Test Project

Car Painting

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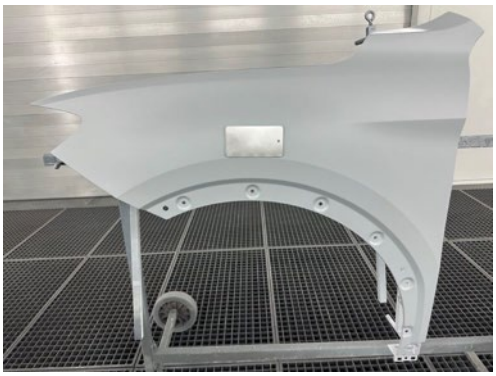
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Module A – Painting a new OEM metal part

Duration: 1h30



Instructions

Paint a new OEM metal part with a wet-on-wet system

Participance get a new OEM MG left side front fender

Preparation

- Preparation of the front fender.
  - Cleaning the fender
  - What does the surface structure of the vehicle part look like?
- Check the fender (scratches/dents and make a note if something damaged) (Expert note the damage)
  - Cleaning again the fender.
  - Participant must mix- primer filler and use "**Job Card**" in Refinity program max. 180,0 g RFU
  - Prepare metal sample for measure film build of primer filler (Expert)!
- Apply Primer filler greyshade with hardener and reducer for wow version.
  - Spray coats (TDS)
  - Flash of the primer filler (TDS)
  - STOP/Before the Base coat is applied the expert must evaluate the primer filler result!
- Participants mix 2 Stage colour (**MG LMD**, bright metallic colour).
  - Participant must mix- base coat colour and use "**Job Card**" in Refinity program max. **200,0** g RFU.
  - Prepare metal sample for measure film build of Base coat (Expert)!
  - Apply base coats on the fender and flash off the base coat anthill matt
- Application of clear coat (A-C-10)
  - Participant must mix- Clear coat and use "**Job Card**" in Refinity program max. **200,0** g RFU.
  - Prepare metal sample (measure film build of CC/Expert)!
  - 1+½ spray coats (TDS) or 2 spray coats for quality (TDS)
  - Outside and inner fender edges (everywhere)
- Clear coat - **gloss finish** (A-C-10)
  - Drying the clear coat





No "STOP" during this part of task. Delegates are clean the work area and equipment.

Save all dry waste in dry waste material container and all liquid waste in liquid material container.

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Module B – Painting a new OEM MG front bumper

Duration: 1h30

Instructions

Paint the new panel with a wet-on-wet system



Preparation

- Preparation of new OEM MG front bumper
  - Bumper must be cleaned.
  - What does the surface structure of the vehicle part look like?
- Bumper must check and defects must note (Expert note the damage)
  - The bumper must be cleaned again.
  - Prepare metal samples for measure film build of all coats (Expert)
  - Participant must mix- primer filler and use "**Job Card**" in Refinity program for mixing max. **390,0** g RFU.
- Application primer filler greyshade
  - ½+ 1 spray coats
  - Flash of the primer filler (TDS)
  - **STOP/Before the Base coat is applied**
  - **The Expert evaluate the primer filler result!**



Colour – 2 Stage metallic (BMW C4G green met.)

Preparation





- Participants mix the 2-stage Base colour
  - Use "**Job Card**" in Refinity program for mixing max. **450,0** g RFU.
  - Prepare metal sample for Base coat (Expert).
  - Apply base coats on the front bumper.
  - Visible area outside and inner edges of the bumper
- Application of clear coat (A-C-10 with 1+ ½ or 2 spray coats).
  - Participant must mix- clear coat using "**Job Card**" in Refinity, mixing max. **450,0** g RFU.
  - Prepare metal sample for clear coat (Expert)
  - Apply the clear, 1+½ spray coats (TDS) or 2 spray coats for quality (TDS)
- Clear coat – **glos s finish**
  - Drying the clear coat.

No "STOP" during this part of task. Delegates are clean the work area and equipment.

Save all dry waste in dry waste material container and all liquid waste in liquid material container

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Module C – Masking a side of a MG car

Duration: 1h

Instructions

Each participant work on one (1) side of the car.

