

**Luminate.Doors.3D Colour Repair Instructions**

Updated: Oct 2010

**Tools and Products Required****Abrasives (Scuff Marks)**

- 600 grit
- 800 grit
- 1200 grit
- 1500 grit
- 2000 grit

**Additional Abrasives (Scratches)**

- 240 grit
- 320 grit
- 400 grit

**Automotive paint abrasive compounds**

- Cutting compound
- Buffing compound
- Buffing cloth or foam pad

**Tools / Other**

- Random orbital sander (optional)
- Sanding block (cork or similar)
- Buff polishing machine (optional) suggest use only by a car finishing expert
- Foam or lambs wool buffing pads (only requ with buff polishing machine)
- Mentholated spirits or similar

**Repair Process****1. Initial preparation**

Wash surface to be repaired with mentholated spirits

**2. Sanding damaged area**

Sand the area to be repaired with appropriate sandpaper using either an orbital sander or hand sanding block.

Typically a scratch will require a coarse grit paper eg 320 grit, depending on depth of scratch, whereas a scuff mark may require 800 grit paper. It is important to note that the coarser the initial sand the more processing is required, therefore be conservative with the sanding by testing with finer grits and moving toward coarser options if required.

Once the scratch / scuff is removed work through each finer grit of sandpaper to remove the sanding scratches. Eg if you start with 400grit then you must work through 600, 800, 1200, 1500 and 2000 grits, if any of these steps are missed you may not easily achieve the desired result. Water lubrication may assist with the sanding process although the factory process is totally dry sanding. It is critical (particularly with deep scratches) that an area larger than the damaged area is processed, eg if you have a 15cm (6 inch) scratch then work an area of say 30cm (12 inch) and blend (feather) the sanding area from the deepest part of the scratch outward.

**3. Cutting (using compound)**

Wipe off fine dust and apply automotive cutting compound using a soft buffing cloth or a recommended foam pad. If using a buffing / polishing machine ensure the surface being repaired does not heat excessively, the surface will conduct and transmit heat very easily. Using a pad on an orbital sander is effective and safe as it will not heat the surface like a polishing machine will. Rub work the cutting compound until all fine sanding scratches are removed.

**4. Buffing (using compound)**

Apply buffing compound using a proper buffing cloth, allow the compound to flash off (leave for a few minutes to dry a little) then furiously rub by hand or use the mechanical means to bring the surface to a full shiny gloss. Once the repaired area is to the desired gloss level work over the whole door to blend the finish. If the repaired area is not consistent with the original surface you may need to return to previous steps to correct the issue. Eg- if there are scratches showing, remove them using the relevant coarseness of abrasive and work back through the steps.