

**NORTON**

SAINT-GOBAIN



# COSMETIC REPAIR SOLUTIONS

For body, wheel and headlight repair

THE COMPLETE PRODUCT SOLUTION





## INTRODUCTION

### Saint-Gobain Abrasives: A World Class Manufacturer

With operations in 64 countries, employing almost 190,000 people, Saint-Gobain is one of the world's top 100 leading industrial corporations. Saint-Gobain Abrasives has a presence on every continent, with operations in 26 countries, employing c.10, 700 people; and is the only international manufacturer of the 5 main types of abrasives: Bonded, Coated, Diamond Blades, Cutting-off and Grinding Wheels and Super Abrasives.

### Norton and the Automotive Aftermarket

As one of the leading manufacturers in the automotive refinishing sector, Norton is committed to the manufacturing and distribution of a wide range of non-paint products for the professional bodyshop. The combination of high quality products, vast experience and knowledge of professional sanding systems – from paint removal to surface reconditioning and polishing; allowing you to meet all customers requirements.

**It is our aim to provide optimal abrasive solutions to meet the bodyshop technician needs:**

- By developing complete application and process solutions for a constantly evolving automotive refinishing market
- By working in partnership with our customers to reduce repair costs
- By supplying the highest quality standards through innovation and development
- Strong commitment to health and safety
  - Active founding member of oSa (Organisation for Safety of Abrasives)
  - Active founding member of FEPA (Federation of European Producers of Abrasives)

THE COMPLETE PRODUCT SOLUTION



## CONTENTS

P4-5

LOCALISED REPAIR



P6-7

ALLOY WHEEL REPAIR



P8-9

HEADLIGHT REPAIR

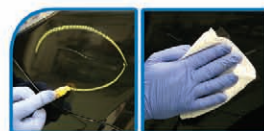


P10-11

PRODUCT GUIDE



## STEP 1



Identify all repairs and assess damage suitability for cosmetic repair. Clean and degrease damaged area

**Recommended Product:**  
Special Solvent Wipes - 160 x 400mm

**Part Number:**  
69957364051

## STEP 5



Use Norton Paint System to mix and apply Primer, referring to the paint manufacturers recommendations

**Recommended Product:**  
Norton Paint System Disposable Kit - 250ml, 125micron  
Norton Paint System Disposable Kit - 250ml, 190micron  
Hard Mixing Cup (Reusable) - 250 ml

**Part Number:**  
07660721644  
07660721645  
07660721650

## STEP 9



Use Norton Paint System to mix and apply top coat, referring to the paint manufacturers recommendations

**Recommended Product:**  
Norton Paint System Disposable Kit - 250ml, 125micron  
Norton Paint System Disposable Kit - 250ml, 190micron  
Hard Mixing Cup (Reusable) - 250 ml

**Part Number:**  
07660721644  
07660721645  
07660721650

## STEP 2



Sanding damaged area using 76mm orbital sander. Take care to minimise area sanded

**Recommended Product:**  
Norton Pro A275 Norgrip® 76mm Disc - P180-P320

**Part Number:**  
P180 - 63642585150  
P240 - 63642585156  
P320 - 63642569699

## STEP 6



Machine sand using orbital sander with interface pad or hand sand for awkward areas

**Recommended Product:**  
Norton Pro A275 Norgrip® 76mm Disc - P500  
Norton Pro Norgrip® Foam Interface  
Rotolo Foam® Norton Pro - P600  
BearTex® Non-Woven Pad - Grey  
BearTex® Non-Woven Pad - Gold  
Norton Scuff Gel

**Part Number:**  
69957391303  
69957394589  
63642557612  
66261058002  
66261058005  
07660705376

## STEP 10



Denib imperfections using a 38mm rosette disc and sand area with 80mm Norton Ice disc

**Recommended Product:**  
Black Ice Self-Adhesive Rosette Disc - P2000  
Norton Ice Foam Backed Disc - 80mm 1500  
Norton Ice Foam Backed Disc - 80mm 2000  
Norton Ice Foam Backed Disc - 80mm 3000

**Part Number:**  
69957360371  
66623324958  
66623324955  
66623324956

## STEP 3



Clean and degrease area and if needed apply a stopper. If stopper used, apply guide coat and sand using a 125mm hand block

**Recommended Product:**  
Multi-Air® Plus Cut Sheet - 70 x 125mm P240  
Multi-Air® Plus Cut Sheet - 70 x 125mm P320

**Part Number:**  
69957394460  
69957394461

## STEP 7



Machine sand any existing paintwork requiring a keyed surface, using an interface pad

**Recommended Product:**  
Dry Ice Q260 Film Norgrip® Disc - P1000  
Norton Pro A275 Norgrip® Disc - P1000  
Norton Pro Norgrip® Foam Interface

