

valspar®  
REFINISH



# Valspar Refinish

Process Guide for Vehicle Repairs



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## High Performance Finishes That Drive Success

The Valspar Refinish system is known for its versatility, compact range and easy-to-use characteristics. The simplicity of the system lies in the proprietary tinting technology. One set of universal tinters allows you to create acrylic, basecoat, and single-stage 2K polyurethane topcoat systems.

This booklet contains easy to read process charts for painting a range of different substrates. It is designed to allow sales staff to assist customers in choosing the correct system and products for their job.

For more information on any product, contact Valspar Automotive.

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REFINISH

### SAFETY FIRST!

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# QUICK MIXING CHART

SERIES	PRODUCT NAME	FUNCTION	MIXING RATIO	MIXING STICK	ACTIVATOR				HIGH PERFORMANCE REDUCER		
					VERY FAST	FAST	STANDARD	SLOW	FAST	MEDIUM	SLOW
<b>PRIMERS</b>											
DTM2035	DTM PRIMER ( DIRECT TO METAL)	PRIMER	4 : 1 : 1	MS1		DTM 2035 ACTIVATOR			171HP	172HP	173HP
		SEALER	4 : 1 : 2	MS1					171HP	172HP	173HP
-	VALSPAR INDUSTRIAL ETCH	PRIMER	0-30%	-		NONE			171HP	172HP	173HP
AP33	1K ACRYLIC PRIMER	PRIMER	2 : 1	-		NONE			30MP Multi-Purpose Reducer		
VP50	EPOXY PRIMER	PRIMER	4 : 1 : 1	MS1		VPC 50 ACTIVATOR			171HP	172HP	173HP
		SEALER	4 : 1 : 2	MS1					171HP	172HP	173HP
HS35	HS PRIMER SURFACER	SURFACER	4 : 1 : 1	MS1	HPC3	HPC2	HPC1	HPC0	171HP	172HP	173HP
		SEALER	4 : 1 : 2	MS1	X				171HP	172HP	173HP
<b>TOPCOATS</b>											
303C01	1K ACRYLIC TOPCOAT		1 : 1.5	-		NONE			30MP Multi-Purpose Reducer		
888C88	HIGH PERFORMANCE BASECOAT BINDER		1 : 1	MS3		NONE			171HP	172HP	173HP
862	2K TOPCOAT		4 : 1 : 0-10%	MS1	HPC3	HPC2	HPC1	HPC0	171HP	172HP	173HP
<b>CLEARCOATS</b>											
AC200MS	MS CLEARCOAT		4 : 1 : 0 - 5%	MS1	HPC3	HPC2	HPC1	HPC0	171HP	172HP	173HP
AC4400	HS CLEARCOAT		2 : 1 : 1	MS3	HPC3	HPC2	HPC1	HPC0	171HP	172HP	173HP
AD4200	AIR CURE CLEAR		4 : 1 : 0 - 5%	MS1			HPC420	HPC400	171HP	172HP	173HP
AC303	1K ACRYLIC CLEAR		1 : 1.5	-		NONE			30MP Multi-Purpose Reducer		
<b>SPECIALTIES</b>											
PR2	PLASTIC ADHESION PROMOTER		R.F.U	-	-	-	-	-	-	-	-
Z777	MID COAT ADHESION PROMOTER		R.F.U	-	-	-	-	-	-	-	-
BZ1	UNIVERSAL BLENDING SOLVENT		R.F.U	-	-	-	-	-	-	-	-
T566	ACCELERATOR		-	-		NONE			-	-	-

## System Key:

**AC** Process uses Acrylic based products

**EP** Epoxy Primer

**DTM** Direct to Metal. Do not apply bodyfiller over top

**ETCH** Etch Primer

**SAND** Sand the Primer before applying topcoat

**WOW** Wet-On-Wet. No need to sand the primer before applying topcoat.

**2K** Direct gloss colour, no need for clear coat.

**BC** Base coat colour. Needs clear coat over it.

**AL** For use over Aluminium

**ST** For use over steel

**PL** For use over plastic

**FG** For use over fibreglass

**+3** For more than 3 panels.

**-3** For 3 or less panels.

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# BASE COAT ACRYLIC PROCESS FOR ALUMINIUM AND STEEL

SYSTEM NUMBER: **1-10**



1

Preparation



Clean panel with 155 Surface Cleaner



Feather edges with P180 or P240



Red Scotch-Brite or hand pad P800 all key edges & difficult areas



Clean panel with 155 Surface Cleaner

2

Industrial Etch

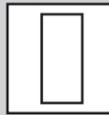


Industrial Etch



171HP-173HP

0-30%



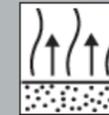
171HP-173HP Up to 30% if required



Set up/Air Pressure 1.4-1.8mm 2 Bar



Apply 1 - 2 medium wet coats



Flash 5-10 min between coats

3

AP33 Acrylic Primer

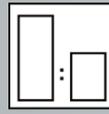


AP33



30MP

Mix Ratio 2 1



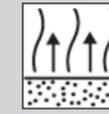
2:1 30MP Multi-Purpose Reducer



Setup/Air Pressure 1.5-2mm 1.7-2 Bar



Spray 1-4 coats maximum 100 microns



Flash for 5-7 mins between coats



Dry to sand 60 min per coat at 20°C

4

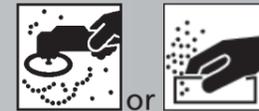
Preparation



Guide coat and block the repair with P240



Guide coat and feather out with P500 on a 3mm orbital sander



Use P800/P1000 into blend areas



Grey Scotch-Brite or a hand pad P800 to key difficult areas



Clean with 155 Surface Cleaner

5

303C01 Acrylic Binder

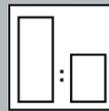


303C01



30MP

Mix Ratio 1 1.5



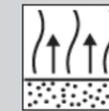
1:1.5 30MP Multi-Purpose Reducer



Setup/Air Pressure 1.4-2mm 1.7-2 Bar



Apply 2-4 coats



Flash for 5-7 mins between coats



Note: Make sure basecoat has flashed off thoroughly before clear is applied

6

AC303 Acrylic Clear

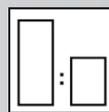


AC303



30MP

Mix Ratio 1 1.5



1:1.5 30MP Multi-Purpose Reducer



Setup/Air Pressure 1.4-2mm 1.7-2 Bar



Apply 2-4 coats



5-7 mins between coats 24 hours to polish



Air dry 20°C 30 min dry to handle 24hrs dry to polish

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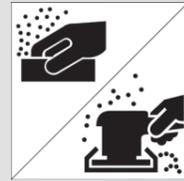
# BASE COAT PLASTIC PROCESS USING 1K ACRYLIC



