

AZT Paint operations within Audatex

Paint Operations for metal panels

Operations		Paint Structure	New Part Paint	Blend & Paint	Repair paint < 50%	Repair Paint > 50%	Comments
Pre Preparation for painting	Movement of vehicle & panels		✓	✓	✓	✓	New bolted panels are assumed to be delivered in perfect condition not requiring any repair finished in factory e-coat
	Hand over of job, including specifying scope of job		✓	✓	✓	✓	
	Recording the time on the job		✓	✓	✓	✓	
	Preparing, cleaning and clearing away installations, tools, equipment & materials		✓	✓	✓	✓	New welded panels are assumed to be delivered in perfect condition not requiring any repair finished in factory e-coat. The welded area is assumed to be finished off using 80g paper by the panel beater.
	Identify colour		✓	✓	✓	✓	
	Mix colour and carry out spray out for colour match		✓	✓	✓	✓	
	Prepare all spraying materials		✓	✓	✓	✓	
	Fit and remove protective clothing and PPE		✓	✓	✓	✓	It is not considered the job of the painter to rectify imperfect contours or pin holing
	Mask the vehicle and cover with plastic sheet		✓	✓	✓	✓	
	Flash off times		✓	✓	✓	✓	
	Drying and cleaning of panel(s)		✓	✓	✓	✓	✓
Paint application	Clean panel several times		✓	✓	✓	✓	
	Apply and remove masking		✓	✓	✓	✓	The use of lifter tapes is not included
	Apply etch primers		✓		✓	✓	Small areas of bare metal around repaired areas and welded joints where necessary
	Apply build primer		✓		✓	✓	Small imperfections and welded joints on new panels where necessary . Across the surface area of any repaired areas where necessary
	Flat or sand build primers		✓		✓	✓	Ready for the next process
	Apply wet on wet primers		✓		✓	✓	To provide uniform substrate
	Apply light stone chip primers		✓		✓	✓	
	Apply Basecoat to achieve uniformity, colour match & the required level of opacity to:		✓	✓	✓	✓	
	External surface of panel						
	Internal surface of panel		✓				
	Apply Clearcoat		✓	✓	✓	✓	
	De-nib & polish		✓	✓	✓	✓	Only to remove minor dirt nibs, not to obtain a finish
Items NOT included in the paint operations listed above							

- Work in the engine bay that involves a second colour coat (where the second colour is not applied as part of the priming operation, e.g. localising a slam panel or flitch panel)
- Removal of protective wax and preservative materials (relating to new vehicles not yet on the road)
- Application of underbody protection materials (Some vehicle manufacturers allow for this in their panel operations. Refer to the Seam Sealer Matrix on the Audatex website: www.audatex.co.uk)
- Application of sealants (Some vehicle manufacturers allow for this in their panel operations. Refer to the Seam Sealer Matrix on the Audatex website: www.audatex.co.uk)
- Cavity wax reinstatement
- Use of lifter tapes
- Paint internal parts:
 - Vehicle floor pan (passenger cell compartment floor pan)
 - Dashboard (metal panel)
 - Rear parcel shelf
- No time or materials are included to polish in the edges of localised clearcoats. For example: C posts, D posts, Sills, front and rear panels, roof rails, etc.
 - Time and materials for polishing localised clearcoat should be added manually into Zone 99
- Fade out thinners are not included in any AZT paint process
- Detailed masking of items left in situ

AZT paint operation V3

Paint and Materials List for metal panels

Prices do NOT include Mica, pearlescent or xirallic basecoats. For Pearl and Mica finishes use the Pearlescent uplift feature in Audatex UK

Paint and materials. VOC Compliant systems	Flattening Papers:	Hardeners – Activators:
	• Hand flattening paper	• Activator for primers
	• Flattening discs (DA)	• Activators for clearcoats
	• Flattening discs (DA< adhesive)	• Activators for high solid colours
	• Fibre sanding discs	Thinners and cleaners:
	• Scotchbrite sheets	• 2K Thinner (primers and clearcoats)
	Stoppers:	• Basecoat reducer & additives
	• Polyester stoppers	• Silicone remover & degreasers
	• Spray filler (high build primers)	• Gun wash thinners
	• Soft fine for plastics	Material for special operation:
	Primer fillers:	• Thin aerosol type stone chip
	• Reactive primers (etch)	Sundry items:
	• 2K High solids primer filler	• Masking paper 20cm wide
	Clearcoats:	• Masking paper 90 cm wide
	• 2kKHigh solid clearcoats	• Masking tape 19mm
	• Matt clearcoats	• Edging tape (lining tape)
Colour coats:	• Disposable face masks	
• 2K High solid one coat colours	• Plastic sheeting	
• Waterborne solid basecoats		
• Waterborne metallic basecoats		

