



# BODY PREPARATION

## BEST PRACTICE

## RECOMMENDED PRODUCTS

### Clean the Repair Area

Wash area with soap and water then use a wax and grease remover. Wipe dry with a clean cloth.



### Grind the Repair Area

Prepare areas for filler/putty/glaze with 36 to 50 grit then blow off debris with clean, dry air.

**Objective:** Provide tooth for the filler.



PRODUCT	PART NO.
3" Carbo Fire Flex-Loc TR 50 grit	<b>99389</b>
3" Flex-Loc TR Back-Up Pad	<b>55105</b>
6" PSA Premier Red 40 grit	<b>21301</b>
6" Grip-On Premier Red 40 grit	<b>21316</b>

### 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.



6 INCH	PREMIER RED DRI-LUBE PSA	PREMIER RED DRI-LUBE GRIP-ON	PREMIER RED DRI-LUBE CLEANAIR
P80 grit	<b>18173</b>	<b>20289</b>	<b>99325</b>

### 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 NO.
Mixing Spreader	<b>06396</b>

### Block the Body Filler

Shape the filled areas with 40 grit file or block paper.

**Objective:** To level the filler surface.



PRODUCT	PART NO.
PSA Premier Red Body File 40 grit	<b>21337</b>
Clip-On Premier Red Body File 40 grit	<b>21349</b>
PSA and Clip-On Body File board	<b>12013</b>
Grip-On Premier Red Body File 40 grit	<b>21343</b>
Grip-On Body File Board	<b>12014</b>

### Sand the Body Filler

Finish sand the body filler with 80 grit file, block or DA then wipe off the excess debris then blow with clean, dry air to remove sanding dust and inspect for pinholes and low spots.

**Objective:** Improve surface finish.



PRODUCT	PART NO.
2-3/4" PSA Sheet Roll P80 Premier Red Dri-Lube	<b>20340</b>
2-3/4" PSA Sheet Roll P80 White Lightning	<b>99349</b>
2-3/4" x 7-3/4" Firm Block PSA	<b>70405</b>

### 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. Final sand with 180 to 220 grit, as per 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 INCH	PREMIER RED DRI-LUBE PSA	PREMIER RED DRI-LUBE GRIP-ON	PREMIER RED DRI-LUBE CLEANAIR
P180	<b>18169</b>	<b>20284</b>	<b>99328</b>
P220	<b>18168</b>	<b>20283</b>	<b>99329</b>
P320	<b>18165</b>	<b>20277</b>	<b>99331</b>
Back-Up Pads	<b>99319</b>	<b>99323</b>	<b>99337</b>



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