SYSTEM NUMBER: **1-20**

**1**

Preparation



  
Clean panel with  
155 Surface Cleaner

 or   
Feather edges with  
P180 or P240

  
Red Scotch-Brite or hand pad  
P800 all key edges & difficult  
areas

  
Clean panel with  
155 Surface Cleaner

**2**

PR2  
Plastic Primer



PR2  
Ready For Use



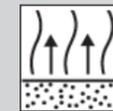
RFU



Setup/Air Pressure  
1.5-2mm  
1.7-2 Bar



Spray 1 Coat



Flash for 5-7 mins

**3**

AP33  
Acrylic Primer

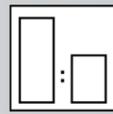


AP33



30MP

Mix Ratio **2** **1**



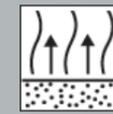
2:1  
30MP Multi-Purpose Reducer



Setup/Air Pressure  
1.5-2mm  
1.7-2 Bar



Spray 1-4 coats  
maximum 100 microns



Flash for 5-7 mins  
between coats



Dry to sand  
60 min per coat at 20°C

**4**

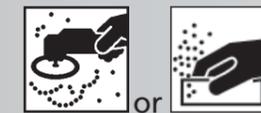
Preparation



Guide coat and block the  
repair with P240



Guide coat and feather out with  
P500 on a 3mm orbital sander



Use P800/P1000 into blend areas



Grey Scotch-Brite or a hand pad  
P800 to key difficult areas



Clean with 155  
Surface Cleaner

**5**

303C01  
Acrylic Binder

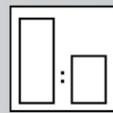


303C01



30MP

Mix Ratio **1** **1.5**



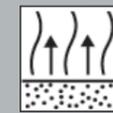
1:1.5  
30MP Multi-Purpose Reducer



Setup/Air Pressure  
1.4-2mm  
1.7-2 Bar



Apply 2-4 coats



Flash for 5-7 mins  
between coats



Note: Make sure basecoat has  
flashed off thoroughly before  
clear is applied

**6**

AC303  
Acrylic Clear

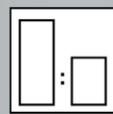


AC303



30MP

Mix Ratio **1** **1.5**



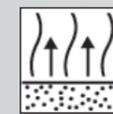
1:1.5  
30MP Multi-Purpose Reducer



Setup/Air Pressure  
1.4-2mm  
1.7-2 Bar



Apply 2-4 coats



5-7 mins between coats  
24 hours to polish



Air dry 20°C  
30 min dry to handle  
24hrs dry to polish

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# 2K ALUMINIUM & STEEL USING DTM2035 DIRECT TO METAL PRIMER FOR WET-ON-WET

SYSTEM NUMBER: **2-10**

**2K** **DTM** **WOW** **ST** **AL**

V2.0520

**1**

Preparation



Clean panel with 155 Surface Cleaner



Sand panel with P320 or P400



Red Scotch-Brite or hand pad P800 all key edges and difficult areas



Clean panel with 155 Surface Cleaner

**2**

DTM2035 Surfacer/  
Sealer



DTM2035



DTMA2035



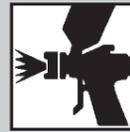
171HP-173HP

Mixing Ratio

4

1

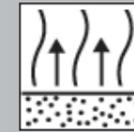
2



Setup/Air Pressure  
1.2-1.4mm  
2 Bar



Apply 1 coat



Flash 10-15 min or until  
Matt

**3**

862 2K  
Topcoat



862



HPC0-HPC3



171HP-173HP

Mixing Ratio

4

1

0-10%



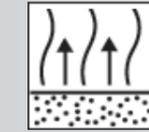
Clean panel with 155 Surface Cleaner



Setup/Air Pressure  
1.3-1.5mm  
2 Bar



Apply 2-3 Coats



Flash for 5-10 mins between  
coats



Air dry 20°C Overnight  
Bake 60°C 30 min

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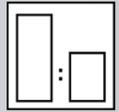
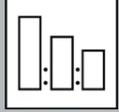
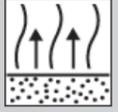
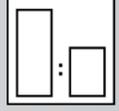
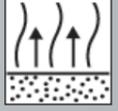


# 2K ALUMINIUM & STEEL ETCH USING INDUSTRIAL ETCH PRIMER FOR WET-ON-WET



SYSTEM NUMBER: **2-20**

V2.0520

1	Preparation		 <p>Clean panel with 155 Surface Cleaner</p>	 <p>Sand Repair area, remove all OEM paint with P80 followed by P180</p>	 <p>Fill repair with 6010 Uni Putty</p>	 <p>Block repair with P80 or P180 depending on repair. Always finish with P180</p>	 <p>Feather edges with P180 or P240</p>	 <p>Clean panel with 155 Surface Cleaner</p>
2	Industrial Etch	 <p><b>Industrial Etch</b></p>	 <p>171HP-173HP Up to 30% if required</p>	 <p><b>171HP-173HP</b> 0-30%</p>	 <p>Set up/Air Pressure 1.4-1.8mm 2 Bar</p>	 <p>Apply 1 - 2 medium wet coats</p>	 <p>Flash 5-10 min between coats</p>	
3	HS35 Multi-use 2K Surfacer/Sealer	 <p><b>HS35</b></p>	 <p>4:1:2 HPC0-2</p>	 <p><b>HPC0-HPC3</b></p>	 <p><b>171HP-173HP</b></p>	 <p>Set up/Air Pressure 1.3-1.5mm 2 Bar</p>	 <p>Apply 1 medium closed coats</p>	 <p>Flash off 10-15 mins or until matt</p>
4	862 2K Topcoat Binder	 <p><b>862</b></p>	 <p>4:1:0-10% HPC0-3</p>	 <p><b>HPC0-HPC3</b></p>	 <p><b>171HP-173HP</b></p>	 <p>Setup/Air Pressure 1.3-1.5mm 2 Bar</p>	 <p>Apply 2-3 Coats</p>	 <p>Flash for 5-10 mins between coats</p>  <p>Air dry 20°C Overnight Bake 60°C 30 min</p>

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# 2K FIBREGLASS USING DTM2035 DIRECT TO METAL PRIMER FOR WET- ON-WET

