OPERATING PROCEDURES
PAINT & PREP
### Products Needed:

<table>
<thead>
<tr>
<th>Product</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>Siikens M600</td>
<td>Wax and Grease Remover</td>
</tr>
<tr>
<td>Tork # 440278A</td>
<td>Wipers</td>
</tr>
<tr>
<td>3M # 09678</td>
<td>13mm Foam Aperture</td>
</tr>
<tr>
<td>Carbo AM #99587</td>
<td>3/4” Masking Tape AM</td>
</tr>
<tr>
<td>Carbo AM #99588</td>
<td>1-1/2” Masking Tape AM</td>
</tr>
<tr>
<td>Norton # 03345</td>
<td>Blue Sheeting</td>
</tr>
<tr>
<td>Norton # 407</td>
<td>Trim Masking Tape</td>
</tr>
<tr>
<td>Norton # 404</td>
<td>36” White Masking Paper</td>
</tr>
<tr>
<td>Norton # 407</td>
<td>18” White Masking Paper</td>
</tr>
<tr>
<td>Carbo AM #99587</td>
<td>3/4” Masking Tape AM</td>
</tr>
<tr>
<td>Carbo AM #99588</td>
<td>1-1/2” Masking Tape AM</td>
</tr>
<tr>
<td>Norton # 03345</td>
<td>Blue Sheeting</td>
</tr>
</tbody>
</table>

Refer to the Manufacturer’s MSDS for recommended safety equipment.

### Step #1

Clean area with water-based cleaner & dry before masking

### Step #2

Apply foam tape to door jambs and any other gaps that need protection

### Step #3

- Outline repair area with 1-1/2” masking tape
- Use Trim Masking Tape to lift and mask gaskets, moldings, etc.
- Use fine line to mask emblems and any other accessories

### Step #4

Mask all adjacent areas with Paint Check masking paper

### Step #5

Cover entire vehicle with overspray sheeting

**Note** - Make sure that the car is dry before applying sheeting

- Cut sheeting around repair area
- Tape sheeting down onto 1-1/2” masking tape

### Step #6

Blow off area and tack

---

**Tech Support:** [www.carboauto.com](http://www.carboauto.com)

**QR Code:** [Masking Video](#)
The suggested procedure on this page is a summary of the manufacturer’s procedure. For complete details, review the manufacturer’s instructions that accompany the products and/or that can be found at their websites.

**Sanding System (Prep)**

**Products Needed:**
- Carbo # 99308 - Preppers 6” Soft Density Backup pad
- Tork # 192479 - Specialist Wipes
- Carbo # 99439 - 400 grit soft roll
- Carbo # 10890 - Primer Prep Red Scuff Pads
- Carbo # 10891 - Color Prep Gray Scuff Pads
- Carbo # 99517 - 400 Grit 6” DA Grip-On Sand Paper
- Carbo # 99514 - 600 Grit 6” DA Grip-On Sand Paper

Refer to the Manufacturer’s MSDS for recommended safety equipment.

**Step #1**
Body work comes to the prep department finished in 180 Grit DA sand scratches
Prep department never jumps more than 100 grit / step

**Step #2**
Prepper’s sand with 3/32 offset and a soft pad.
Sand around the filler areas (stay off filler) with 220 grit to remove 180 grit scratches on metal and feathered paint.

**Step #3**
Sand around the filler areas (stay off filler) with 320 grit to remove 220 grit scratches on metal and feathered paint.

**Step #4**
Prime as per Siikens recommended procedures
Caution: Do not Prime beyond 320 Grit Scratches

**Step #5**
ON THE PRIMED AREAS
Block sand—starting with 320 grit follow with 400 grit

**Step #6**
Sand with 600 grit on a DA with a soft pad—the total area to be painted.
Surface must be fully sanded, no shiny spots, no orange peel.

**Step #7**

**OEM / Non-OEM Panels / All**

**NEW—Non OEM Panels**
Finish sand with 400 Grit 6” DA, soft Pad, 3/32 Offset sander
(May use Red Thin Flex Scuff Pad as alternate)

**Step #8**

**NEW—OEM Panels**
Finish sand with 400 Grit 6” DA, soft Pad, 3/32 Offset Sander

**Step #9**
Primed OEM and aftermarket Bumpers
Hand sand with 400 Grit Soft Roll or Gray scuff + Blend Prep
IMP: Identify Primer & follow Akzo recommended process

**Step #10**
Unprimed or Raw OEM and Aftermarket Bumpers
Hand sand with Grey Scuff + Plastic Fix
IMP: Do Float Test & follow Akzo recommended process

**Info**
General Rule of sanding steps:
* Do Not jump more that 100 grits between steps from 80 to 400.
* Preppers on a DA use: soft pad + 3/32 finish sander
* Hand sand with 100 grit finer than DA sand for similar scratch performance in finish or use soft backed paper.
# Sanding “Repaired” Plastic

