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DIY Auto Body and Paint

Steps For Using Lead

- 1 After metal has been straightened and ready for filling, grind the repair area 4 inches to bare metal past the damaged area.
- 2 Blow metal with compressed air to assure the metal is clean.
- 3 Using the tinning flux, apply a thin coat using an acid brush to the area where body solder will be applied.
- 4 Heat the tinning flux using a acetylene or propane torch. The surface should start to provide a shinny surface. Care should be taken not to overheat the metal.
- 5 Wipe the tinning flux with a towel or steel wool to spread the flux and remove all contaminates. This will provide a shinny surface, which indicates the surface is ready to accept the body solder to be applied.
- 6 Using an oxyacetylene torch or propane torch, heat the solder and metal and apply the solder to the low area of the damaged area. Do not overheat the metal

and remove the tinning flux. If this happens the surface will need to have tinning flux reapplied.

- 7 Apply the solder until the solder is 1/8 inch higher than the surrounding surface.
- 8 Once the solder is applied to the surface use wooden paddles to flatten and smooth the solder while the solder is still hot.
- 9 Using a body file to file and level the body solder. File the solder at a 30 degree angle until the surface is level and the same shape as the original contour of the panel.
- 10 This lead-free body solder can be block sanded for final shaping if desired.
- 11 Wipe the repair area with a solution of 1 part alcohol, 1 part pneumonia, and 1 part water to remove any remaining tinning flux residues that be on the surface.
- 12 Once the body solder is shaped correctly, the surface is ready to primer.

That is it, now you are ready for prime, block and paint.
Works great!