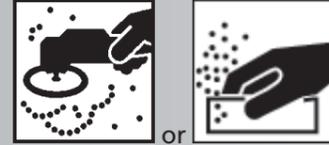
SYSTEM NUMBER: **2-30**

1

Preparation



Clean panel with 155 Surface Cleaner



Sand panel with P320 or P400



Red Scotch-Brite or hand pad P800 all key edges and difficult areas



Clean panel with 155 Surface Cleaner

2

DTM2035 Surfacer/  
Sealer



DTM2035



DTMA2035

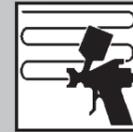


171HP-173HP

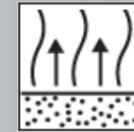
Mixing Ratio 4 1 2



Setup/Air Pressure  
1.2-1.4mm  
2 Bar



Apply 1 coat



Flash 10-15 min or until  
Matt

3

862 2K  
Topcoat



862



HPC0-HPC3



171HP-173HP

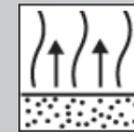
Mixing Ratio 4 1 0-10%



Setup/Air Pressure  
1.3-1.5mm  
2 Bar



Apply 2-3 Coats



Flash for 5-10 mins between  
coats



Air dry 20°C Overnight  
Bake 60°C 30 min

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# 2K ALUMINIUM & STEEL USING DTM2035 DIRECT TO METAL PRIMER FOR SANDING

SYSTEM NUMBER: **2-40**

SAND 2K DTM ST AL

1	Preparation								
		Clean panel with 155 Surface Cleaner	Sand panel with P320	Red Scotch-Brite or hand pad P800 all key edges and difficult areas	Clean panel with 155 Surface Cleaner				
2	DTM2035 Surfacers/ Sealer								
		DTM2035	DTMA2035	171HP-173HP	Setup/Air Pressure 1.2-1.4mm 2 Bar	Apply 1-3 coats	Flash 10-15 min or until Matt		
		<b>Mixing Ratio</b>		4	1	1			
3	Preparation								
		Guide coat and block the repair with P240	Guide coat with P500 on a 3mm orbital sander or by hand	Use P800/P1000 into blend areas	Grey Scotch-Brite or a hand pad P800 to key difficult areas	Clean panel with 155 Surface Cleaner			
4	862 2K Topcoat								
		862	HPC0-HPC3	171HP-173HP	Clean panel with 155 Surface Cleaner	Setup/Air Pressure 1.3-1.5mm 2 Bar	Apply 2-3 Coats	Flash for 5-10 mins between coats	Air dry 20°C Overnight Bake 60°C 30 min
		<b>Mixing Ratio</b>		4	1	0-10%			

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# 2K REPAIR ALUMINIUM EPOXY PROCESS FOR SANDING

SYSTEM NUMBER: **2-50**

1

Preparation



Clean panel with 155 Surface Cleaner



Sand repair area, remove all OEM paint with P80 followed by P180



Clean with 155 Surface Cleaner

2

VP50 Epoxy Primer



VP50

VP50 Activator

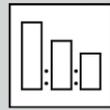
171HP-173HP

Mixing Ratio

4

1

2



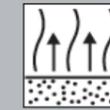
4:1:2 HPC0-3



Set up/Air pressure 1.3-1.4mm 2 Bar



Apply 1 medium closed coat



Flash for 45 min at 20°C



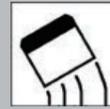
Air Dry 20°C 16 Hours  
Bake 60°C 1 Hour

3

Preparation



Sand area to be repaired with P180



Fill repair



Block repair with P80 or P180 depending on repair. Always finish with P180



Feather edges with P180 or P240

4

HS35 Multi-use 2K Surfacer/ Sealer



HS35

HPC0-3

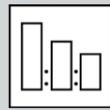
171HP-173HP

Mixing Ratio

4

1

1



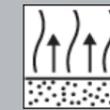
4:1:1 HPC0-3



Set up/Air Pressure 1.6-1.8mm 2 Bar



Apply 1-3 coats



Flash off until matt between coats



Air dry 20°C 16 Hours  
Bake 60°C Object 20-30 mins

5

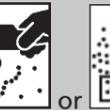
Preparation



Guide coat and block the repair with P240



Guide coat and feather out with P500 on a 3mm orbital sander



Use P800/P1000 into blend areas



Grey Scotch-Brite or a hand pad P800 to key difficult areas



Clean with 155 Surface Cleaner

6

862 2K Topcoat Binder



862

HPC0-3

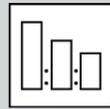
171HP-173HP

Mixing Ratio

4

1

0-10%



4:1:0-10% HPC0-3



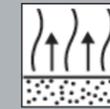
Clean with 155 Surface Cleaner



Setup/Air Pressure 1.3-1.5mm 2 Bar



Apply 2-3 Coats Followed by a control coat



Flash for 5-10 mins between coats



Air dry 20°C Overnight  
Bake 60°C 30 min

**SAFETY FIRST!**

Always wear appropriate PPE.  
Always refer to the appropriate product technical data sheet and safety data sheet prior to use.  
Products are for Trade use only.



# 2K ALUMINIUM ETCH PROCESS FOR SANDING

SYSTEM NUMBER: **2-60**

1

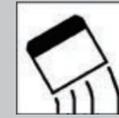
Preparation



Clean panel with 155 Surface Cleaner



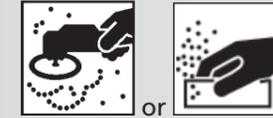
Sand Repair area, remove all OEM paint with P80 followed by P180



