** Feather edge sanding of repaired areas with Audurra Premium Disc C. Machine sand surrounding area with Audurra Premium Disc D.



**STEP 6:** If required prime bare metal sand through areas with Priomat® Reactive Pretreatment Wipes 4000. Flash off. Apply Permasolid® HS Speed Surfacers 5500. Dry.



**STEP 7:** Apply Audurra Dry Guide Coat, Sand repair area with Hand block with Audurra Premium Strip C.



**STEP 8:** Hand sand corners and edges with Audurra Soft Roll E. Sand remaining surface with random orbital sander and Audurra Premium Disc D. Remove sanding dust and clean before masking.



Follow relevant Spies Hecker product TDS's.

Some products in this chart may not be available in Australia & New Zealand however alternatives can be supplied.

This Minor Repair Process for Metal Parts has been performed using products from the Spies Hecker product range.



Spies Hecker – simply closer.