You required to mask a combination of two (2) to three (3) adjacent panels how could be painted after masking



Preparation

- Preparation of car
  - Clean the areas to be masked
- Masking from inside to outside
  - Inside could be paper or soft tape, masking tape 19/25/50 mm
  - Outside area in foil, front doors window down, no air vortex traps in the foil cover.
- Fine Line 3-5 mm on the vehicle strips
- A soft edging technique has to demonstrated of a least one (1) car part to minimum 50 cm in length
- Door molding, exterior mirrors, headlights and rear lights you have to taped
- Door handle get no masking.

No "STOP" during this part of task. Delegates are clean the work area and equipment.

Save all dry waste in dry waste material container.

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Module D – Repair a new damaged door with putty, primeer filler, sading system and colour in and outside

Duration: 3h



Instructions

You will get a new OEM MG metal door with damages. (3)

Preparation

- Preparation of a damaged new door
  - Cleaning the MG door, check the damaged area
  - Clean the door again and sand the damaged.
  - Preparing the door damage area removes e-coat anthill bare metal.
  - **(STOP, Expert check)**
  - Fill the dents with body filler, sanding the body filler area (check with guide coat), sanding inside and outside of the door
  - **(STOP, Expert check)**
  - Cleaning the door in and outside
  - Participant must mix- primer filler max. **520,0** g RFU and use "**Job Card**" in Refinity program for all mixings.
  - Apply primer filler sanding version in and outside of the door.
  - Drying the primer filler, sanding primer filler and cleaning the door in and outside.
  - **(STOP, Expert check sand-through spots)**
- Participants mix the OEM colour (**POR M9A** solid colour).
  - Participant must mix- Base coat colour max. **525,0** g use "**Job Card**" in Refinity program.
  - Mix the mixed colour 2:1 100-E5 = RFU
  - Apply base coat first on the outside (both layers)
  - then inside of the door.
  - Flash of until mat, using dry jets?





- Clear coat-gloss finish.
  - Participant must mix- Clear coat max. **500,0** g RFU and use "**Job Card**" in Refinity program.
  - Outside and inside high gloss (everywhere) (A-C-10)
  - Drying the clear coat

No "STOP" during this part of task. Delegates are clean the work area and equipment.

Save all dry waste in dry waste material container and all liquid waste in liquid material container.

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Module E – Colour Adjustment (time)

Duration: 1h and 1h30

Instructions

- We give you colour standard samples with colour code and tinter formulas, solid or pearl colour
- And you get wrong colour samples with some colour codes.
- You get from each colour **120,0** g for colour adjustment and to spray colour samples

Preparation

- Cleaning the samples and check the colours
- Prepare colour samples (max.3)
- Colour adjustment, tinting the colour.
- Application of adjust base colour and finish at the end with all prepared samples with clear coat (A-C-10).
    - Participant must mix- Clear coat max. **100,0** g RFU and use "**Job Card**" in Refinity program.
    - Drying the clear coat with IR lamp
- Clear coat – **gloss finish**

No "STOP" during this part of task. Delegates are clean the work area and equipment.

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Module F1 – Design on OEM MG Spoiler

Duration: 1h

Instructions

You will get an OEM MG tailgate spoiler.

The Design must show the China flag, Shanghai City Skyline, name WorldSkills plus Icon and the wording "Worldskills Shanghai 2026" too.

Preparation



- Preparation of the spoiler
  - Cleaning with, check and sanding the spoiler.
    - Participant must mix- Primer Filler max. **120,0** g RFU and use "**Job Card**" in Refinity program.
  - Apply primer filler wow version, flash of.
- Participants get premix colour (**Ral 9003** solid) white **100** g.
  - Mix the colour 2:1 100-E5 = RFU
  - Apply the white colour of 100 Line, flash of time after application.
  - Mix clear coat (A-C-10) max. **150,0** g RFU and use "**Job Card**" in Refinity program
  - Drying the clear coat.
  - **(STOP the Module F1)**

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Module F2 – Design on OEM MG Spoiler

Duration: 2h30

Instructions

Part F2 of Design of Competition.