Fill repair with 6010 Uni Putty



Block repair with P80 or P180 depending on repair. Always finish with P180



Feather edges with P180 or P240



Clean panel with 155 Surface Cleaner

2

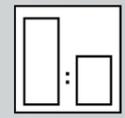
Industrial Etch



Industrial Etch



171HP-173HP  
0-30%



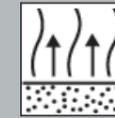
171HP-173HP  
Up to 30% if required



Set up/Air Pressure  
1.4-1.8mm  
2 Bar



Apply 1 - 2 medium wet coats



Flash 5-10 min between coats

3

HS35 Multi-use 2K Surfacer/ Sealer



HS35

Mix Ratio

4



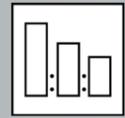
HPC0-HPC3

1



171HP-173HP

1



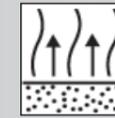
4:1:1  
HPC0-3



Set up/Air Pressure  
1.6-1.8mm  
2 Bar



Apply 1-3 coats



Flash off until matt between coats



Air dry 20°C 16 Hours  
Bake 60°C object 20-30 mins

4

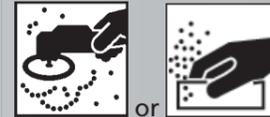
Preparation



Guide coat and block the repair with P240



Guide coat and feather out with P500 on a 3mm orbital sander



Use P800/P1000 into blend areas



Grey Scotch-Brite or a hand pad P800 to key difficult areas



Clean panel with 155 Surface Cleaner

5

862 2K Topcoat Binder



862

Mix Ratio

4



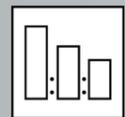
HPC0-HPC3

1

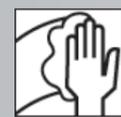


171HP-173HP

0-10%



4:1:0-10%  
HPC0-3



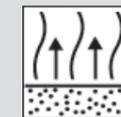
Clean with 155 Surface Cleaner



Setup/Air Pressure  
1.3-1.5mm  
2 Bar



Apply 2-3 Coats  
Followed by a control coat



Flash for 5-10 mins between coats



Air dry 20°C Overnight  
Bake 60°C 30 min

**SAFETY FIRST!**

Always wear appropriate PPE.  
Always refer to the appropriate product technical data sheet and safety data sheet prior to use.  
Products are for Trade use only.



# BASE COAT ALUMINIUM & STEEL USING DTM2035 DIRECT TO METAL PRIMER FOR WET-ON-WET (MORE THAN 3 PANELS)

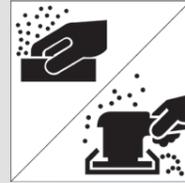
SYSTEM NUMBER: **3-10**



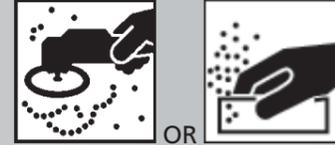
V2-0520

**1**

**Preparation**



Clean panel with 155 Surface Cleaner



Sand panel with P320 or P240



Red Scotch-Brite or hand pad P800 all key edges and difficult areas



Clean panel with 155 Surface Cleaner

**2**

**DTM2035 Surfacer/ Sealer**



DTM2035

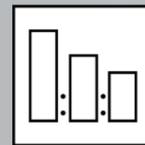


DTMA2035



171HP-173HP

**Mix Ratio**      4                      1                      2



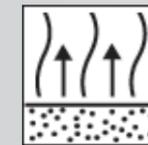
4:1:2



Setup/Air Pressure  
1.2-1.4mm  
2 Bar



Apply 1 medium closed coat



Flash 10-15 min or until Matt

**3**

**888C88 High Performance Basecoat Binder**

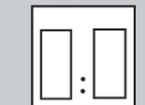


888C88



171HP-173HP

**Mix Ratio**      1                      1



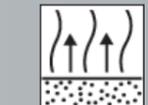
1:1  
High Performance Reducer 171HP, 172HP, 173HP



Set up/Air pressure  
1.3-1.4mm 1.5-1.8 Bar



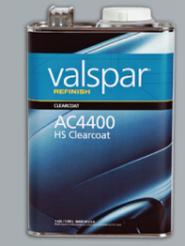
Apply 2-3 medium wet coats  
Followed by a control coat



Flash for 5-10 mins between coats

**4**

**AC4400 HS Clear Coat**



AC4400

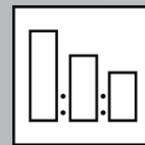


HPC0-HPC3



171HP-173HP

**Mix Ratio**      2                      1                      1



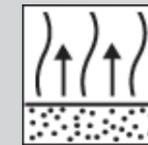
2:1:1  
HPC0-3



Set up/Air pressure  
1.3-1.4mm  
2-2.3 Bar



Apply medium to wet closed coat, flash, followed by a full coat



Flash for 5-10 mins between coats



Airdry 20°C 16 hours  
Bake at 60°C object temp 45 mins

**SAFETY FIRST!**

Always wear appropriate PPE.  
Always refer to the appropriate product technical data sheet and safety data sheet prior to use.  
Products are for Trade use only.



# BASE COAT ALUMINIUM & STEEL USING DTM2035 DIRECT TO METAL PRIMER FOR WET-ON-WET (3 OR LESS PANELS)

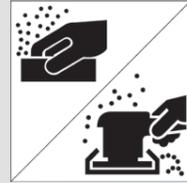
SYSTEM NUMBER: **3-15**

BC DTM WOW ST AL -3

V2-0520

1

**Preparation**



Clean panel with 155 Surface Cleaner



Sand panel with P320 or P240



Red Scotch-Brite or hand pad P800 all key edges and difficult areas



Clean panel with 155 Surface Cleaner

2

**DTM2035 Surfacer/ Sealer**



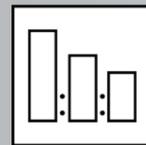
DTM2035



DTMA2035



171HP-173HP



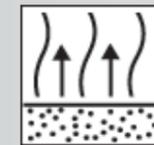
4:1:2



Setup/Air Pressure  
1.2-1.4mm  
2 Bar



Apply 1 medium closed coat Flash 10-15 min or until Matt



<b>Mix Ratio</b>	4	1	2
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3

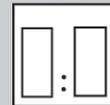
**888C88 High Performance Basecoat Binder**



888C88



171HP-173HP



1:1  
High Performance Reducer  
171HP, 172HP, 173HP



Set up/Air pressure  
1.3-1.4mm 1.5-1.8 Bar



Apply 2-3 medium wet coats Followed by a control coat Flash for 5-10 mins between coats



<b>Mix Ratio</b>	1	1
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4

**AD4200 Air Cure Clear**



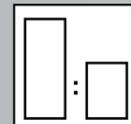
AD4200



HPC400-HPC420



171HP-173HP



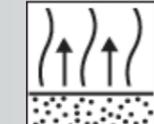
4:1:0-5%  
HPC400-420



Set up/Air pressure  
1.3-1.4mm 2 Bar



Apply 2 full coats



No flash between coats



Airdry 25°C 30 min to nib sand and buff

<b>Mix Ratio</b>	4	1	0-5%
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**SAFETY FIRST!**

Always wear appropriate PPE.  
Always refer to the appropriate product technical data sheet and safety data sheet prior to use.  
Products are for Trade use only.



