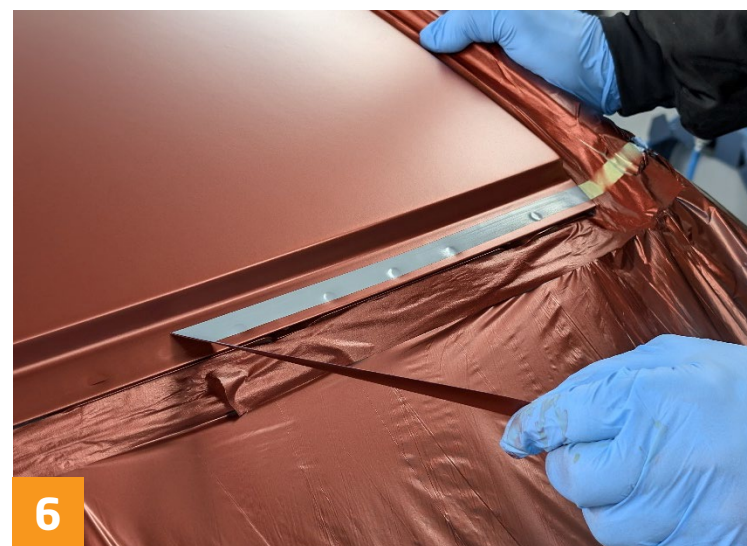
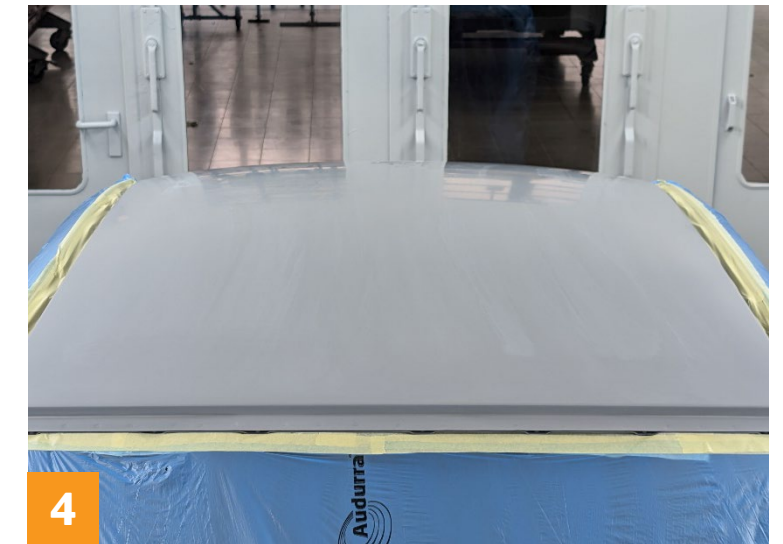


STATIONARY GLASS PROCESS BODY FLANGE IN GLAZING AREA



Step 1: Clean surface

- All pinch welds where glass will be installed need grinding and/or abrading to ensure smoothness and adhesion. Depending on the car make also riveting and bonding might be performed.
- Clean body flange in the glazing area thoroughly by using an appropriate Axalta silicone remover or degreaser. For more details refer to "Preparatory surface degreasing SOP".

Step 2: Apply primer

- Follow OEM procedures for all steps of the process. If OEM procedures do not exist, apply an appropriate Axalta 2K Epoxy Primer Surfacer or Etching Primer followed by a 2K Surfacer/Filler.
- Follow technical data sheet for mixing, application and drying procedures of the products being used.

Step 3: Sand repair

- Sand primed area as usual using DA/orbital sander and P500-P600 disc. Use P800-P1000 for manual sanding.

Step 4: Clean surface

- Clean prepared surface in readiness for topcoat application by following the "Surface cleaning prior to topcoating SOP".

Step 5: Mask body flange

- Mask the primed body flange in the glazing area where glass primer and bonding components will be applied.

Step 6: Apply topcoat

- Apply and dry your chosen Axalta clear over base system or single stage topcoat by following the technical data sheet of the quality being used.
- Remove masking of the body flange.

Step 7: Finalize

- If applicable, apply glass primer to the previously masked area only, or follow OEM procedure for glass installation.



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