Four (4) templates need their position

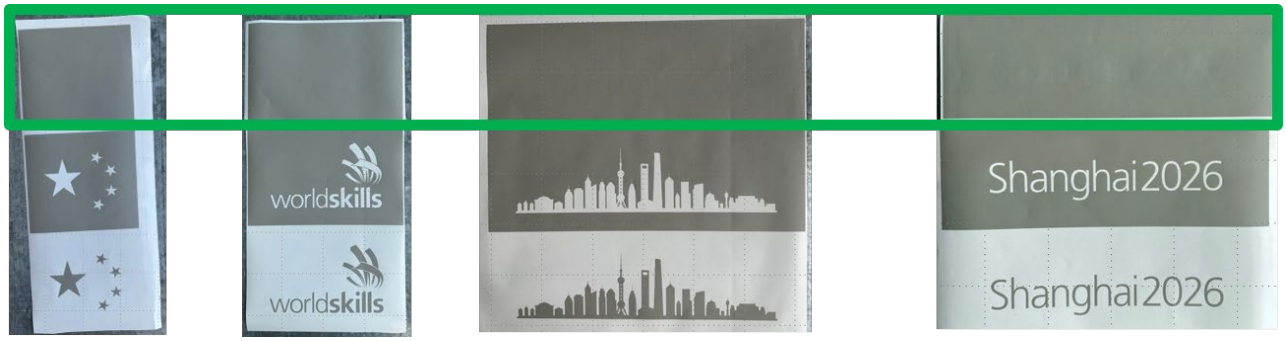
Preparation

- Sanding the MG spoiler (Module F1) matt (P500/P800)
- Clean the spoiler with Waterborne cleaner



Preparation

Preparation of the different templates

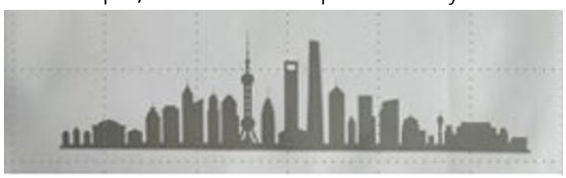


Instructions

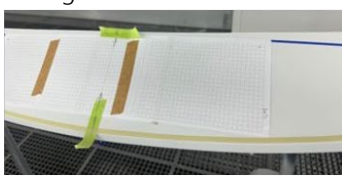
Part F2 of Design of Competition.

Preparation

- The center of the spoiler must be determined.
- Example, the size of template of CityLine is 48 cm/480 mm and is the basic of the design







- Two (2) letterings you will get: WorldSkills plus Logo and Shanghai 2026







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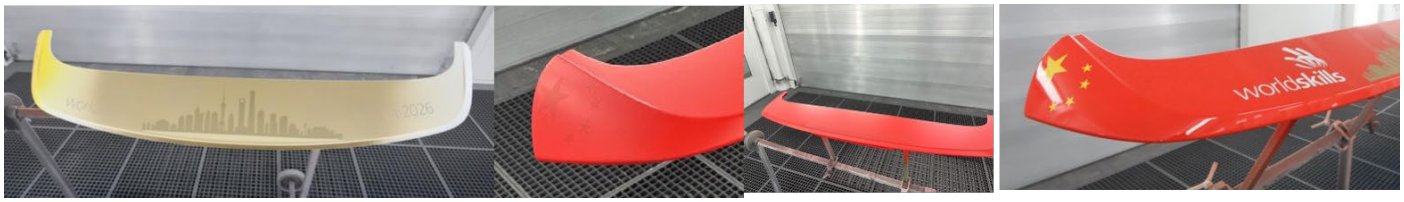
Instructions

Spray colours

Preparation

- Clean the Spoiler with Waterborne cleaner
- You get three (3) premix colours Yellow (50 g), Gold (60 g) and Red (100 g) of 100 Line to paint the MG spoiler.
- Place the given WorldSkills templates
- Spray the colours of 100 Line
- Flash of between all colours, using dry jets.
- After drying remove all masking/templates