**Part Number:**  
66254405679  
63642585180  
69957394589

## STEP 11



Polish area using Liquid Ice: Xtra-Cut, Step 1 and Step 2 polishing compounds

**Recommended Product:**  
Liquid Ice Xtra-Cut Polishing Compound  
Liquid Ice Step 1 Polishing Compound  
Liquid Ice Step 2 Polishing Compound  
Foam Polishing Head - Xtra-Cut Orange (Firm)  
Foam Polishing Head - Step 1 Blue (Medium)  
Foam Polishing Head - Step 2 Black (Soft)

**Part Number:**  
66623339742  
66254429419  
66261191537  
66623339749  
66254441984  
66254441987

## STEP 4



Clean and degrease repair, mask and tack area in preparation for primer

**Recommended Product:**  
Foam Edge Masking Tape (Standard) - 13mm  
Foam Edge Masking Tape (Standard) - 19mm  
Medium Masking Tape 80° - 38 mm x 50m  
Fine Line Tape - 6mm x 55m  
Premium Perforated Trim Tape - 50mm x 10m  
Non-Woven Tack Rags - 320 x 400mm

**Part Number:**  
66254470735  
66254470744  
69957394611  
66261194994  
66261194743  
07660708051

## STEP 8



Clean and degrease repair, mask and tack area in preparation for top coat

**Recommended Product:**  
Foam Edge Masking Tape Standard - 13mm  
Foam Edge Masking Tape Standard - 19mm  
Medium Masking Tape 80° - 38mm x 50m  
Fine Line Tape - 6mm x 55m  
Premium Perforated Trim Tape - 50mm x 10m  
Non-Woven Tack rags - 320 x 400mm

**Part Number:**  
66254470735  
66254470744  
69957394611  
66261194994  
66261194743  
07660708051

## STEP 12



Carefully de-mask and apply detailer spray and remove using a microfibre cloth

**Recommended Product:**  
Norton Liquid Ice Detailer Spray  
Blue Magnet Microfibre Cloth

**Part Number:**  
63642542082  
63642504402

## STEP 1



Deflate tyre push away from the rim for improved access. Clean wheel and removing road traffic dirt/brake dust

**Recommended Product:**  
N/A

**Part Number:**  
N/A

## STEP 2



Sand any imperfections using 76mm orbital sander, taking care to retain the original wheel shape

**Recommended Product:**  
Norton Pro A275 Norgrip® 76mm Disc - P180-P500

**Part Number:**  
P180 - 63642585150  
P240 - 63642585156  
P320 - 63642569699  
P400 - 63642585169  
P500 - 69957391303

## STEP 3



Hand sand any awkward areas using a Rotolo Foam® backed product or BearTex®

**Recommended Product:**  
Rotolo Foam® Norton Pro - P600  
BearTex® Non-Woven Pad - Grey  
Norton Scuff Gel

**Part Number:**  
63642557612  
66261058002  
07660705376

## STEP 4

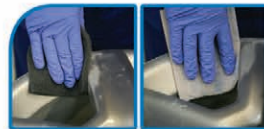


Clean off, degrease and mask wheel and prepare for priming. Apply primer using Norton Paint System 250ml disposable system

**Recommended Product:**  
Medium Masking Tape 80° - 38mm x 50m  
Fine Line Tape - 6mm x 55m  
Norton Paint System Disposable Kit - 250ml, 125micron  
Norton Paint System Disposable Kit - 250ml, 190micron

**Part Number:**  
69957394611  
66261194994  
07660721644  
07660721745

## STEP 5



Apply defect guide coat, and sand primed area, using both orbital sander with interface or hand pads

**Recommended Product:**  
Rotolo Foam® Norton Pro - P1000  
BearTex® Non-Woven Pads - Grey  
Norton Pro A275 Norgrip® 76mm Disc - P1000  
Norton Pro Norgrip® Foam Interface

**Part Number:**  
63642557616  
66261058002  
63642585180  
69957394589

## STEP 6



Clean off, degrease and mask wheel and prepare for top coat. Apply base coat and lacquer using Norton Paint System 250ml disposable system

**Recommended Product:**  
Norton Paint System Disposable Kit - 250ml, 125micron  
Norton Paint System Disposable Kit - 250ml, 190micron  
Hard Mixing Cup (Reusable) - 250 ml  
Medium Masking Tape 80° - 38mm x 50m

**Part Number:**  
07660721644  
07660721745  
07660721650  
69957394611

## STEP 7



De-mask, re-inspect for any imperfections and polish if necessary. Inflate tyre

**Recommended Product:**  
N/A

**Part Number:**  
N/A

## STEP 1



Isolate headlight (remove or mask). Sand headlight using a 76mm P500 disc, removing all scratches, ensuring that the entire surface is prepared

