

Time Allowances (hrs)

The division of the preparatory operations is as follows:

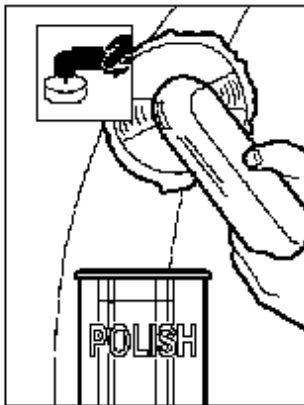
Coarse putty operations and sealing operations come under sheet metal operations in group A. Fine putty operations come under the paint operations in group B.

Paintable surfaces are to be produced in the sheet metal work division (body workers, panel beaters).

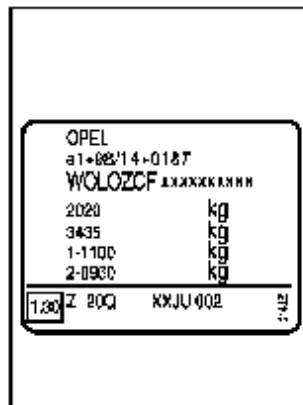
The paint operations division (painters) takes over the work from the sheet metal work division and completes the surface to be painted. This includes: at most 3 fine putty coats for screw parts at most 4 fine putty coats for welded parts

Note: Spraying colour samples for the painting of individual parts is a part of the set-up time.

Finding the right colour



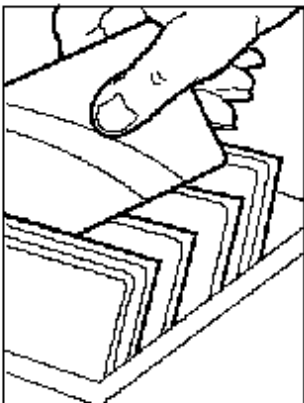
1



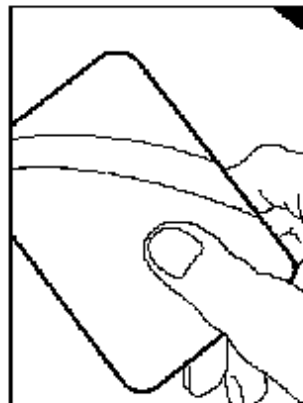
2



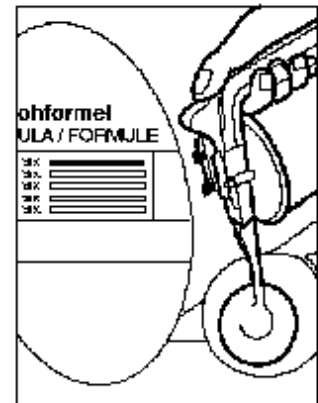
3



6



5



4

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1. Clean a hand-sized area. Polish the damaged area and adjoining surface using rubbing compound.
2. Look for the colour code on the vehicle identification plate (check for touching up)
3. Compare colour found on vehicle with colour roster/colour shade roster.
4. Select the mixture recipe after identifying the colour.

5. Carry out a colour test as a rough comparison with colour sample to check the colour in daylight or suitable artificial light.
6. Keep the sample.

The time allowances for paint operations in the main and combined operations are organised into the following stages:

Paint stage / individual-part painting	Sheet metal parts
I	New part painting <ul style="list-style-type: none"> ● Partial application of putty for welded-in parts – attached sheet metal parts ● Apply filler to entire surface area ● Apply top coat to entire surface area
II	Surface painting <ul style="list-style-type: none"> ● Apply top coat to entire surface area, including minor repairs (not including putty operations)
III	Repair painting <ul style="list-style-type: none"> ● Partially apply putty to worked area covering up to 50% of the surface to be painted ● Apply filler to worked surface ● Apply top coat to entire surface area
Paint stage / blending	Sheet metal parts (only 2-coat paint systems)
II a	Blend-in painting <ul style="list-style-type: none"> ● Blend-in basefix to approx. 50% into the adjoining part
II b	Touching-up <ul style="list-style-type: none"> ● Blend-in basefix into the whole, adjoining part
Paint stage / individual-part painting	Plastic parts
I	New part painting <ul style="list-style-type: none"> ● Apply top coat to entire surface area
II	Surface painting <ul style="list-style-type: none"> ● Apply filler to entire surface area ● Apply top coat to entire surface area
III	Repair painting <ul style="list-style-type: none"> ● Apply putty to the worked area covering up to approx. 30% of the component surface ● Apply filler to entire surface area ● Apply top coat to entire surface area ● Create structure if required (structure spray)