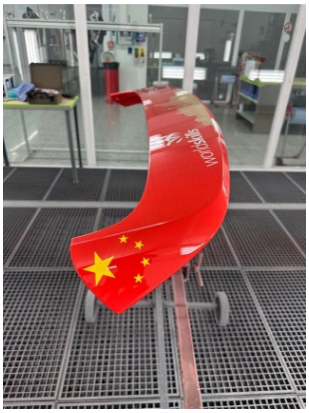
Instructions

Clear coat

Preparation

- Cleaning with dust-binding cloth
- Application of clear coat A-C-30 max, **180.0** g RFU and use "**Job Card**" in Refinity program
    - 2 spray coats
    - Drying the clear coat





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Module G – Painting a damaged MG front bumper

Duration: 1h30

Instructions

Paint the damaged front pumper

Preparation



- Bumper must be cleaned check the damaged area
  - Sand the damage area as small as possible, masking and cleaning the bumper
  - Participant mix- primer filler and use "**Job Card**" in Refinity program max. **60,0** g RFU
- Application primer filler greyshade (TDS)
  - Drying the primer filler with IR lamp
  - Sand primer filler area and the blending zone of the bumper
  - Cleaning again the bumper.



- Application base coat 100 Line
  - Participant get 100 Line premixed colour with 100-M 15 and you mix max. **100,0** g RFU
    - Apply base coats on the prepared area.
- Application clear coat
  - Participant must mix- Clear coat **(RFU)** (A-C-10) using "**Job Card**" in Refinity, mixing max. **100,0** g.
  - Apply the clear and use blending additive for the fade out area
  - Drying the clear coat.

No "STOP" during this part of task. Delegates are clean the work area and equipment.

Save all dry waste in dry waste material container and all liquid waste in liquid material container.

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Module H – Blending into an adjacent panel

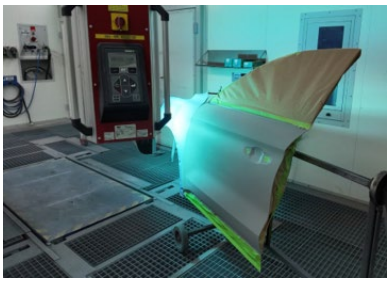
Duration: 2h



Instructions

Using the fender from module A repair as the damaged area and the door from module D for blending in adjacent panel

Preparation



- Preparation of damaged fender and blending the front door
  - Cleaning the panels and sand the damaged area on the fender
  - Mask the fender, spray and dry the **UV primer filler greyshade**
  - Sand the dryed UV primer filler
  - Sand the door matt
  - Clean the panels and mask the door from inside
  - Cleaning again all parts.
  - **STOP/Before the Base coat is applied the Expert must evaluate the primer filler result! (transparent)**



- Preparation of base coat (POR **M9A** solid colour).
  - Participant mix- the noted colour and use "**Job Card**"
  - Refinity program 100 Line max. **240,0** g
  - Mix the basecoat with Blendering Clear max. **100,0** g RFU
- Apply Blender Clear and 100 Line base coat like recommended e-book.
  - Flash of the painted area anthill matt.



- Preparation of clear coat application
  - Participant mix- the clear (A-C-30) and use "**Job Card**"
  - Refinity program max. **350,0** g RFU
- Apply Clear on booth panels

No "STOP" during this part of task. Delegates are clean the work area and equipment.

Save all dry waste in dry waste material container and all liquid waste in liquid material container.

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Module I – Polishing tasks

Duration: 1h

Polishing tasks

- Preparation of front bumper from Module G
- Cleaning the front bumper
- Check the blending/fade out zone of the front bumper.
- If there is a gloss level difference, polish the clear coat in the blending zone area
- In the repair area, a damage area (grinding grooves P1200) must be processed and polished
- Polishing the clear coat sprayed area to a high gloss level.

No “STOP” during this part of task. Delegates are clean the work area and equipment.

Save all dry waste (sanding dics/paper) in dry waste material container.

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