













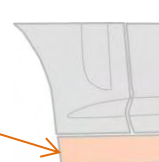


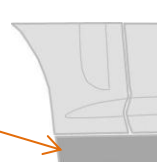







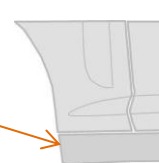


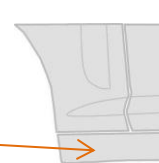

# Land Rover Standard Operating Procedure

Steel coating process for new replacement parts

## Landrover Steel Repair Guidelines

Mild steel is used on many structural and some minor body sections of Land Rover vehicles and must be handled and repaired with care to avoid cross-metal contamination maintain the long life warranty of the part and vehicle.



<p>01. <b>New replacement part preparation</b></p>	<p>Inspect parts for damage. Clean with silicone remover before sanding begins.</p>	 <p>Wet a lint free cloth and wipe on to clean the part. Do not allow to dry on the surface.</p>	 <p>Wipe dry with a lint free cloth.</p>	<p>Welded areas need to be carefully sanded to remove weld-splatter and burnt paint layers. Feather the repair edges.</p>	 <p>Sand the rest of new part with grey pad or e-coat abrasive.</p>	 <p>Re clean as earlier.</p>	
<p>02. <b>New or damaged replacement part preparation</b></p>	<p>Identify the extent of the damage. Clean with silicone remover before sanding.</p>	 <p>Wet a lint free cloth and wipe on to clean the part. Do not allow to dry on the surface.</p>	 <p>Wipe dry with a lint free cloth.</p>	<p>For dents, scratches or any breaks in the electro coat use standard sanding tools and equipment.</p>	 <p>Sand with P180 for dents and fill. Sand with P240-320 for break through areas.</p>	 <p>After drying, sand the stopper areas with P240-320 until shaped and feathered in.</p>	 <p>Re clean as earlier</p>
<p>03. <b>New or damaged replacement part preparation etch &amp; prime</b></p>	<p>All <b>exposed bare steel</b> must be coated with an approved 2K Etch Primer <b>before</b> applying Primer Filler.</p>	 <p>Mix and apply the 2K Etch Primer according to the TDS.</p>		 <p>Dry as TDS.</p>	 <p>Mix 2K Primer or 2K Surfacer and apply to the entire part or zones.</p>		 <p>Dry as TDS.</p>
<p>04. <b>New or repaired replacement part primer sanding</b></p>	<p>Dried primed areas and blending zones can now be sanded ready for colour.</p>	 <p>Sand primer and old paint with P400-500.</p>	 <p>Sand blend areas with P1000-2000.</p>	 <p>Re clean.</p>	 <p>Wipe dry.</p>	 <p>Welded joints can now be sealed before paint is applied.</p>	
<p>05. <b>Basecoat colour for primed parts</b></p>	<p>Primed and sanded parts can now be painted with approved basecoat material.</p>	 <p>Mix and apply the basecoat colour according to the TDS.</p>		 <p>Dry as TDS.</p>			
<p>06. <b>Clear coat for base coated or fine sanded parts</b></p>	<p>After drying the base coat the approved clear coat can be mixed and applied.</p>	 <p>Mix according to the TDS.</p>		 <p>Dry as TDS.</p>			