<table>
<thead>
<tr>
<th>Products Needed:</th>
<th>Carbo # 99518 - 320 Grit 6” DA Medalist discs</th>
<th>Carbo # 99442 - 800 Grit Soft Roll sand paper</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td>Carbo # 99515 - 600 Grit 6” DA Medalist Discs</td>
<td>Carbo # 99308 - 6” soft density pad</td>
</tr>
<tr>
<td></td>
<td>Carbo # 99514 - 800 Grit 6” DA Medalist discs</td>
<td></td>
</tr>
<tr>
<td></td>
<td>Carbo #99564 - 320 Grit Grip-On Sheet Roll</td>
<td></td>
</tr>
<tr>
<td></td>
<td>Carbo # 99592 - 600 Grit Grip-On Sheet Roll</td>
<td></td>
</tr>
</tbody>
</table>

## Products Needed:

- Carbo # 99518 - 320 Grit 6” DA Medalist discs
- Carbo # 99442 - 800 Grit Soft Roll sand paper
- Carbo # 99515 - 600 Grit 6” DA Medalist Discs
- Carbo # 99308 - 6” soft density pad
- Carbo # 99514 - 800 Grit 6” DA Medalist discs
- Carbo #99564 - 320 Grit Grip-On Sheet Roll
- Carbo # 99592 - 600 Grit Grip-On Sheet Roll

## SAFETY

- P100 or N95 Masks
- Disposable Gloves
- Safety Glasses

## TABLE OF CONTENTS

- This section deals with prep sanding Bumpers that were repaired in the shop.
- Repair Plastic often comes to the Prep department with fine “hair” on the exposed plastic. This is easily dealt with using slow DA speed and a small amount of water. (All Carbo sand papers are water tolerant)
- If Bumper is Floating Plastic
  - DA sand - finishing with 800 grit areas to be primed.
  - (following normal sanding process up to 800 grit finish)
  - Prime Plastic as per Siikens SOP for repaired Plastics
- If Bumper is sinking Plastic
  - Dry sand to 320 grit entire area to receive primer
  - Prime Plastic as per Siikens SOP for repaired plastics
- Block sand primed areas with 600 Grit

---

The suggested procedure on this page is a summary of the manufacturer’s procedure. For complete details, review the manufacturer’s instructions that accompany the products and/or that can be found at their websites.
### Sanding System Blends

**Products Needed:**
- **Siikens** - Blend Prep
- **Carbo # 10891** - Color Prep Gray Scuff Pads
- **Carbo # 30893** - Clear Prep Gold Scuff Pads
- **Carbo # 47283** - 1000 Grit 6” Medalist Film Finishing Disc
- **Carbo # 53381** - 3000 Grit 6” Medalist Foam Finishing Disc
- **Carbo # 99308** - Soft DA Pad
- **Carbo # 42089** - 6” Interface Pad
- **Carbo # 99514** - 800 Grit 6” sanding disc
- **Carbo # 47283** - 1000 Grit 6” Medalist Film Finishing Disc
- **Carbo # 53381** - 3000 Grit 6” Medalist Foam Finishing Disc

This system assumes damaged repair is completed as per standard sanding preparation system and deals specifically with the A, B, C, D Blend “Panel” area as shown below.

**Step #1**
Sand areas A and B (Blend Panel Area) with 800 Grit, soft pad, 3/32 offset sander. Remove orange peel where color will be applied on the B portion of the panel. 1000 Grit may be preferable when color involves a fine metallic or pearl.

**Step #1**
Alternately you may wet sand with P800 to P1000 grit on the A + B areas, making sure orange peel is removed when color will be going.

**Step #2**
Completely sand areas C + D with 1000 Grit on a 6” DA, 3/32 offset finishing sander and soft + interface pad.

Alternately — Sand areas C + D with Gray Thin Flex Scuff Pad and Siikens Blend Prep and water — This can be important on heavy orange peel original finish — if the goal is to keep this peel intact.

⇒ Make a gradual taper (as shown)

### SAFETY
- P100 or N95 Masks
- Disposable Gloves
- Safety Glasses

### TABLE OF CONTENTS

#### Products Needed:

<table>
<thead>
<tr>
<th>Product</th>
<th>Code</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>Siikens Blend Prep</td>
<td>Carbo 99308</td>
<td>Soft DA Pad</td>
</tr>
<tr>
<td>Carbo # 10891</td>
<td>Color Prep Gray Scuff Pads</td>
<td>Carbo 42089 - 6” Interface Pad</td>
</tr>
<tr>
<td>Carbo # 30893</td>
<td>Clear Prep Gold Scuff Pads</td>
<td>Carbo 99514 - 800 Grit 6” sanding disc</td>
</tr>
<tr>
<td>Carbo # 47283</td>
<td>1000 Grit 6” Medalist Film Finishing Disc</td>
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<tr>
<td>Carbo # 53381</td>
<td>3000 Grit 6” Medalist Foam Finishing Disc</td>
<td>Carbo 30893 - Clear Prep Gold Scuff Pads</td>
</tr>
<tr>
<td>Carbo # 99308</td>
<td>Soft DA Pad</td>
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</tr>
<tr>
<td>Carbo # 42089</td>
<td>6” Interface Pad</td>
<td></td>
</tr>
<tr>
<td>Carbo # 99514</td>
<td>800 Grit 6” sanding disc</td>
<td></td>
</tr>
</tbody>
</table>