**Recommended Product:**  
Norton Pro A275 Norgrip® 76mm Disc - P500

**Part Number:**  
69957391303

## STEP 2



Continue to sand headlight using a 76mm P800 disc removing any finer scratches. Wipe with microfibre cloth

**Recommended Product:**  
Norton Pro A275 Norgrip® 76mm Disc - P800  
Norton Blue Magnet Microfibre Cloth

**Part Number:**  
63642585172  
63642504402

## STEP 3



Sand headlight using a 80mm 1500grit Norton Ice disc, ensuring the Norton Ice disc is wet

**Recommended Product:**  
Norton Ice Foam Backed Disc - 80mm 1500

**Part Number:**  
66623324958

## STEP 4



Follow same procedure as step 3 using a 3000grit Norton Ice disc. Wipe headlight, ensure all dirt is removed using a microfibre cloth

**Recommended Product:**  
Norton Ice Foam Backed Disc - 80mm 3000  
Norton Blue Magnet Microfibre Cloth

**Part Number:**  
66623324956  
63642504402

## STEP 5



Restore UV protection lacquer in line with paint manufacturer's recommendations

**Recommended Product:**  
N/A

**Part Number:**  
N/A

## STEP 6



Once cooled, polish full headlight using Liquid Ice Step 1 polish and 76mm blue polishing head. Wipe with microfibre cloth

**Recommended Product:**  
Liquid Ice Step 1 Polishing Compound  
Foam Polishing Head - Step 1 Blue (Medium)  
Norton Blue Magnet Microfibre Cloth

**Part Number:**  
66254429419  
66254441984  
63642504402

## STEP 7



Following step 6, use Liquid Ice Step 2 polish with a 76mm black polishing head. Wipe with microfibre cloth

**Recommended Product:**  
Liquid Ice Step 2 Polishing Compound  
Foam Polishing Head - Step 2 Black (Soft)  
Norton Blue Magnet Microfibre Cloth

**Part Number:**  
66261194537  
66254441987  
63642504402

## STEP 8



Finally clean headlight using Norton Detailer Spray and microfibre cloth

**Recommended Product:**  
Norton Liquid Ice Detailer Spray  
Norton Blue Magnet Microfibre Cloth

**Part Number:**  
63642542082  
63642504402

## PRODUCT GUIDE



### Norton Pro A275 Norgrip® 76mm Discs



Norton Pro A275 Velcro discs are made with premium aluminium oxide grain designed for a dry sanding process. The A275 grain provides a fast and consistent cut rate and the special No-Fil® coating prevents clogging caused by dust build up, resulting in a longer lasting, more cost effective disc.

Grits: P80 - P1000 Sizes: 76mm - 150mm Extraction: 7 Hole - 181 Hole

### Multi-Air® Plus Cut Sheets



Multi-Air® cut sheets provide a perfect combination of performance and dust extraction. The unique ceramic blend provides a fast and aggressive cut, whilst the Multi-Air® hole pattern offers a 35% improved extraction over conventional sheets. Use a Multi-Air® block for optimum extraction.

Grits: P80 - P400 Sizes: 70 x 125mm - 70 x 420mm

### Rotolo Foam® Norton Pro



Norton Pro A275 Rotolo Foam perforated rolls are ideal for fine sanding curved and contoured areas; providing an outstanding finish on primer and top coats. Offering the premium performance of A275 grain and the softness of a foam backing, Rotolo Foam provides a superior finish and prevents break through on contoured surfaces. The new and improved perfect cut perforation guarantees a straight edge whenever a piece is torn.

Grits: P120 - P1500 Sizes: 115mm x 25m

### BearTex® Non-Woven Pads



BearTex® products consist of a non-woven nylon, impregnated pad with a unique and high performance abrasive. The result is an ultra flexible, three dimensional material designed for easy surface preparation of contoured and curved surfaces. The uniform spread of abrasives throughout the web provides a consistent and even finish during use, especially when used with Scuff Gel. For ease of use, hand pads are supplied perforated for fast tearing and prolonged life.

Grits: Maroon, Grey & Gold Roll sizes: 100mm x 10m & 115mm x 10m  
Size of each pad: 152mm x 229mm

### Scuff Gel



Norton Scuff Gel is formulated to clean, degrease and abrade in one step. Designed for use with grey and gold BearTex® pads, Scuff Gel enables consistent abrasion for better paint adhesion. The water based formula rinses off easily and leaves no mess.

### Black Ice Self-Adhesive Rosette Discs



Self-adhesive waterproof rosette discs combine a very flexible light-weight latex paper with ultra fine premium grain for fine wet sanding applications.

Grits: 1500 - 2500 Size: 38mm

### Norton Ice Foam Backed Discs



Norton Ice polishing discs are the perfect addition to any polishing process. Designed for flattening prior to polishing, the foam backing absorbs water and provides even pressure across all moulded surfaces during sanding. The unique 3D abrasives structure gives extended life, minimises scratch depth, thus reducing polishing time and providing a perfect finish.