# BASE COAT ALUMINIUM & STEEL ETCH USING INDUSTRIAL ETCH FOR WET-ON- WET (MORE THAN 3 PANELS)

SYSTEM NUMBER: **3-20**

ETCH BC WOW ST AL +3

V2.0520

1	Preparation																	
									Clean panel with 155 Surface Cleaner			Sand Repair area, remove all OEM paint with P80 followed by P180			Fill repair with 6010 Uni Putty			Block repair with P80 or P180 depending on repair. Always finish with P180
2	Industrial Etch																	
								Industrial Etch	171HP-173HP	171HP-173HP Up to 30% if required	Set up/Air Pressure 1.4-1.8mm 2 Bar	Apply 1-2 medium wet coats	Flash 5-10 min between coats					
3	HS35 Multi-use 2K Surfacer/Sealer																	
									HS35	HPC0-3	171HP-173HP	4:1:2 HPC0-2	Set up/Air Pressure 1.3-1.5mm 2 Bar	Apply 1 medium closed coats	Flash off 10-15 mins or until matt			
4	888C88 High Performance Basecoat Binder																	
								888C88	171HP-173HP	1:1 High Performance Reducer 171HP, 172HP, 173HP	Set up/Air pressure 1.3-1.4mm 1.5-1.8 Bar	Apply 2-3 medium wet coats followed by a control coat	Flash for 5-10 mins between coats					
5	AC4400 HS Clear Coat																	
										AC4400	HPC0-3	171HP-173HP	2:1:1 HPC0-3	Set up/Air Pressure 1.3-1.4mm 2-2.3 Bar	Medium to wet closed coat flash followed by a full coat	Flash for 5-10 mins between coats	Airdry 20°C 16 hours Bake at 60°C object temp 45 mins	

**SAFETY FIRST!**

Always wear appropriate PPE.  
Always refer to the appropriate product technical data sheet and safety data sheet prior to use.  
Products are for Trade use only.



# BASE COAT ALUMINIUM & STEEL ETCH USING INDUSTRIAL ETCH FOR WET-ON-WET (3 OR LESS PANELS)

SYSTEM NUMBER: **3-25**



V2-0520

1	Preparation			Clean panel with 155 Surface Cleaner		Sand Repair area, remove all OEM paint with P80 followed by P180		Fill repair with 6010 Uni Putty		Block repair with P80 or P180 depending on repair. Always finish with P180		Feather edges with P180 or P240		Clean panel with 155 Surface Cleaner			
	2	Industrial Etch								Industrial Etch	171HP-173HP	171HP-173HP Up to 30% if required	Set up/Air Pressure 1.4-1.8mm 2 Bar	Apply 1-2 medium wet coats	Flash 5-10 min between coats		
3	HS35 Multi-use 2K Surfacers/Sealer									HS35	HPC0-3	171HP-173HP	4:1:2 HPC0-2	Set up/Air Pressure 1.3-1.5mm 2 Bar	Apply 1 medium closed coats	Flash off 10-15 mins or until matt	
	4	888C88 High Performance Basecoat Binder								Mixing Ratio 4	1	2	1:1 High Performance Reducer 171HP, 172HP, 173HP	Set up/Air pressure 1.3-1.4mm 1.5-1.8 Bar	Apply 2-3 medium wet coats Followed by a control coat	Flash for 5-10 mins between coats	
5	AD4200 Air Cure Clear									AD4200	HPC400-420	171HP-173HP	4:1:0-5% HPC400-420	Set up/Air pressure 1.3-1.4mm 2 Bar	Apply 2 full coats	No flash between coats	
										Mixing Ratio 4	1	0-5%					Airdry 25°C 30 min to nib sand and buff

**SAFETY FIRST!**

Always wear appropriate PPE.  
Always refer to the appropriate product technical data sheet and safety data sheet prior to use.  
Products are for Trade use only.



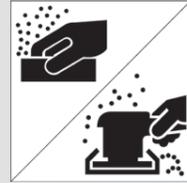
# BASE COAT FIBREGLASS USING DTM2035 DIRECT TO METAL PRIMER FOR WET-ON- WET (MORE THAN 3 PANELS)

BC DTM WOW FG +3

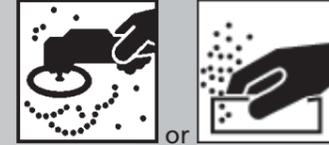
SYSTEM NUMBER: **3-30**

1

Preparation



Clean panel with 155 Surface Cleaner



Sand panel with P320 or P400



Red Scotch-Brite or hand pad P800 all key edges and difficult areas



Clean panel with 155 Surface Cleaner

2

DTM2035 Surfacer/ Sealer



DTM2035

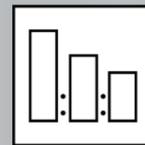


DTMA2035



171HP-173HP

Mix Ratio	4	1	2
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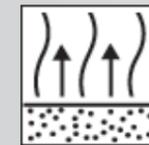
4:1:2



Setup/Air Pressure  
1.2-1.4mm  
2 Bar



Apply 1 medium closed coat



Flash 10-15 min or until Matt

3

888C88 High Performance Basecoat Binder



888C88



171HP-173HP

Mix Ratio	1	1
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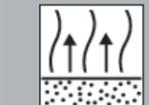
1:1 High Performance Reducer 171HP, 172HP, 173HP



Set up/Air pressure  
1.3-1.4mm 1.5-1.8 Bar



Apply 2-3 medium wet coats Followed by a control coat



Flash for 5-10 mins between coats

4

AC4400 HS Clear Coat



AC4400

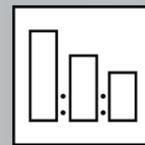


HPC0-HPC3



171HP-173HP

Mix Ratio	2	1	1
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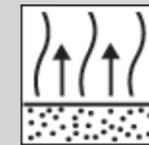
2:1:1 HPC0-3



Set up/Air pressure  
1.3-1.4mm  
2-2.3 Bar



Apply medium to wet closed coat, flash, followed by a full coat



Flash for 5-10 mins between coats



Airdry 20°C 16 hours  
Bake at 60°C object temp 45 mins

**SAFETY FIRST!**

Always wear appropriate PPE.  
Always refer to the appropriate product technical data sheet and safety data sheet prior to use.  
Products are for Trade use only.



