

Land Rover Standard Operating Procedure

Steel coating process for new replacement parts

Mild Steel Parts

Mild steel is used on many structural and some minor body sections of Land Rover vehicles. New parts are delivered with a protective coating (e-coat) which should not be removed. The following processes **MUST** be used. Failure to use the correct process will invalidate the warranty of the part and vehicle. Always refer to the product Technical Data Sheets (TDS) where applicable.

01. **New non-damaged replacement part preparation**

Clean part according to TDS.

Use a lint free cloth to clean the part. Do not allow product to dry on the surface.

Wipe dry with a clean lint free cloth.

Sand the part according to TDS.

Do not break through the e-coat.

 If the e-coat is broken through go to step 02.

Clean according to TDS.

 Go to step 04.
02. **New damaged replacement part preparation**

Clean part according to TDS.

Use a lint free cloth to clean the part. Do not allow product to dry on the surface.

Wipe dry with a clean lint free cloth.

Identify the extent of the damage. For dents, scratches or breaks in the e-coat use standard sanding tools and equipment.

Welded areas need to be carefully sanded to remove weld-splatter and burnt paint layers. Feather the repair edges.

Prepare the damaged area according to TDS. For filler repairs go to step 03

Clean according to TDS.

 Go to step 04.
03. **New damaged replacement part preparation**

Clean part according to TDS.

Mix the polyester filler or stopper material according to the TDS and apply to the damaged area.

Dry and sand the polyester material according to TDS.

Clean according to TDS.

 Go to step 04.
04. **New or repaired replacement part etch & prime**

All exposed bare steel must be coated with an approved 2K Etch Primer before applying Primer Filler.

Mix and apply the 2K Etch Primer according to the TDS.

Dry primer according to TDS.

Mix 2K Primer or 2K Surfer and apply to the entire part or repair zones.

Dry, sand and clean the primer according to TDS. Reinstall sealer as required.

 Go to step 05.
05. **Basecoat colour for primed and sanded blend areas**

Clean according to TDS.

Primed and sanded parts can now be painted with approved basecoat material.

Mix and apply the basecoat colour according to the TDS.

Dry according to TDS.

 Go to step 06.
06. **Clear coat for base coated or fine sanded blend areas**

After drying the base coat the approved clear coat can be mixed and applied.

Mix and apply the clear coat according to TDS.

Dry according to TDS.