**Step #3**

If Blending of the clearcoat is inevitable (sail panels)

**Step #3**
Either a) Prepare sail panels using some Siikens Blend Prep on a damp sponge until gloss is removed.

**Step #3**

**Step #3**
Or c) Prepare sail panel using Carbo Clear Blend Prep Gold scuff pad
The suggested procedure on this page is a summary of the manufacturer’s procedure. For complete details, review the manufacturer’s instructions that accompany the products and/or that can be found at their websites.

**Spray Booth Maintenance - General**

**Products Needed:**
- Camfil Exhaust Filters
- Like 90 Particle Control - # 10009
- Camfil Pre-Filters
- Like 90 White Out - # 10032
- Camfil Ceiling Media
- Like 90 Clear View - # 10034

**SAFETY**
- Safety Glasses
- Organic Vapors Respirator
- Disposable Gloves

**Replace exhaust filters weekly or as needed**

**Replace Pre-filters semi annually**

**Replace ceiling media every 12 months or as required**

**Apply Particle Control Daily to booth floor to actively control all dust movement from cement floor**

**Apply White-Out & Clear View every 8 months**

- In between new applications of White Out:
  - Refresh booth walls with White Out as overspray accumulates
  - Remove and reapply Clear View as overspray accumulates on glass

**Info**

**Tech Support:** [www.like90.net](http://www.like90.net)

**QR Code:** Particle Control Tech Info

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**Info**

**Tech Support:** [www.like90.net](http://www.like90.net)

**QR Code:** White Out Tech Info
The suggested procedure on this page is a summary of the manufacturer's procedure. For complete details, review the manufacturer's instructions that accompany the products and/or that can be found at their websites.

**1st Stage** - Clean or replace every 6 months
Replacement Filter # 22160

**2nd Stage** - Replace every 6 months
or
When 2nd pressure gauge shows a 5 psi drop from the 1st pressure gauge
Replacement Filter # 81810

**3rd Stage** - Replace every 3 months
Replacement Filter # 85373

**3 Stage Filter Part Numbers**
- 129.6 CFM Capacity Filter - # 92320  (shown above)
- 72 CFM Capacity Filter - # 141218

Tech Support:  [www.satausa.com](http://www.satausa.com)

QR Code:  [3 Stage Filter Video](#)
The suggested procedure on this page is a summary of the manufacturer’s procedure. For complete details, review the manufacturer’s instructions that accompany the products and/or that can be found at their websites.

**Products Needed:**
- U-POL # 2002 - Water-Based Cleaner
- SATA # 6007 - Cleaning Brushes
- SATA # 9209 - Small Cleaning Brushes
- SATA # 9894 - Nozzle Cleaning Needles
- SATA # 48173 - Gun Lube
- Tork # 440278A - Wipers

**Safety**
- Safety Glasses
- Organic Vapors Respirator
- Disposable Gloves

Refer to the Manufacturer’s MSDS for recommended safety equipment.

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**Spray Gun Cleaning - Waterborne**

**Step #1**
Flush material passage and gun body with water-based cleaner

**Step #2**
Clean with SATA cleaning brushes

**Step #3**
Use SATA nozzle cleaning needle to clean out the air cap holes

**Step #4**
Rinse with water-based cleaner

**Step #5**
Dry air passages and exterior of gun with an air blower

**Step #6**
Connect air hose and pull trigger on gun to ensure that all cleaning solution is sprayed out of the gun

**Step #7**
Use SATA gun lube on all threads and moving parts including the needle

**Info**

**Tech Support:**  www.satausa.com

**QR Code:**
Gun Cleaning Video
Spray Gun Set Up

Table of Contents

Step #1
Select the correct nozzle size per paint companies recommendation

Step #2
Thin paint material to paint companies recommended viscosity

Step #3
Fan Control Knob - Set fan control knob wide open

Step #4
Air Micrometer and Fluid Control Knobs - Set air micrometer and fluid control knobs wide open

Step #5
Incoming Air Pressure - Set incoming air pressure at maximum psi per spray gun manufacturers recommendation

