

manufacturingservicesdata

Refurbishment and painting



Our repair and refurbishment activities include

- Repair of light and heavy accident damage for chassis and body with laser alignment and co-ordinated measurement to ensure accuracy
- Conversion of vehicle interiors to suit individual client needs using 3D CAD technology to confirm build
- Access to key suppliers of bespoke parts and materials specific to the industry
- Ability to perform full coach and bus re-sprays in our purpose-built spray plant
- Retro-fit of air-conditioning systems, ramps, and kneeling systems (where engineering parameters allow)
- Application of under-body corrosion protection systems to prolong vehicle lifeCollection and return of vehicles
- Free, no obligation, quotation

Bluebird Vehicles' paint process

- Removal of all handles, lamps, reflectors and rubbers prior to paint prep
- Wet flat the existing surface with p800 paper
- Wash off flattening residue
- Mask appropriate areas and final wash off
- For direct gloss systems, apply 1 x mist & 3 x normal coats of 2k paint - paint build to 80microns
- Position paint masks
- Apply further coats of 2k paint using the 1 x mist 3 x normal coats rule of thumb per colour used
- In the case of a metallic C.O.B. system, apply 4 x coats of basecoat - paint build to 30microns
- Apply 3 x coats clear lacquer- paint build to 70microns
- For both types of paint scheme, machine polish front, back and sides of vehicle
- Replace all handles, lamps, reflectors and rubbers that were removed prior to paint prep
- Black any over-spray in door checks wheel-arches etc
- Apply 1 x coat of 3m Hand glaze to vehicle exterior, clean windows, entrance step areas and black tyres

Paint Bay and Paint systems

- All vehicles are painted in a fully heated spray booth fitted with a filtration system to both air inlets and outlets. The filtration system works on positive pressure from the top of the bay forcing the airflow downwards to filtered extraction system located at floor level around the bay perimeter.
- All vehicles are subjected to a 3hr bake period at the end of each colour applied, and are subjected to a 15min bake period between coats.
- All painted vehicles are left for a minimum of 12hrs before being polished.
- All paint systems used are two-pack systems normally we would use either Lechler, Tetrosyl, Spies Hecker and HMG. We have access to ICI, Sikkens and PPG schemes though it should be noted that these are more expensive.

Warranty

Bluebird Vehicles guarantee the paint adhesion to the existing substrate for a period of 5 years; this guarantee does not take into account any issues that may be caused by failure of adhesion between original substrate and the factory finish. Any field failure of paint adhesion or finish quality will be dealt with by our service department who will, if required, recover the vehicle to our Scarborough facility for this work.