

# Hail Damage Repair

**FOR PROFESSIONAL USE ONLY**

## Description

This Bulletin describes the optimum repair system for substrate damages caused by hail.

## Process steps

Dent removal should be executed to such an extent that the maximum film build of body filler does not exceed 500 µm. Polysurfacer application should not be over 300 µm.



Remove surface contamination using the appropriate surface cleaner.  
 Next, clean the surface with warm water and detergent, rinse sufficiently with clean water.



P80/P120                      Remove the existing finish.  
 P220                              Sand a larger featheredge with P220 grit.



Remove surface contamination using the appropriate surface cleaner.



Apply a single coat of Primer Surfacer EPII

**Important:**

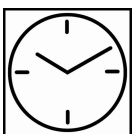
- Apply a maximum layer thickness of 15 – 25 µm.
- To avoid lifting do not apply Primer Surfacer EPII too wet.



**Recommended:**

5 minutes low power      10 minutes high power                      50 – 70 cm distance

Allow 5 minutes flash-off prior to infra red curing  
 Temperature should not exceed 100°C.



**Optional:**

45 minutes at 60°C or 16 hours at 20°C



P220-P320                      Abrade the Primer Surfacer EPII.  
 ➤ Do not sand through the Primer Surfacer EPII.

Apply the appropriate polyester bodyfiller or Polysurfacer

**Important:**

In case of using Polysurfacer, first apply a thin coat to avoid lifting and flash off for at least 5 minutes.

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After drying sand the polyester bodyfiller or Polysurfacer with P120 – P220 grit.

**Important:**

After sanding, the maximum film build of body filler should not exceed 500 µm. Polysurfacer application should not be over 300 µm.

**Important:**

Sikkens Polysurfacer should not be applied to bare metal. Therefore it is advised to precede with a single coat of Primer Surfacer EPII and dry as described before.



Apply Primer Surfacer EPII according to TDS 2.4.5



**Recommended:**

15 minutes **Low** power, 50 – 70 cm distance.  
 Temperature should not exceed 90°C.



**Optional:**

45 minutes at 60°C or 16 hours at 20°C



After drying sand the Primer Surfacer EPII with P320 – P400/P500 grit.



Remove surface contamination using the appropriate surface cleaner



Apply required topcoat according to the respective TDS



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