

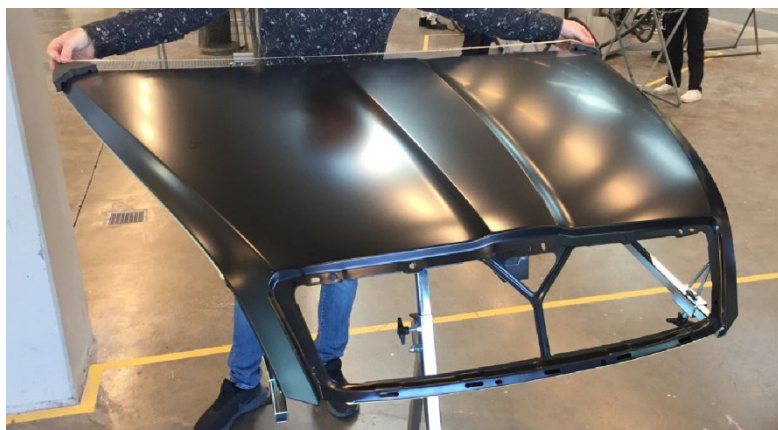
Test Project

Car Painting

Submitted by: Andreas Jansen BASF

Module A - Standard application inside and outside Bonnet

4 hours



Instructions

- Repair damaged area on exterior of Bonnet
 - Mounted on mobile tilting stand.
 - 6-8 dents front side of Bonnet
- Apply Body filler – **Have expert evaluate**
- Apply primer filler. Before sanding have expert evaluate
 - Participant must mix- Primer Filler RFU and use **"Job Card"** in computer program for all mixings.
 - Prepare metal sample for film build Primer Filler 285-2X0, to stick on the bonnet.
 - **Coupon must be given to expert**
 - Sanding filler (grey shade) (Time, sanding material P400/ 500)

Color – 2 Stage

- The Bonnet must be cleaned.
- Participant must mix RFU from given color and use **"Job Card"** in computer program for all mixings!
 - RFU on mixing scale
 - Prepare metal sample for film build, Base coat
 - Apply base inside and outside of the Bonnet Base coat.
 - **Coupon must be given to expert**
- Application of clear coat
 - 929-335
 - Prepare metal sample for film build
 - clear coat coupon must be given to expert



- Clear coat - **gloss finish**
- In and outside high gloss (everywhere)



- Save all dry waste in dry waste material container and all liquid waste in liquid material container.

Module B - Paint a new Fender

2 hours



Instructions

- Prepare the new Fender
 - Check Fender/damages or scratches
 - Sand the fender as needed
- Prepare primer filler wet on wet process
 - Participant must mix- Primer Filler RFU and use **"Job Card"** in computer program for all mixings.
 - Prepare metal sample for film build Primer Filler, to stick on the fender
 - **Coupon must be given to expert**



- Wet on wet primer filler for the Fender

Color – 2 Stage Color is provided on site.

- Participants get the color mixed with 90-905
 - Participant must mix- Base coat RFU and use **“Job Card”** in computer program for all mixings.
 - Prepare metal sample for film build 90 Line, to stick on the fender
 - **Coupon must be given to expert**
- Apply base coats on the Fender
- **Spray the color 90-905**
 - Spray effect coats(s) with color 90-905
- Application of clear 929-335 or 929-135
 - Participant must mix- Clear coat RFU and use **“Job Card”** in computer program for all mixings.
 - Prepare metal sample for film build Clear coat, to stick on the fender
 - **Coupon must be given to expert**
- Clear coat - **gloss finish**



- In and outside high gloss (everywhere)
- Save all dry waste in dry waste material container and all liquid waste in liquid material container

Module C - New Bumper, Color, solid blue

2 Hours



Instructions

Preparation of new bumper transport damaged/scratches

- Preparation of new bumper
- Check the bumper for scratches or defect
 - Participant must mix- Primer Filler RFU and use **"Job Card"** in computer program for all mixing.
 - Prepare metal sample for film build Primer Filler, to stick on the bumper, attach to bumper as shown in the picture below.
- Apply primer fille 285-2X0 included plastic additive sanding version.
 - One spray coat Coupon must be given to expert
 - **Have expert evaluate before applying base coat.**

Color – 2 Stage solid

Color is provided on site.