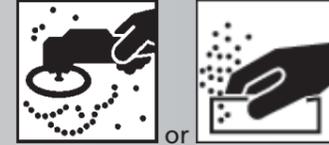
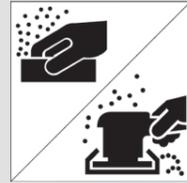
# BASE COAT FIBREGLASS USING DTM2035 DIRECT TO METAL PRIMER FOR WET-ON- WET (3 OR LESS PANELS)



SYSTEM NUMBER: **3-35**

**1**

**Preparation**



Clean panel with 155 Surface Cleaner

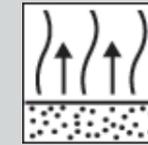
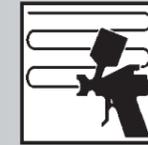
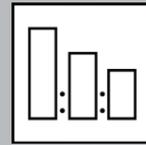
Sand panel with P320 or P400

Red Scotch-Brite or hand pad P800 all key edges and difficult areas

Clean panel with 155 Surface Cleaner

**2**

**DTM2035 Surfacer/ Sealer**



DTM2035

DTMA2035

171HP-173HP

4:1:2

Setup/Air Pressure  
1.2-1.4mm  
2 Bar

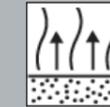
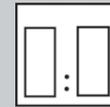
Apply 1 medium closed coat

Flash 10-15 min or until Matt

<b>Mix Ratio</b>	<b>4</b>	<b>1</b>	<b>2</b>
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**3**

**888C88 High Performance Basecoat Binder**



888C88

171HP-173HP

1:1  
High Performance Reducer  
171HP, 172HP, 173HP

Set up/Air pressure  
1.3-1.4mm 1.5-1.8 Bar

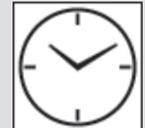
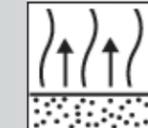
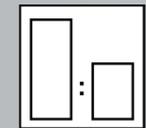
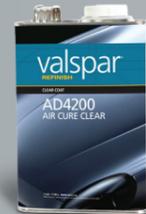
Apply 2-3 medium wet coats  
Followed by a control coat

Flash for 5-10 mins between coats

<b>Mix Ratio</b>	<b>1</b>	<b>1</b>
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**4**

**AD4200 Air Cure Clear**



AD4200

HPC400-HPC420

171HP-173HP

4:1:0-5%  
HPC400-420

Set up/Air pressure  
1.3-1.4mm 2 Bar

Apply 2 full coats

No flash between coats

Airdry 25°C 30 min to nib sand and buff

<b>Mix Ratio</b>	<b>4</b>	<b>1</b>	<b>0-5%</b>
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**SAFETY FIRST!**

Always wear appropriate PPE.  
Always refer to the appropriate product technical data sheet and safety data sheet prior to use.  
Products are for Trade use only.



# BASE COAT ALUMINIUM & STEEL USING DTM2035 DIRECT TO METAL PRIMER FOR SANDING (MORE THAN 3 PANELS)

SYSTEM NUMBER: **3-40**

SAND BC DTM ST AL +3

**1**

Preparation



Clean panel with 155 Surface Cleaner



Sand panel with P320



Red Scotch-Brite or hand pad P800 all key edges and difficult areas



Clean panel with 155 Surface Cleaner

**2**

DTM2035 Surfacers/ Sealer



DTM2035



DTMA2035



171HP-173HP

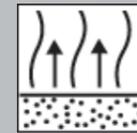
Mixing Ratio 4 1 1



Setup/Air Pressure 1.2-1.4mm 2 Bar



Apply 1-3 coats



Flash 10-15 min or until Matt

**3**

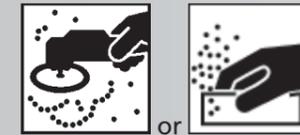
Preparation



Guide coat block the repair with P240



Guide coat and feather out with P500 on a 3mm orbital sander



Use P800/P1000 into blend areas



Grey Scotch-Brite or a hand pad P800 to key difficult areas



Clean panel with 155 Surface Cleaner

**4**

888C88 High Performance Basecoat Binder



888C88



171HP-173HP

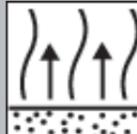
Mixing Ratio 1 1



Set up/Air pressure 1.3-1.4mm 1.5-1.8 Bar



Apply 2-3 medium wet coats Followed by a control coat



Flash for 5-10 mins between coats

**5**

AC4400 HS Clear Coat



AD4200

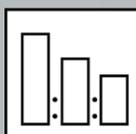


HPC0-HPC3



171HP-173HP

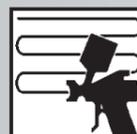
Mixing Ratio 2 1 1



2:1:1 HPC0-3



Set up/Air pressure 1.3-1.4mm 2-2.3 Bar



Apply medium to wet closed coat, flash, followed by a full coat



Flash for 5-10 mins between coats



Airdry 20°C 16 hours Bake at 60°C object temp 45 mins

**SAFETY FIRST!**

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# BASE COAT ALUMINIUM & STEEL USING DTM2035 DIRECT TO METAL PRIMER FOR SANDING (3 OR LESS PANELS)

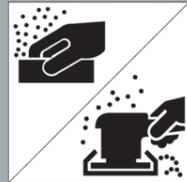
SYSTEM NUMBER: **3-45**

SAND BC DTM ST AL -3

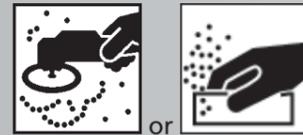
V2-0520

**1**

Preparation



Clean panel with 155 Surface Cleaner



Sand panel with P320



Red Scotch-Brite or hand pad P800 all key edges and difficult areas



Clean panel with 155 Surface Cleaner

**2**

DTM2035 Surfacers/ Sealer



DTM2035



DTMA2035



171HP-173HP

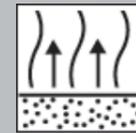
Mixing Ratio 4 1 1



Setup/Air Pressure 1.2-1.4mm 2 Bar



Apply 1-3 coats



Flash 10-15 min or until Matt

**3**

Preparation



Guide coat block the repair with P240



Guide coat and feather out with P500 on a 3mm orbital sander



Use P800/P1000 into blend areas



Grey Scotch-Brite or a hand pad P800 to key difficult areas



Clean panel with 155 Surface Cleaner

**4**

888C88 High Performance Basecoat Binder



888C88



171HP-173HP

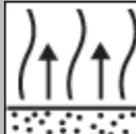
Mixing Ratio 1 1



Set up/Air pressure 1.3-1.4mm 1.5-1.8 Bar



Apply 2-3 medium wet coats Followed by a control coat



Flash for 5-10 mins between coats

**5**

AD4200 Air Cure Clear Coat



AD4200



HPC400-HPC420

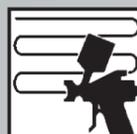


171HP-173HP

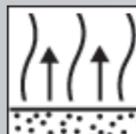
Mixing Ratio 4 1 0-5%



Set up/Air pressure 1.3-1.4mm 2 Bar



Apply 2 full coats



No flash between coats



Airdry 25°C 30 min to nib sand and buff

**SAFETY FIRST!**

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# BASE COAT REPAIR ALUMINIUM EPOXY PROCESS FOR SANDING (MORE THAN 3 PANELS)



