

2021 – Car painter

Task, front fender

Part (not attached to vehicle)

- 1 front fender with small damage



Products and processes

In AS 2021 we will use products from [R-M](#) and [Glasurit](#) brand's of BASF. You can find all the processes described in the «[Technical Data Sheets](#)» on the paint supplier's website (<http://www.rmpaint.com>), and you will have access to these before and during the competition. The correct procedures are described in the «[Technical Data Sheets](#)», and the judging will be based on that information.

The sanding materials, tools and workplace will be prepared in advance.

Personal equipment:

Each competitors will bring following personal equipment's:

Safety shoes, working clothes, goggles and ear protection.

Schedule

		Schedule	Max score
A	Fix dent damage on front fender	0915 – 1000	26
B	Spray filler on front fender	1030 – 1130	23
	Lunch	1130 – 1200	
C	Paint front fender	1200 – 1400	48
		Total 5 hours	Total 109

Tasks

Task A

1. Fix dent on fender
2. Use available equipment in the workshop such as hammer, counter hold and grinding tools
3. Spackle with [STOP UNI](#) or 839-20 and sand it so it's ready for filler

Evaluation: Do not proceed until you have been evaluated.

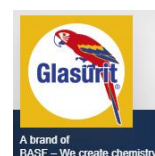
Task B

1. Spray chromate-free wash primer [EUROFILL](#) or 283-150 if necessary
2. Spray [Light Filler Grey 2530E- UV filler](#) or [151-190E UV-filler](#) according to manufacturer's instructions only on damage area.

Evaluation: Do not proceed until you have been evaluated.

Task C

1. Sand UV-filler area, and use non sanding filler [285-31](#) or [Extrasealer](#) on the entire new unpainted fender.
2. Make the fender ready to paint.
3. Mix and spray basecoat [ONYX HD](#) or 90 according to manufacturer's instructions



4. Mix and spray clearcoat [CHRONOLUX](#) or 923-625 according to manufacturer's instructions

Use assessment forms A, B, and C for this task

		Task
		A

Car/ Component	Front Fender
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Time	08.00 – 10.00
Break time	
Task length	
Total task time	

Task sections / Distribution of points		Maximum score
A1	Health, safety, environment, and labor structure	4
A2	Wash	2
A3	Fix dent in door	2
A4	Sanding	2
A5	Apply body putty	4
A6	Sanding the putty	4
A7	Surface scuffing/mat	4
A8	Neatness/organization	4
Task Total		26

Task description:

1. Fix dent on fender with correct equipment
2. Spackle the damaged area

3. Sand the spackle and prepare for filler

						Assessment Form		
						A		
Group ID	Description	Assessment Criteria		Max points	Achieved points Name/candidat			
A	Fixing the damage				A	B	C	D
A1	Health, environment and safety Multiple points deducted for serious/repeated breaking of safety/health rules	Not using gloves	-1p	4				
		Not using a mask	-1p					
		Not using proper work clothes	-1p					
		Not using safety glasses	-1p					
		Not using ear protection	-1p					
A2	Washing With cleaner before starting	Not washing before starting fixing/grinding	-1p	2				
		Not removed glue residues	-1p					
A3	Fix damage Use of repair tools such as hammer and counter hold	Spackled more than 2 mm Outward dent	-2p -1p	2				
A4	Sanding Before spackling	Bottom of dent not grinded clean Unsanded area before spackling	-2p -1p	2				
A5	Polyester body putty	No dust remove	-1p	4				
		Three times spackling	-2p					
		Each large pores/holes in spackle before filler	-1p					
		Too much or not enough hardener	-2p					
A6	Sanding body putty	Begin with P320 or finer	-2p	4				
		If spackling does not finish with P180 (Machine)/ P240/ P320/	-2p					
		Damage visible after grinding	-1-3					
A7	Surface scuffing/mat	Use of abrasives other than P400, P500, Gray Scotchbrite or	-2p	4				
		None sanded aeras	-1p					
		Removed all e-coat down to metal	-1p					
A8	Neatness/organization	Do not tidy up tools or equipment	-2p	4				
		Do not sweep, tidy up workspace	-2p					
		Subtract from total						
Sub	Participant's total points for spackling and preparation			26				

		Task
		B

Car/ Component	Front fender
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Time	10.00 – 11.00
Break time	
Task length	
Total task time	

Task sections / Distribution of points		Maximum score
B1	Health, safety, environment, and labor structure	4
B2	Washing	2
B3	Mix Acid primer	2
B4	Spray Acid primer	3
B5	Mix filler	2
B6	Spray filler	4
B7	Wash paint gun	3
B8	Neatness/organization	3
B9		
B10		
TaskTotal		23

Task description:

1. Prepare fender for primer and filler
2. Mix and spray etch primer/283-150/ Eurofill if needed.
3. Mix and spray UV-filler/151-190/ Light Filler Grey 2530 UV

