






## Classic Car – Repair process for tin-coated surfaces

**Description:** Refinishing process for the restoration of classic cars  
Coating of tin-plated body panels

- Tin-plating is very suitable to fill out deeper irregularities that can occur during body repair work. During this process, irregularities are filled with solder.
- In order to improve the processing and smoothing properties of tin, soldering fluid and paste are used. These materials have a negative impact on the adhesion of the paint system. Therefore, tin-plated areas must be cleaned extremely thoroughly.

<b>Cleaning</b>	360-4 Glasurit® Metal cleaner	 Brush the tin-plated surface with wire brush 1x	 Wipe dry	 P80 - P150	700-10 Glasurit® Degreasing and Cleansing Agent	 1x	 Wipe dry

- You can get a better cleaning result using thinned household ammonia (~ 5% ammonia). Apply the household ammonia with a soaked cloth and allow it to act for about 10-15 minutes. Ensure that the material does not start to dry. Then wash the treated surfaces thoroughly with a lot of water.

- If the vehicle will stand in the shop for a longer time before being refinished, the bare panels should be primed at first with 285-270 Glasurit Primer Filler PRO in order to avoid flash rust.
- Alternatively, an increased corrosion protection can be achieved by the use of 360-100 Glasurit® PRO Active Wipes.

Please refer to the EU Material Safety Data Sheet for product labelling as required by Directive 1999/45/EC and the respective national rules. The products are suitable for professional use only.

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### Small damaged areas:

<b>Body filler</b>	839-20/-20K Glasurit® Multi-Purpose Body Filler	948-36 Glasurit® Hardener Paste, red	+ 2-3%	20-30 min at 20°C	3-5 min	Coarse sanding with P80/P150

### Larger damaged areas:

<b>Primer</b>	Glasurit® Primer filler PRO 285-270	Glasurit® Filler Hardener PRO 929-58	Glasurit® Reducer 352-91, -216	5 : 1 : 1	HVLP 1.7-1.9 mm 2.0-3.0 bar	½+1 10 - 20 µm	15 min. 60°C	10 min.	Pad

<b>Polyester spray filler</b>	1006-26 Glasurit® UP Spray Filler	948-22 Glasurit® Hardener	1400 : 50	2.5-3.0 mm 2.0-3.0 bar	3-5 150-300 µm	3-4 h at 20°C 30 min at 60°	10 min	P150 coarse sanding P240-P320 fine sanding

Remarks: If spray filler thicknesses of > 300 µm are required, a second spray filler coat can be applied after drying of the first coat without intermediate sanding

- The primer filler must be applied within 24 hours. Otherwise, the inclusion of humidity can cause cracking in the following paint system

Clean the surface with 700-10 Glasurit® Degreasing and cleansing agent before applying 285-270

<b>Primer filler</b>	285-270 Glasurit® Primer Filler PRO	929-58 Glasurit® Hardener	352-91, -216 Glasurit® Reducer	5 : 1 : 1	HVLP 1.7-1.9 mm 2.0-3.0 bar	½+1 50 - 70 µm	60°C 35 min.	10 min.	P 400 - P 500	P 800

Further paint system according to CC T S – Repair process for standard topcoats or  
CC T P – Repair process for premium topcoats

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