SYSTEM NUMBER: **3-50**

V2-0520

<b>1</b>	<b>Preparation</b>			Clean panel with 155 Surface Cleaner		Sand repair area, remove all OEM paint with P80 followed by P180		Clean with 155 Surface Cleaner						
<b>2</b>	<b>VP50 Epoxy Primer</b>					4:1:2 VP50 Activator		Set up/Air pressure 1.3-1.4mm 2 Bar		Apply 1 medium closed coat		Flash for 45 min at 20°C		Air Dry 20°C 16 Hours Bake 60°C 1 Hour
		VP50	VP50 Activator	171HP-173HP	Mix Ratio	4	1	2						
<b>3</b>	<b>Preparation</b>			Sand area to be repaired with P180		Fill repair		Block repair with P80 or P180 depending on repair. Always finish with P180		Feather edges with P180 or P240		Clean panel with 155 Surface Cleaner		
<b>4</b>	<b>HS35 Multi-use 2K Surfacer/ Sealer</b>					4:1:1 HPC0-3		Set up/Air Pressure 1.6-1.8mm 2 Bar		Apply 1-3 coats		Flash off until matt between coats		Air dry 20°C 16 Hours Bake 60°C Object 20-30 mins
		HS35	HPC0-3	171HP-173HP	Mix Ratio	4	1	1						
<b>5</b>	<b>Preparation</b>			Guide coat block the repair with P240		Guide coat and feather out with P500 on a 3mm orbital sander		Use P800/P1000 into blend areas		Grey Scotch-Brite or a hand pad P800 to key difficult areas		Clean with 155 Surface Cleaner		
<b>6</b>	<b>888C88 High Performance Basecoat Binder</b>					1:1 High Performance Reducer 171HP, 172HP, 173HP		Set up/Air pressure 1.3-1.4mm 1.5-1.8 Bar		Apply 2-3 medium wet coats Followed by a control coat		Flash for 5-10 mins between coats		
		888C88	171HP-173HP	171HP-173HP	Mix Ratio	1	1							
<b>7</b>	<b>AC4400 HS Clear Coat</b>					2:1:1 HPC0-3		Set up/Air pressure 1.3-1.4mm 2-2.3 Bar		Medium to wet closed coat flash followed by a full coat		Flash for 5-10 mins between coats		Airdry 20°C 16 hours Bake at 60°C object temp 45 mins
		AC4400	HPC0-3	171HP-173HP	Mix Ratio	2	1	1						

**SAFETY FIRST!**

Always wear appropriate PPE.  
Always refer to the appropriate product technical data sheet and safety data sheet prior to use.  
Products are for Trade use only.



# BASE COAT REPAIR ALUMINIUM EPOXY PROCESS FOR SANDING (LESS THAN 3 PANELS)

EP SAND BC AL -3

SYSTEM NUMBER: **3-55**

<b>1</b>	Preparation			Clean panel with 155 Surface Cleaner		Sand repair area, remove all OEM paint with P80 followed by P180		Clean with 155 Surface Cleaner						
<b>2</b>	VP50 Epoxy Primer					4:1:2 VP50 Activator		Set up/Air pressure 1.3-1.4mm 2 Bar		Apply 1 medium closed coat		Flash for 45 min at 20°C		Air Dry 20°C 16 Hours Bake 60°C 1 Hour
		Mix Ratio	4	1	2									
<b>3</b>	Preparation			Sand area to be repaired with P180		Fill repair		Block repair with P80 or P180 depending on repair. Always finish with P180		Feather edges with P180 or P240		Clean panel with 155 Surface Cleaner		
<b>4</b>	HS35 Multi-use 2K Surfacer/ Sealer					4:1:1 HPC0-3		Set up/Air Pressure 1.6-1.8mm 2 Bar		Apply 1-3 coats		Flash off until matt between coats		Air dry 20°C 16 Hours Bake 60°C Object 20-30 mins
		Mix Ratio	4	1	1									
<b>5</b>	Preparation			Guide coat block the repair with P240		Guide coat and feather out with P500 on a 3mm orbital sander		Use P800/P1000 into blend areas		Grey Scotch-Brite or a hand pad P800 to key difficult areas		Clean with 155 Surface Cleaner		
<b>6</b>	888C88 High Performance Basecoat Binder					1:1 High Performance Reducer 171HP, 172HP, 173HP		Set up/Air pressure 1.3-1.4mm 1.5-1.8 Bar		Apply 2-3 medium wet coats Followed by a control coat		Flash for 5-10 mins between coats		
		Mix Ratio	1	1										
<b>7</b>	AD4200 Air Cure Clear					4:1:0-5% HPC400-420		Set up/Air pressure 1.3-1.4mm 2 Bar		Apply 2 full coats		No flash between coats		Airdry 25°C 30 min to nib sand and buff
		Mix Ratio	4	1	0-5%									

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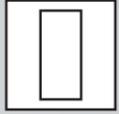
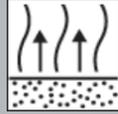
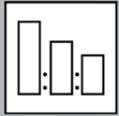
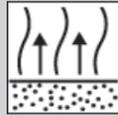
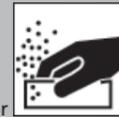
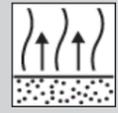
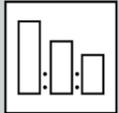
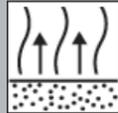
# BASE COAT ALUMINIUM ETCH PROCESS FOR **valspar** SANDING (MORE THAN 3 PANELS)