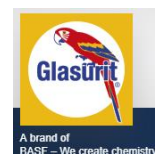


ArcticSkills

Assessment Form

B

Group ID	Description	Assessment Criteria		Max points	Achieved points Name/candidat			
B	Spray filler on fender				A	B	C	D
B1	Health, safety and environment Multiple points deducted for serious/repeated breaking of safety/health rules	Not using gloves	-1p	4				
		Not using mask	-1p					
		Not using painting clothes	-1p					
		Not using safety uv-glasses	-1p					
B2	Washing	Not washed before spraying	-1p	2				
		Not removed dust	-1p					
B3	Mix acid primer?	Incorrect mixing ratio or	-1p	2				
		Mix too much / over 1 dl spill	-1p					
B4	Spray acid primer Repeated mistakes can mean loss of more points,	Wrong spray gun	-1p	3				
		Only one coat	-1p					
		Not matte between coats	-2p					
		Paint runs	-2p					
		Not on bare metal	-2p					
B5	Mix filler	Incorrect mixing ratio	-1p	2				
		Incorrect contents	-2p					
		Over 1 dl spill	-2p					
B6	Spray filler Repeated mistakes can mean loss of more points, e.g. multiple runs	Incorrect spray gun	-2p	4				
		Less than 2 coats or more than 3	-2p					
		Filler not matte between coats	-2p					
		Dry spray/ structure /large spraying distance	-1p					
		Filler runs	-1p					
B7	Wash spray gun ?	Not washing inside	-2p	3				
		Not washing outside	-1p					
B8	Neatness / organization Repeated mistakes can mean loss of more points	Not cleaning tools after use	-1p	3				
		Leave air hose on floor, not cleaning in the boot	-1p					
		Leave paper on floor	-1p					
				Subtract from total				
Sub				23				



		Assessment Form
		C

Car/ Component	Front fender
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Time	11.30 - 14.00

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C1	Health, safety, environment, and labor structure	4
C2	Grinding or sanding	4
C3	Wash and wipe dust	2
C5	Mix basecoat	2
C6	Spray basecoat	5
C7	Wash the painting gun	3
C8	Mix clear coat	2
C9	Spray clear coat	6
C10	Wash the painting gun	3
C11	Neatness and organization	3
C12	Measure total thickness of the paint	4
C13	Check	4
C14		
C15		
Task Total		42

Task description:

1. Sand and prepare fender for paint/ spray non-sanding filler
2. Mix and spray basecoat
3. Mix and spray clearcoat

Participant Name	School	Assessment Form
		C

Group ID	Description	Assessment Criteria		Max points	Achieved points Names/candidate			
C	Paint basecoat and clear coat				A	B	C	D
C1	Health, safety and environment Multiple points deducted for serious/repeated breaking of safety/health rules	Not using gloves	-1p	4				
		Not using mask	-1p					
		Not using painting clothes and hood	-1p					
		Not using safety goggles when washing	-1p					
C2	Sanding Repeated mistakes can mean loss of more points	Use of other than P400/P500 Mirka OSB 4 or gray Scotchbrite (can start with P320 on damage)	-1p	4				
		Filler not grinded/sanded enough	-1p					
		Not using Grinding Guide	-1p					
		Bare metal, each place	-1p					
C3	Washing – Wiping dust	Not washing before painting	-1p	2				
		Not blowing and wiping dust with tack-rag	-1p					
		Not using hood	-1p					
C5	Mix basecoat Candidate mixes basecoat RTU (Ready	1dl over	-1p	2				
		Incorrect mixing	-1p					
C6	Spray basecoat 1st coat - wet 2nd coat - half wet 3rd coat - effect coats	Incorrect spray gun	-1p	5				
		Not mat surface between coats	-2p					
		Paint runs	-2p					
		Must repaint	-4p					
		Primer/ filler shines through	-2p					
		Not painting on sides and under	-2p					
		Clouds	-1p -3p					
C7	Wash spray gun	Not washing inside	-2p	3				
		Poorly washed inside	-1p					
		Not washing outside	-1p					
C8	Mix clear coat	Incorrect mixing ratio	-1p	4				
		Incorrect contents	-2p					
		Over 1 dl spill	-2p					

C9	Spray clear coat 1st coat - half wet 2nd coat – wet/shiny	Spraying with wrong spray gun	-1p	6				
		First layer dries for more than 3 minutes	-2p					
		Second coat to thin, leave an structure (Orange Peel)	-2p					
		Cannot deliver to customer, must be repainted	-5p					
		Runs that can be fixed	-2p					
		Too little clear coat on edges	-2p					
C10	Wash spray gun	Not washing inside	-2p	3				
		Poorly washed inside	-1p					
		Not washing outside	-1p					
C11	Neatness/organization Repeated mistakes can mean loss of more points	Not cleaning tools after use	-1p	3				
		Not cleaning the work place	-1p					
		Leave paper on floor	-1p					
C12	Measure total thickness	Minimum 100 µm 90 µm -1p, 80 µm -2p, 70 µm -3p 60 µm -4p	-1p	4				
C13	Check	Grinding/sanding marks visible after painting	-2p	4				
		Damage slightly visible after painting	-1p					
		Damage clearly visible after painting	-2p					
Sub				42				