- Participants get the color
- Participant must mix- Base coat RFU and use "Job Card" in computer program for all mixings.
- Prepare metal sample for film build Base coat, to attach to the bumper as picture below. **Coupon must be given to Expert**



- Apply base coats on the Fender
 - Spray the color
 - Spray the effect coat
 - Color covered edge to edge

Clear coat

- Application of clear 923-135 or 923-335
 - Participant must mix- Clear coat RFU and use **"Job Card"** in computer program for all mixings.
 - Prepare metal sample for film build Clear coat, to stick on the bumper
 - **Coupon must be given to expert**
- Clear coat - **gloss finish**
 - Apply for a high gloss finish (everywhere)
- Save all dry waste in dry waste material container and all liquid waste in liquid material container

Module D - Repair Damaged Fender

2 Hours



Instructions

- Repair damaged area on exterior of Fender
 - Damaged area front of the Fender where card was sprayed
 - Sand damaged area
- Apply primer filler
 - Apply UV primer filler
 - Sand filler recommended at "Glasurit Know How"

Color – 2 Stage

Use color from Module D

- Participants get the color
- Participant must mix- Base coat RFU and use **"Job Card"** in computer program for all mixings.
- Apply M50 before base coat
 - Participant must mix- M50 RFU and use **"Job Card"** in computer program for all mixings.
 - Apply as recommended
- Apply base 90 Line/90-905 on the Filler area
 - Complete blending process

Clear coat

- Application of clear
 - Participant must mix- Clear RFU and use **"Job Card"** in computer program for all mixings.
 - 923-135 or /923-335

- Clear coat – **gloss finish**
 - Apply to a high gloss finish
 - Save all dry waste in dry waste material container and all liquid waste in liquid material container

Module E - Vehicle Masking

1 hour



Instructions for Masking

- Mask the given area of the vehicle
 - Front Fender right



- Back door left



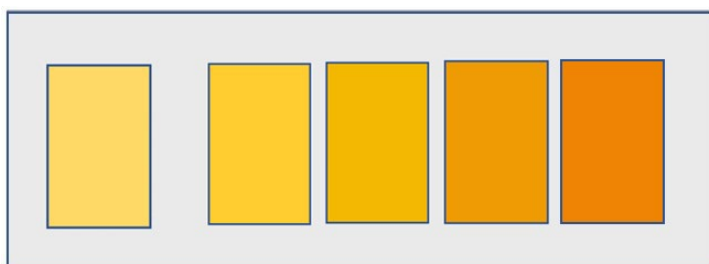
- Use the making material as needed, to mask the give areas of the car, interior and exterior
- **Do not** use masking paper in the exterior of the car
- Experts must score before masking material is removed
- **Save all dry waste in dry waste material container**

Module F - 3 Stage Color

Starting point

The delegate will get the colors for the 3-stage application and one pre-painted color sample.

- You must produce spray samples representing the different color depths/variants and select the one that will give the best match. **This must be given to the Expert.**
- Attention must particularly be paid to the interaction of the undercoat color and subsequent effect color in combination with the number of spray coats and spray coat thicknesses.
- Application of the process below:
 1. Color tone, "Gray shade" or tinting base
 2. Base coat step 1 (solid, metallic, mother of pearl color)
 3. Base coat step 2 (translucent color standard)
 4. Clear coat



Note: Color samples must be produced to define the number of effect color spray passes required prior to repair.

Save all dry waste in dry waste material container and all liquid waste in liquid material container

Module G - Design inside Bonnet

3 Hours

Instructions

For Module G we will use the internal side of the Bonnet



The left side must show the WorldSkills Logo/Icon as stand alone

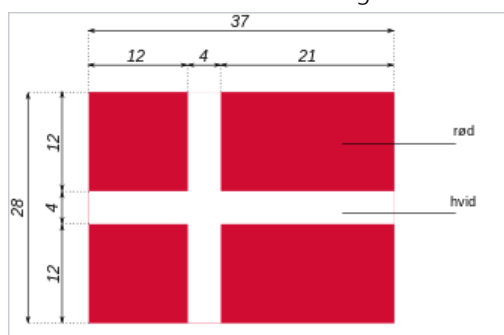
The right side must show the flag of Denmark

The WorldSkills Logo



The right side must show the Dannebrog, flag of Denmark

Construction of the Dannebrog for Module G, because of the using area the size will change!



The sample above is 50 % larger: The actual size for you to produce is listed below.

Down the side: The two red rectangles each have a side length of 6CM. The white cross is 2CM. The total length, $6+2+6 = 14$

Across the top: The first red rectangle is 6CM wide. The white cross is 2CM. The second rectangle is 10,5CM wide. $6+2+10,5 = 18,5$

Prepare the inside of the Bonnet.

- Masking around the design area

Colors for WorldSkills Logo/Icon

Color – 2 Stage

- Participants get premix color
 - Participant must mix- Base coat RFU and use **“Job Card”** in computer program for all mixings.
 - Red color
 - White color
 - Blue color
 - RFU on mixing scale with IC330 100:5:50/70
- Apply first base colors on the design area
 - Masking the area for Danish flag, Dannebrog and WorldSkills logo
 - Apply the paint as needed
 - Application of clear
 - 929-135 or 923-335
 - Clear coat - **gloss finish**
 - Design area in high gloss (everywhere)



Save all dry waste in dry waste material container and all liquid waste in liquid material container

Module H – Polishing

1 Hour



Instructions

- Polishing the sprayed Bonnet
 - Check the bonnet for imperfections
 - Remove the defects with appropriate grit sandpaper
 - Complete the polishing process
- Have all dry waste in dry waste material container