Step #6
Spray Test Pattern
Adjust fan control and air pressure if needed

Step #7
Overlap - Spray panel with a 75% overlap
Gun Distance - HVLP @ 5” - 6” from surface
          RP    @ 6” - 7” from surface

Info
Tech Support: www.satausa.com
QR Code: Spraying Video

The suggested procedure on this page is a summary of the manufacturer’s procedure. For complete details, review the manufacturer’s instructions that accompany the products and/or that can be found at their websites.
## Respirator Fit Testing

### Step #1
Go to OSHA’s website to review medical evaluation questionnaire and medical evaluation requirements

*See QR code in lower right hand corner*

### Step #2
Check fit of respirator before conducting fit test

⇒ *Asses comfort using the points described on the Fit Test Form*

### Step #3
**Sensitivity Test** - Check to make sure that the person being tested can detect the Bitrex solution by using the sensitivity solution # 9401-03 with nebulizer #1 while not wearing the respirator under the fit test hood

### Step #4
**Don the Respirator** - Have the person being tested don their respirator and then put fit test hood on the person being tested

### Step #5
**Fit Test** - Using the Bitrex solution # 9401-04 with nebulizer #2, check to see if the person being tested can detect the Bitrex solution while wearing the respirator under the fit test hood

*Follow instructions on Fit Test Form*

---

### Products Needed:

<table>
<thead>
<tr>
<th>Product Code</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>SAS # 9401-01</td>
<td>Fit Test Kit</td>
</tr>
<tr>
<td>SAS # 8661-92</td>
<td>Medium Disposable Respirator</td>
</tr>
<tr>
<td>3M # 37079</td>
<td>Medium 1/2 Mask</td>
</tr>
<tr>
<td>3M # 37083</td>
<td>Large 1/2 Mask</td>
</tr>
<tr>
<td>3M # 07046</td>
<td>OV Cartridges</td>
</tr>
<tr>
<td>3M # 07184</td>
<td>P100 filters</td>
</tr>
<tr>
<td>3M # 07194</td>
<td>Pre-filter</td>
</tr>
</tbody>
</table>

### Replacement Fit Test Products:

<table>
<thead>
<tr>
<th>Product Code</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>SAS # 9401-03</td>
<td>Sensitivity Solution</td>
</tr>
<tr>
<td>SAS # 9401-04</td>
<td>Bitrex Solution Refill</td>
</tr>
<tr>
<td>SAS # 9401-05</td>
<td>Nebulizer with labels</td>
</tr>
</tbody>
</table>

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### Info

**Tech Support:** [www.sassafety.com](http://www.sassafety.com)

**QR Code:**

**OSHA Link**

**Fit Test Video**

---

*The suggested procedure on this page is a summary of the manufacturer’s procedure. For complete details, review the manufacturer’s instructions that accompany the products and/or that can be found at their websites.*
QUALITATIVE FIT TEST EMPLOYEE FORM

EMPLOYEE: ____________________________

COMPANY NAME: ____________________________

RESPIRATOR MODEL #: ____________________________

RESPIRATOR SIZE: ____________________________

BEFORE TEST PROCEDURES

Prior to testing, the subject must be able to detect the odor of isoamyl acetate (banana-like order). If he/she is unable to detect the isoamyl acetate odor a different type of test must be given.

The mask being fit tested must be worn for at least 5 minutes to assess comfort. Assistance in assessing comfort can be given by discussing the points below. If the test subject is not familiar with the respirator he/she shall be directed to don the mask several times and to adjust the straps each time so that he/she becomes adept at setting proper tension on the straps.

Assessing the comfort shall include reviewing the following points with the test subject:

- CHIN PROPERLY PLACED
- POSITION OF MASK
- STRAP TENSION
- FIT ACROSS NOSE BRIDGE
- ROOM FOR SAFETY GLASSES
- DISTANCE FROM NOSE TO CHIN
- ROOM TO TALK
- TENDENCY TO SLIP
- CHEEKS FILLED OUT
- SELF-OBSERVATION IN MIRROR
- ADEQUATE TIME FOR ASSESSMENT

Fit Test Exercise: (One Minute for each exercise)

Breathe Normally [ ]
Breathe Deeply [ ]
Turn Head Side-To-Side [ ]
Nod Head Up-And-Down [ ]
Talking (READ Rainbow Passage – see attached page) [ ]
Breathe Normally [ ]

FIT TEST RESULTS [ ] PASS [ ] FAIL

COMMENTS: ____________________________

________________________
TESTED BY

________________________
DATE

________________________
EMPLOYEE SIGNATURE

________________________
DATE

3031 Gardenia Avenue, • Long Beach, CA 90807 (562) 427-2775 • Fax (562) 427-4646
www.sassafety.com
MSDS QR Codes

Like 90 #10009
Like 90 #10032
Like 90 #10034
U-Pol #2002