

## The 100mm Rule Explained

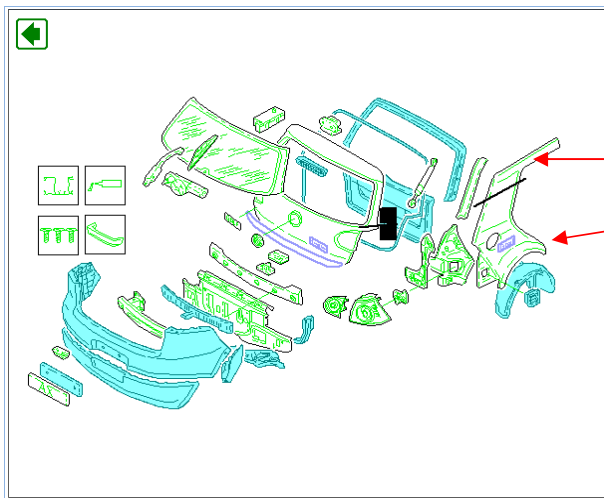
Audatex UK uses paint data provided by the AZT research centre for all vehicle manufacturers with the exception of:

- Mercedes
  - Peugeot
  - Porsche
- } when the manufacturers' own paint operations and times are used.

When 'new part painting' weld-on panels, the Audatex paint calculation will generate an overlap area of 100mm into adjoining panels. This is to accommodate burn and fitting damage etc.

The overlap area will provide 100mm of preparation, primer, basecoat and clearcoat (subject to the paint type used).

**If the 100mm area is considered insufficient to finish, the adjoining panel(s) should be marked to blend.**



In these two areas, arrowed

- Roof rail
- Sill panel

the 100mm is insufficient to "lose" the blend. Therefore it is necessary to select to Blend + Paint the Roof rail and the Sill panel.

However it should be noted that lamps, bumpers, lamps and other panels etc. often cover the panel joints.

If the lamp covers the welded area the 100mm area may be sufficient to lose the blend behind the lamp, and or rear bumper, as in the case shown in the example on the right. Paintwork must be finished to a natural panel break: swage, or seam.



## Painting New Internal Welded Panels

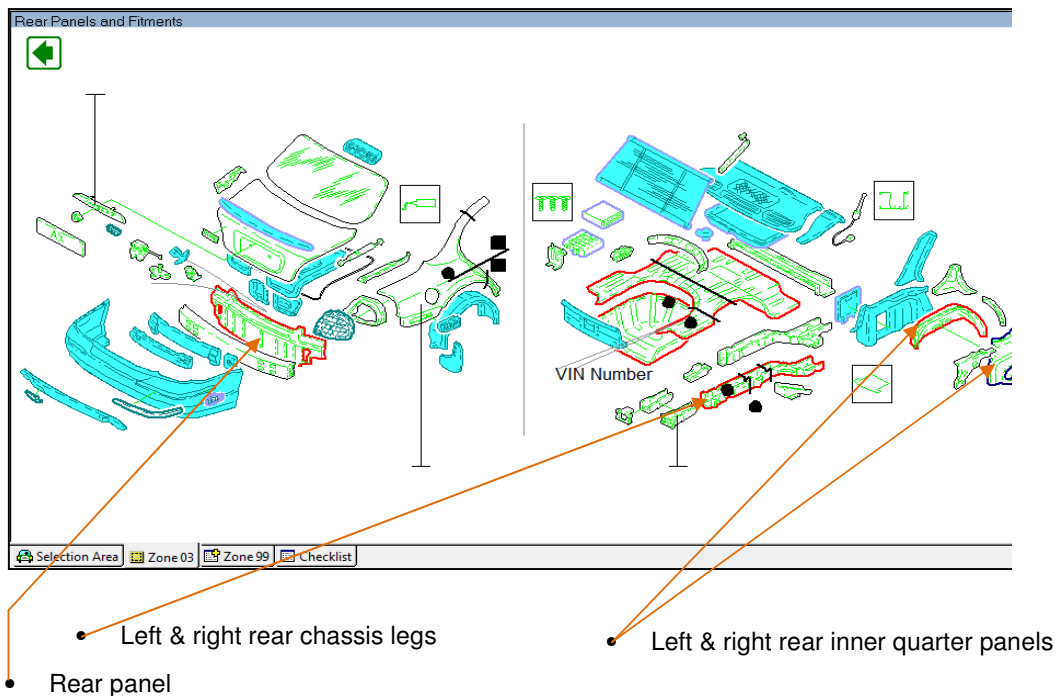
When an internal welded panel has been renewed it must be noted that the 100mm rule **does not apply**. There is no allowance for preparing or painting adjoining panels.

Internal panel painting is surface paint only and the time and paint and material allowance assumes a wet on wet application.

### Example: Boot Floor Renewal

In the scenario where the boot floor pan is to be renewed, the system will only generate time and paint and materials values to surface paint the boot floor. This does include the underside of the panel but does NOT include any adjacent panels

If the method of repair indicates that it is necessary to select to Blend + Paint the adjacent panels as in the example shown below, it will be necessary to manually select the required panels from the graphics within the Audatex system.



If the underside of the boot floor requires coating with an under body anti corrosion material and the time is not included in the vehicle manufacturer's panel times\* the time to apply the under body anti corrosion material should be entered in Zone 99 as an opinion time.

**\*Refer to the Audatex Seam Sealer Matrix on the Audatex website: [www.audatex.co.uk](http://www.audatex.co.uk)**

Enter the value for the under body anti corrosion materials in Zone 99.

Corrosion protection (cavity) will need to be entered in the usual manner.