

THE 6C'S

1. CHECK Repair area for process building

- Always **check OE Procedures** before commencing any repair
- Check substrate/material type
- Fully Check extent of damage – use of an inspection lamp is recommended
- Check panel temperature and address any extremes by way of heating/cooling
- Turn on glue gun and set temperature to 385°F / 195°C (dispensed glue should be smoking hot)

2. CHOOSE Tab | Lifter | Approach based on substrate

- Select a tab best shaped like the dent or bodyline

Steel

- Tabs should fit within the edges of the dent. This enables a view of the secondary damage so as to know when upward 'pull' of the lifter is sufficient

Aluminium

- Generally best results are achieved by a flexible tab (Blue material not Ice) - this will help aid adhesion and not lock in any crowns
- The neck/shaft of the Dead Center Super Tab becomes the effective pulling focus and it is important that the neck/shaft stays inside the dented area, only the flexible edges cover any crowns – choose your tab based on this

Lifting Tool

- Select a pulling tool based on the amount of precision and control required
- Where possible, use a lifter where the feet hold down and control the surrounding metal

3. CLEAN Remove contaminants from the panel

- Use a cutting compound, either by hand or machine, to clean all stubborn contaminants or wax coatings from the working area
- Thoroughly clean the panel with minimum 95% Isopropyl Alcohol (IPA) - Ideally 99%
- Thoroughly clean the tab surface with minimum 95% Isopropyl Alcohol (IPA) - Ideally 99%

4. COAT How do I apply the glue and tabs?

- Heat the panel surface to 120°F / 50°C
- Flash tab surface over with heat source
- Fill tab surface entirely with glue
- Place tab on panel, do not force glue out from tab - Look for a visible bead of glue surrounding tab edge
- Fill in any gaps surrounding the tab with hot glue from the glue gun directly
- Wait for glue to set up (see next step for pulling temperature)



5.CORRECT The correcting process

- Use infrared thermometer to check for optimal base glue pulling temperature of 85°F / 29°C around bond line of glue then begin setting your pulling device
- Using your chosen lifter start the correcting process
- Remember to create use of the double-action process, which creates metal flow, wherever possible by applying slight upward tension to the tab by way of the lifter
- Knock down highs wherever needed with selected knock down tools – this is the secondary part of the double-action process creating metal flow helping to restore original panel tension.

Remember to check your 'spent' glue for an insight to pulling temperature:

- If a high amount of very small bubbles is visible in the glue, it indicates the glue was too warm when pulled
- If the glue is breaking up or becomes brittle, it indicates the glue was too cold when pulled

6.CONTINUE Moving on to conventional repair

- Repeat KECO's 6C process until large damage reduces and reaches the desired level of panel flatness
- Prepare for filling, remembering some of today's fillers can be used over OE clear coat by keying with 180P (always check Technical Data Sheets)
- Sand
- Repaint

Scan for an in-depth explanation on the 6C's Process pulltopaint.com



Scan to view Commonly asked questions



GLUE GUIDE

FLEX

Large & Complex Damage

This glue is ideal for large and complex dents. It's flexibility and increased setup time equates to a longer working time so you can utilize multiple actions to knockdown while pulling.

HOT

Fast, Small & Simple

This glue is ideal for smaller dents. It's less flexible and requires less time to setup. This allows you to move quicker with more short pulls.

www.kecotabs.com

