

NORTON

SAINT-GOBAIN

best
PRACTICE

BODY PREPARATION

BEST PRACTICE

Clean the Repair Area

Wash area with Mothers® Auto Wash, and rinse, then clean with a solvent or waterbased degreaser. Wipe dry with a clean cloth.



RECOMMENDED PRODUCTS

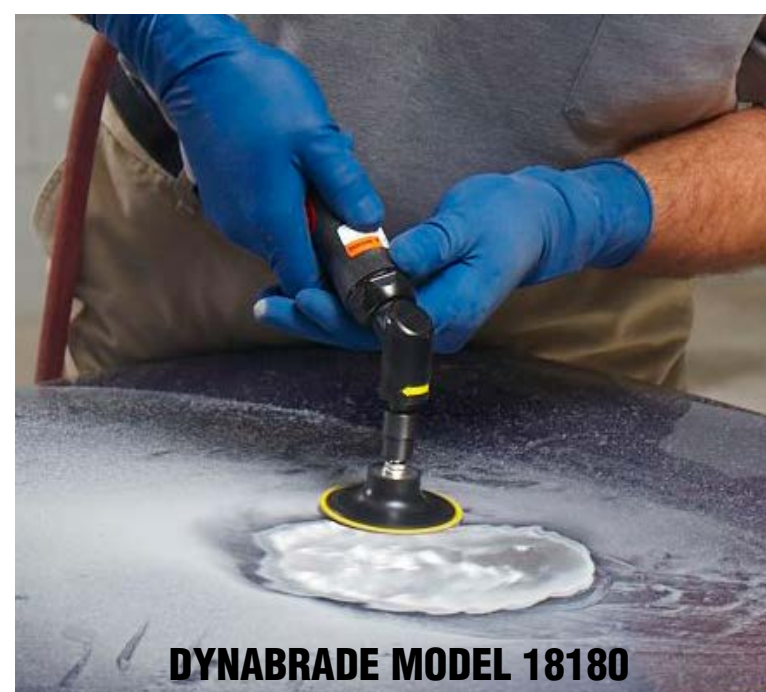
PRODUCT	PART #
Waterbased Cleaner/Degreaser	076607- 21937
Panel and Adhesive Cleaner	076607- 82780
Mothers® Auto Wash 1 Gallon	078175- 80138

Grind the Repair Area

Prepare areas for filler/putty/glaze with 40 to 50 grit then blow off debris with clean, dry air.

Objective: Provide tooth for the filler.

Tip: For aluminum or galvanized steel, use 80 grit.



PRODUCT	PART #
6" PSA BlueFire 40 grit	662611- 23574
6" NorGrip BlueFire 40 grit	662611- 23589
3" Blaze Speed-Lok TR 50 grit	662611- 62330
6" PSA BlueFire 80 grit	662611- 23573
6" NorGrip BlueFire 80 grit	662611- 23588

Prep for Filler

Sand repair area with a DA using 80 grit. Remove debris with clean, dry air.

Objective: Round off the coarse grit scratch on the bare metal to prevent bridging. This will eliminate primer sinking into scratches and reduce pinholes. It will also prepare the paint edge to receive putty or glaze.

Tip: Straighten the metal as necessary prior to applying filler.



PRODUCT	PART #
6" P80 GRIT DRY ICE A975	
PSA	662611- 40512
NorGrip	662611- 40532
NorGrip Multi-Air Cyclonic	776960- 07770

Apply Body Filler

Mix filler on a non-porous mixing board using recommended hardener ratio. Slice and fold in hardener. Do not stir or flip rapidly. Apply filler to panel being careful to keep the body filler within the bare metal area.

Objective: Smooth mixing and application will help eliminate or reduce pinholes.



PRODUCT	PART #
Mixing Spreader	636425- 06396
Norton Premium Filler	636425- 06035
Blue Cream Hardener	636425- 06036

Block or Sand the Body Filler

Begin sanding with 80 grit file, block or DA, then apply the guide coat to identify pinholes or low spots. Finish sand the body filler to eliminate any pinholes and low spots. Wipe off the excess debris then blow with clean, dry air.

Objective: To level the filler and improve the surface finish.



2-3/4" 80 GRIT PRODUCTS	PART #
PSA BlueFire Body File	662611- 23608
Clip-On BlueFire Body File	662611- 23620
NorGrip BlueFire Body File	662611- 23614
PSA Dry Ice A975 Sheet Roll	662611- 49566
NorGrip Dry Ice A975 Sheet Roll	636425- 06261

GUIDE COATS	PART #
Black Powder with applicator	666233- 34772
Carbon Black - aerosol	076607- 21938

Feather Edge and Apply Putty or Glaze

Feather edge the filler and surrounding paint with a DA using 180 grit. Sand from high toward low areas / from center toward outer edge. Blow with clean, dry air. Apply a skim coat of Putty or Glaze over the repair area, overlapping the paint feather edge. Sand the glaze with 180 grit, apply guide coat and continue sanding to remove any pinholes or high spots. Finish sanding with 320 grit (or the grit recommended as per the paint manufacturer's recommendation) then blow with clean, dry air and examine for coarse sand scratches, pinholes or low spots.

Objective: Improve finish and eliminate solvent penetration under the edge of the repair area.



6" DRY ICE A975	PART #
PSA P180	662611- 40508
NorGrip P180	662611- 40528
NorGrip Multi-Air Cyclonic P180	776960- 07775
PSA P320	662611- 55374
NorGrip P320	662611- 49543
NorGrip Multi-Air Cyclonic P320	776960- 07781

PRODUCT	PART #
Norton Premium Glaze	636425- 06032



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