Arrival and delivery of panels and vehicles to the paintshop

Delivery condition of panels and vehicles into the paintshop	New panels (bolted)	Delivered without imperfection, finished in factory e-coat
	New panels (welded)	Panel delivered on the vehicle without imperfection, finished in factory e-coat. Spot welded seams are expected to be cleaned up by the panel beater using a nylon wheel to a bright condition. Panel joints are expected to be metal finished or smoothed with body filler to perfect contours without pin holing and finished using 80g abrasives
	Repaired panels	Paint edge to have been feathered out by the panel beater using 80g abrasives. Body filler to be finished by the panel beater to perfect contour without pin holing using 80g abrasives. Painter should be able to achieve a surface ready to receive colour in two processes: 1) preparation and application of build primer. 2) Flat - block build primer ready for wet on wet primer application (includes tinted or spectral coloured primers) Where the panel beater has achieved a "metal finish" the surface should be free from evidence of filing, the surface to be finished using 80g abrasives If blocking of hi build primers is required to achieve perfect contours this is deemed to be a panel operation and not a paintshop operation.
	Blend panels	Delivered to the paintshop without scratches, stone chips or panel surface defects. Panel should only require surface preparation using a Scotchbrite pad All blend panels are expected to be rust free

Paint operations for plastic components								
Operations		New parts				Repaired parts		Comments
		Primed (LE1)	Not Primed (LE2)	Not primed texture Hard (LE3)	Not primed texture Soft (LE4)	Blend & Paint	Repair Paint <50%	
Paint application	Clean panel several times	✓	✓	✓	✓	✓	✓	
	Apply and remove masking					✓	✓	New bumpers are assumed to be off the vehicle and to have all sub components removed
	Temper component				✓			
	Eliminate spores				✓			
	Flat or sand to prepare surface	✓	✓	✓	✓	✓	✓	
	Apply bonding agent		✓	✓	✓		✓	
	Elastify paint	✓	✓	✓	✓	✓	✓	To paint manufacturer's recommendations
	Fill texture- surface defects			✓				Using polyester stoppers for plastic
	Apply build primer						✓	
	Flat or sand build primers							
	Apply wet on wet primers		✓	✓	✓		✓	
	Apply colour coats	✓	✓	✓	✓	✓	✓	
	Apply clearcoats	✓	✓	✓	✓	✓	✓	
De-nib & polish	✓	✓	✓	✓	✓	✓	Only to remove minor dirt nibs. NOT to obtain a finish	

Paint and Materials List for Plastic Components

Prices do **NOT** include Mica, Pearlescent or Xirallic basecoats. For Pearl and Mica finishes use the Pearlescent uplift feature in Audatex UK

Paint and materials. VOC Compliant systems	Flattening Papers:	Hardeners – Activators:
	• Hand flattening paper	• Activator for primers
	• Flattening discs (DA)	• Activators for clearcoats
	• Flattening discs (DA< adhesive)	• Activators for high solid colours
	• Fibre sanding discs	Thinners and cleaners:
	• Scotchbrite sheets	• 2K Thinner (primers and clearcoats)
	Stoppers:	• Basecoat reducer & additives
	• Stopper for plastic repair (3m 5900)	• Silicone remover & degreasers
	• Spray filler (high build primers)	• Gun wash thinners
	• Soft fine for plastics	Material for special operation:
	Primer fillers:	• Adhesive promoter
	• 1K Plastic primer	Sundry items:
	• 2k High solids primer filler	• Masking paper 20cm wide
	Clearcoats:	• Masking paper 90 cm wide
	• 2K High solid clearcoats	• Masking tape 19mm
	• Matt clearcoats	• Edging tape (lining tape)
Colour coats:	• Disposable face masks	
• 2K High solid one coat colours		

	<ul style="list-style-type: none"> • Waterborne solid basecoats 	
	<ul style="list-style-type: none"> • Waterborne metallic basecoats 	
Delivery condition of components and vehicles into the paintshop	Arrival and delivery of components and vehicles to the paintshop	
	Structural repairs are expected to have been carried out by the panel beater and to be finished using 80g abrasives	
	Scratches and abrasions to the component are to be no deeper than 1mm and not exceeding 2xDm ² (small parts) and less than 15% of the surface area of larger components such as bumpers etc.	
	If textured bumpers are required to have a smooth finish appearance after painting then additional build primers should be applied to allow blocking and flattening to prepare the surface to receive wet on wet primers.	
	Additional time for these operations should be entered manually in Zone 99	
If the surface area of the repair is larger than 15% of the surface area, on large components, and additional time and materials are required they should be entered into Zone 99		
Selecting >50% will have no effect on the paint operations time and will not provide any uplift in paint and materials for painting plastic components		
Items NOT included in the paint operations listed above		
<ul style="list-style-type: none"> • Detailed masking of items left in situ 		

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