Grits: 1500 - 3000 Sizes: 80mm & 150mm

### Liquid Ice: Xtra-Cut, Step 1 and Step 2



Liquid Ice polishing compounds provide the perfect finish, and combined with Norton Ice discs will reduce your overall polishing process. The silicon free compounds will restore a showroom finish and reduce polishing time.

Grades: Xtra-Cut, Quick-cut and OEM

### Foam Polishing Heads



Norton foam and lamb's wool polishing heads, for use with the Liquid Ice compound. The traditional natural fibres of lamb's wool gives a fast and cool cut for an immediate shine. The colour coded foam heads have an open cell design to reduce heat build up and risk of spray.

Grades: Hard, Medium & Soft Sizes: 76mm & 150mm

### Liquid Ice Detailer Spray



Liquid Ice detailer spray is designed to easily clean up excess buffing residue and provide excellent paint protection. Simply spray on and wipe off with a Blue Magnet microfibre cloth.

Volume: 1 litre

### Dry Ice Q260 Film Norgrip® Discs



Norton Dry Ice Q260 Norgrip® Finishing Film Discs are dedicated to achieving a flawless finish. The exceptionally uniform cut of Dry Ice Q260 provides a consistent finish that significantly reduces polishing time to produce a perfect finish.

Grits: P800 - P1500 Sizes: 76mm - 150mm

### Blue Magnet Microfibre Cloth



Blue Magnet is the ultimate performance cleaning cloth for dusting, drying, polishing and waxing. It absorbs 8 times its own weight in water, dries faster and better than chamois material and is ultra soft, reusable and machine washable. Blue Magnet can be used dry or slightly damp to easily remove dirt, grease and dust. It is suitable for most surfaces: metal body, painted surfaces, glass, plastic and leather.

Size: 400mm x 400mm

### Medium Masking Tape



Medium masking tape is ideal for use in oven and dry cycles when the temperature does not exceed 80°C. Flexibility and good adhesion means it conforms to curves and contours and many surface types including most paints and lacquers, leaving no adhesive residue.

Sizes: 19mm - 50mm

### Blue Decoration Adhesive Tape



Fine line tapes are designed for the demarcation of the most delicate paint work. The tape adheres and conforms easily to contours and irregular surfaces without wrinkling or tearing. It's unique thickness allows minimum edge build-up and leaves no residue when removed. Fine line tape will perform in temperatures up to 150°C for at least 30 minutes and leave a sharp, clean separation line.

Sizes: 3mm - 19mm

### Special Solvent Wipes



These wipes are used for quickly removing polishing residues, improving brightness of the surface without cutting into the coating.

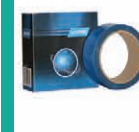
### Foam Edge Masking Tape



Norton Foam Edge Masking Tape is perfect for protecting doors and edges before spraying. Highly absorbent and one continuous length, the adhesive is recessed, leaving no marks on the surface upon removal; requiring no rubbing down. The tape can simply be peeled off for quick and easy use.

Sizes: 13mm and 19mm (standard) & 20mm (premium)

### Premium Perforated Trim Tape



Norton premium perforated trim tape is an ideal way to protect rubber trims and body side mouldings during spraying. The tape is pre-perforated for easy tear off and is flexible to follow contours and tight curves:

- One size and thickness plastic strip to fit all types of rubber trims
- High quality adhesive with no residue upon removal

Size: 50mm x 10m

### Non-Woven Tack Rags



Excellent product to collect very small particles or accumulation of dust. The blue non-woven tack rag is used at the cataphoresis exit, in the production workshop and between each coat, providing a perfect surface finish prior to painting.

Size: 320mm x 400mm

### Disposable Kit



The most effective and productive solution for preparing, mixing, and spraying paint. Providing a faster and cleaner solution, the Norton Paint System saves on cleaning time and solvent usage, and allows the paint to be reused without replacing the filters. The easy to assemble system ensures a consistent spray (even upside down), convenient storage of paint as well as easy and clean disposal of the entire unit, making it ideal for mobile repairs. The small 250ml size cup is ideal for cosmetic repair allowing larger repairs in a single mix.

Cup sizes: 250ml, 750ml & 950ml Filters: 125 & 190 micron

### Hard Mixing Cups



The reusable mixing cup has pre-printed mixing ratio scales for greater convenience.

Cup sizes: 250ml, 750ml & 950ml

Saint-Gobain Abrasives Ltd, Doxey Road, Stafford, ST16 1EA

Tel: 01785 279550 | Fax: 01785 213487

Email: [info.sgauk@saint-gobain.com](mailto:info.sgauk@saint-gobain.com) | [www.saint-gobain-abrasives.com](http://www.saint-gobain-abrasives.com)