REFINISH



V2-0520

SYSTEM NUMBER: **3-60**

1	<p>Preparation</p> 	 <p>Clean panel with 155 Surface Cleaner</p>	 or  <p>Sand Repair area, remove all OEM paint with P80 followed by P180</p>	 <p>Fill repair with 6010 Uni Putty</p>	 <p>Block repair with P80 or P180 depending on repair. Always finish with P180</p>	 or  <p>Feather edges with P180 or P240</p>	 <p>Clean panel with 155 Surface Cleaner</p>
2	<p>Industrial Etch</p>  <p><b>Industrial Etch</b></p>  <p><b>171HP-173HP</b></p> <p><b>0-30%</b></p>	 <p>171HP-173HP Up to 30% if required</p>	 <p>Set up/Air Pressure 1.4-1.8mm 2 Bar</p>	 <p>Apply 1-2 medium wet coats</p>	 <p>Flash 5-10 min between coats</p>		
3	<p>HS35 Multi-use 2K Surfacer/ Sealer</p>  <p><b>HS35</b></p>  <p><b>HPC0-HPC3</b></p>  <p><b>171HP-173HP</b></p> <p>Mix Ratio 4 1 1</p>	 <p>4:1:1 HPC0-3</p>	 <p>Set up/Air Pressure 1.6-1.8mm 2 Bar</p>	 <p>Apply 1-3 coats</p>	 <p>Flash off until matt between coats</p>	 <p>Air dry 20°C 16 Hours Bake 60°C object 20-30 mins</p>	
4	<p>Preparation</p> 	 <p>Guide coat block the repair with P240</p>	 or  <p>Guide coat and feather out with P500 on a 3mm orbital sander</p>	 or  <p>Use P800/P1000 into blend areas</p>	 <p>Grey Scotch-Brite or a hand pad P800 to key difficult areas</p>	 <p>Clean panel with 155 Surface Cleaner</p>	
5	<p>888C88 High Performance Basecoat Binder</p>  <p><b>888C88</b></p>  <p><b>171HP-173HP</b></p> <p>Mix Ratio 1 1</p>	 <p>1:1 High Performance Reducer 171HP, 172HP, 173HP</p>	 <p>Set up/Air pressure 1.3-1.4mm 1.5-1.8 Bar</p>	 <p>Apply 2-3 medium wet coats Followed by a control coat</p>	 <p>Flash for 5-10 mins between coats</p>		
6	<p>AC4400 HS Clear Coat</p>  <p><b>AC4400</b></p>  <p><b>HPC0-HPC3</b></p>  <p><b>171HP-173HP</b></p> <p>Mix Ratio 2 1 1</p>	 <p>2:1:1 HPC0-3</p>	 <p>Set up/Air Pressure 1.3-1.4mm 2-2.3 Bar</p>	 <p>Medium to wet closed coat flash followed by a full coat</p>	 <p>Flash for 5-10 mins between coats</p>	 <p>Airdry 20°C 16 hours Bake at 60°C object temp 45 mins</p>	

**SAFETY FIRST!**

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# BASE COAT ALUMINIUM ETCH PROCESS FOR **valspar** REFINISH

## SANDING (3 OR LESS PANELS)



SYSTEM NUMBER: **3-65**

V2-0520

1	Preparation									
			Clean panel with 155 Surface Cleaner	Sand Repair area, remove all OEM paint with P80 followed by P180	Fill repair with 6010 Uni Putty	Block repair with P80 or P180 depending on repair. Always finish with P180	Feather edges with P180 or P240	Clean panel with 155 Surface Cleaner		
2	Industrial Etch									
		Industrial Etch	171HP-173HP 0-30%	171HP-173HP Up to 30% if required	Set up/Air Pressure 1.4-1.8mm 2 Bar	Apply 1-2 medium wet coats	Flash 5-10 min between coats			
3	HS35 Multi-use 2K Surfacer/ Sealer									
		HS35	HPC0-HPC3	171HP-173HP	4:1:1 HPC0-3	Set up/Air Pressure 1.6-1.8mm 2 Bar	Apply 1-3 coats	Flash off until matt between coats	Air dry 20°C 16 Hours Bake 60°C object 20-30 mins	
4	Preparation									
			Guide coat block the repair with P240	Guide coat and feather out with P500 on a 3mm orbital sander	Use P800/P1000 into blend areas	Grey Scotch-Brite or a hand pad P800 to key difficult areas	Clean panel with 155 Surface Cleaner			
5	888C88 High Performance Basecoat Binder									
		888C88	171HP-173HP	1:1 High Performance Reducer 171HP, 172HP, 173HP	Clean with 155 Surface Cleaner	Set up/Air pressure 1.3-1.4mm 1.5-1.8 Bar	Apply 2-3 medium wet coats Followed by a control coat	Flash for 5-10 mins between coats		
6	AD4200 Air Cure Clear									
		AD4200	HPC400-HPC420	171HP-173HP	4:1:0-5% HPC400-420	Set up/Air pressure 1.3-1.4mm 2 Bar	Apply 2 full coats	No flash between coats	Airdry 25°C 30 min to nib sand and buff	

# Shopping List

- Protective equipment:
  - Safety glasses
  - Nitrile gloves
  - Vapour mask
  - Dust mask
  - Spray Overalls
- Paint:
  - Plastic or Etch Primer if required
  - Primer/Activator
  - Colour/Activator
  - Clear Coat/Activator
- Sandpaper:
  - P80
  - P180
  - P240
  - P320
  - P400/500
  - P1000
  - P2000
  - Guide Coat
  - Scotch Brite
- Consumables:
  - Mixing/ Measuring Stick
  - Masking tape
  - Masking paper or plastic film
  - 155 wax & grease remover
  - Plastic drop sheet
  - Rags
  - Sanding block
  - Polyester fine body filler (bog), applicator
  - Tack cloth
  - Fine cut and polish compound

## Safety

Wear protective gloves. Wear eye or face protection. Keep away from ignition sources such as heat/sparks/open flame. - No smoking. Do not breathe vapour or spray mist. Wash hands thoroughly after handling. Product Technical Data Sheets & Safety Data Sheets are available from your retailer.



## About Valspar Refinish

At Valspar we are passionate about paint. We love seeing our products used to protect and enhance the look of objects both large and small. This is equally true for our Valspar Refinish system. The Valspar Refinish system is used by professionals and individuals for car refinish across the globe. We are constantly developing the system and colour range to meet and exceed the needs of our customers.

## Pro Tips

Check you have all required products before starting the job.

Sharp paint edges must be feathered back by sanding otherwise they will still be visible after the repair.

Primer will not hide deep scratches, apply body filler to repair these areas.

Practice application technique and check colour on paper before applying to your car.

If you get a run during paint application, don't worry. Let the coating dry and lightly sand the run back to a smooth finish before proceeding.

Paint mist will carry some distance, it is important to protect your vehicle and surrounding items from overspray.

The advice given in this guide is general in nature. For the best quality repair, we recommend using an authorised Valspar Refinish repairer.

## Notes

Vehicle Make:  
Colour Code:  
Year: