

# Front and Rear Skirts

## Refinishing Procedures (cont'd)

NOTE: It is not necessary to apply the clear coat.

- Spray 2-3 coats of the top coat enamel to get 15-20 microns of thickness. The primer surfacer (gray) should not show through the top coat.

NOTE:

- Apply the top coat enamel to the repaired surface.
- Apply the top coat enamel to the entire surface of the primer surfacer when replacement is necessary.

### 12. Degreasing and Cleaning

Air dry the entire surface, then clean with a wax and grease remover (for USA usage-Dupont 38125 Enamel Reducer).

NOTE: For shading or spot painting, polish the area with a polishing compound. Also sand with a #1500 paper to make a better bonding surface for the paint.

### 13. Masking

- Remove all existing masking paper, then mask with new paper.
- Use a heat resistant type masking tape (SCOTCH TAPE) where tape is attached directly to the skirt.
- Use brown paper or masking roll paper to cover.

NOTE:

- Mask the area completely to prevent overspray.
- Protect resin parts with aluminum foil under the brown paper or masking paper to prevent damage due to heat during baking.

### 14. Top Coating

- Air dry and degrease the surface before spraying the paint. Also clean the surface with a tack cloth.

#### ⚠ WARNING

- **Ventilate when spraying paint. Most paint contains substances that are harmful if inhaled or swallowed. Read the paint label before opening the paint container.**
- **Avoid contact with skin. Wear an approved respirator, gloves, eye protection and appropriate clothing when painting.**
- **Paint is flammable. Store it in a safe place, and keep it away from sparks, flames or cigarettes.**
- Remove dust and dirt from the surface to be coated with compressed air, then use a tack cloth.
- Use a strainer when filling the cup with paint.
- Spray the paint evenly over the surface so the replacement part is completely covered.
- For application of the top coating refer to step 11 "Intermediate coating."

NOTE: Do not try to cover the surface with one heavy coat. Apply several thin coats.

- With solid color (2-coat type), metallic color and pearl color enamels, allow final coat to flash-off (5-20 minutes) before applying clear coat.
- Mix the additive into the clear in the ratio of 1 to 5. Adding the hardener and adjusting viscosity should be done the same way as described on the previous page.  
Viscosity: 68°F (20°C) 13-15 sec.

Mixing Ratio (weight)

| Metallic enamel/Clear solid enamel | Additive | Hardener |
|------------------------------------|----------|----------|
| 5                                  | :        | 1=4 : 1  |

## 15. Drying top coat

**⚠ WARNING** Body parts being dried with an industrial dryer can get hot enough to cause injury. Do not touch parts being dried.

- Before force drying, let it air dry for 5-10 minutes.
- Force dry the sprayed surface under the infrared lamps for 60-90 minutes.
- Keep the drying temperature between 140°F (60°C) and 158°F (70°C).

NOTE: Take care not to let the heat deform the part during the drying process.

## 16. Polishing and Buffing

- Let the paint dry gradually, then polish the surface carefully using a polishing compound and sponge buff.
- To remove lint or dirt, wet sand the surface with #2000 or finer paper first, then polish with compound.

NOTE: Polish all roughness caused by sanding thoroughly. To do this, first polish with very fine compound, then with ultra fine compound.

- After polishing, remove the masking paper and tape and wash the entire vehicle thoroughly.

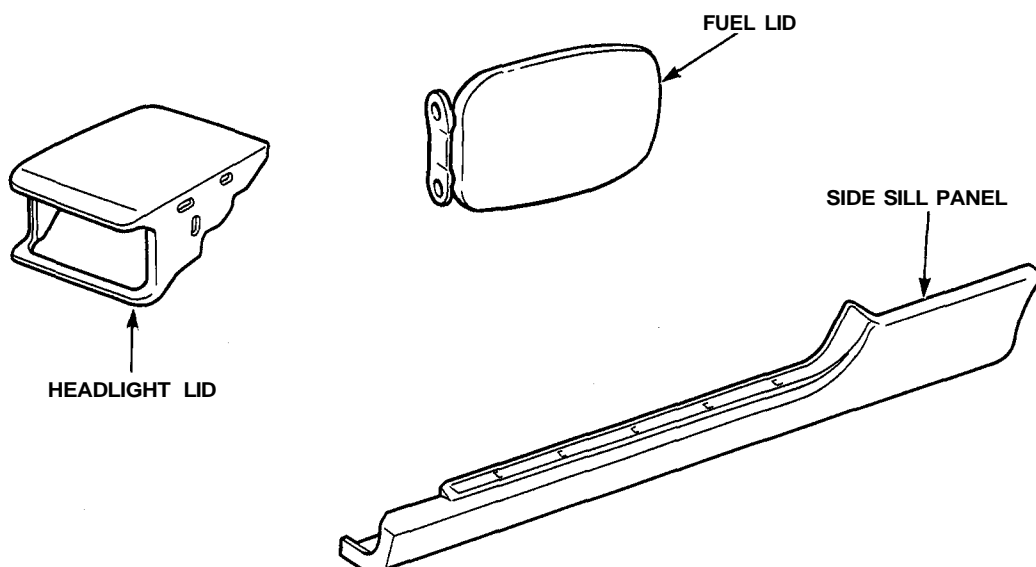
# Headlight Lid, Side Sill Panel and Fuel Lid

## General

The nylon-resin parts can be repaired when it is lightly damaged or deformed. The repair procedure slightly differs from that of the PP, ABS resin and urethane resin parts.

### NOTE:

- Nylon-resin is a polymer of nylon and PPE alloy which has excellent heat resistance properties and flexibility.
- Heat-resisting temperature: 284°F (140°C).



NOTE: The following repair procedures also apply to the trunk lid spoiler.

## Repair Materials (Example)

The following materials are required to repair of the nylon-resin parts. Use the specified material or a commercially available equivalent.

### Adhesive and filler:

#### Epoxy

- Kemit TE2301 bond quick mender

#### Filler

- Body filler 873 (R-M)
- 3M 5900 Flexible Parts Repair Material (Akzo)

### Primer:

Use when the resin material is exposed.

- Prast flex (Akzo)
- 800R Flexible filler (DuPont)

### Primer surfacer:

Some primer surfacers can be applied to the basis material directly, depending on the manufacturer's.

NOTE: Coat with PP bumper primer when the resin material is exposed.

- 1220R H,S-filler primer (DuPont)
- Auto cryl filler (Akzo)
- NPS735 urethane primer surfacer (R-M)

### Top coat:

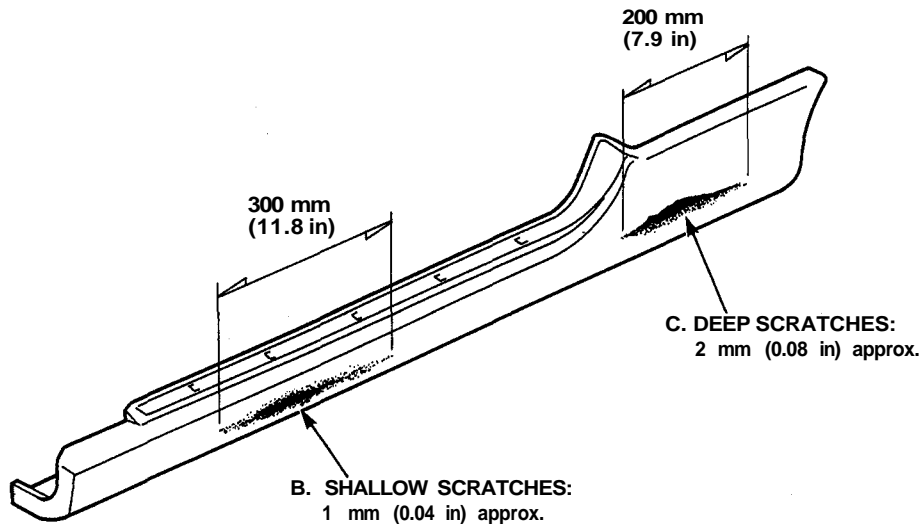
- Super ponacle II (R-M)
- Super Centari: (DuPont)
- Auto cryl (Akzo)

### Repair materials and paints:

Use the repair materials listed in the "Example of repair materials" as instructed in the manufacturer's instruction manual.

NOTE: Be sure to refer to the manual(s) and use the repair material(s) properly.

## Repair Procedures



### A. Replacement part:

- (1) Apply intermediate coat (gray)  
Sand both sides of the part (#400, #600).
- (2) Dry primer surfacer, then sand (#400, #600).
- (3) Apply top coating
  - 1. Metallic enamel + color clear coat.
  - 2. Solid color enamel + clear coat.
  - 3. Pearl enamel + clear coat.

NOTE: Also applicable to "Shallow scratches", "Deep scratches" and "When filling".

### B. Shallow scratches:

Not down to the base material:

- (1) Sand top coat (#400, #600).
- (2) Apply top coating.

NOTE: Coat with primer surfacer when the base material is exposed.

### C. Deep scratches, When filling:

- (1) Sand the damaged section (#180, #240).
- (2) Spray with primer and dry.  
NOTE: When the base material is exposed.
- (3) Coat with primer surfacer.
- (4) Dry primer surfacer, then sand (#240, #400).
- (5) Apply polyester resin filler.
- (6) Dry polyester resin filler, then sand (#240, #320).
- (7) Coat with primer surfacer.
- (8) Dry primer surfacer, then sand (#400, #600).
- (9) Apply top coating.

# Headlight Lid, Side Sill Panel and Fuel Lid

## Refinishing Procedures

### 1. Base material reconditioning (sanding)

#### -1. Replacement part

Lightly sand both sides of the part.

#### -2. Slight scores or scratches

Use a flexible sanding block and wet sand the damaged section with #400, #600.

NOTE: Sand level to remove damage.

#### -3. Deep scratches, When filling

Use a flexible sanding block and wet sand the damaged section with #180, #280.

NOTE: Perform the featheredging on the material surface and coat surface (primer, intermediate coat, and top coat) thoroughly and properly.

### 2. Degreasing, and cleaning

Clean the repair area with wax and grease remover, then blow with air dry.

#### **⚠ WARNING**

- Do not use high air pressure; use only an approved, 210kPa (2.1 kg/cm<sup>2</sup>, 30 psi) air nozzle.
- Wear goggles or safety glasses to prevent eye injury.

NOTE: Wipe dust off the surface with a tack cloth.

### 3. Primer application

- Apply to the deep scratches and areas to be filled. This procedure might not be required by some manufacturer's, products.
- Spray wider than the damaged section (i.e. area to be filled) two or three times.

NOTE: Follow the manufacturer's specification.

### 4. Coating with primer surfacer and drying

NOTE: Some manufacturers might require puttying before performing this step.

Spray the primer surfacer wider than the filled area and the exposed base material.

The spray guideline should be 20-23 microns.

#### **⚠ WARNING**

- Ventilate when spraying paint. Most paint contains substances that are harmful if inhaled or swallowed. Read the paint label before opening paint container.
- Avoid contact with skin. Wear an approved respirator, gloves, eye protection and appropriate clothing when painting.
- Paint is flammable. Store in a safe place, and keep it away from sparks, flames or cigarettes.

NOTE: Follow the manufacturer's instructions.

- After coating with the primer surfacer, let the primer surfacer dry naturally for 5 to 10 minutes then dry the paint film of the primer surfacer with an infrared dryer.
- While drying the primer surface with the dryer, be sure to keep the dryer 40-50 cm (16-20.in) away from the paint film.

#### **⚠ WARNING**

Body parts being dried with an industrial dryer can get hot enough to burn. Do not touch parts being dried.

### 5. Filling drying and sanding

- The exposed base material could be directly filled, depending on the manufacturer's specification.
- Be sure that the primer surfacer is dried completely.
- Lightly dry sand the primer surfacer paint film with the #240 paper.

- Apply the filler in several thin coats.

NOTE: Mix and apply the filler according to the manufacturer's instructions.

- Dry the filler with an infrared dryer for 5 or 6 minutes.
- While drying the filler with the dryer, be sure to keep the dryer 40-50 cm (16-20 in) away from the surface.
- Scratch the filled surface with your nail. If the surface is white when scratched, dry sand and wet sand with the #280, #320 paper. Be sure to sand level.

## 6. Cleaning with compressed air, and degreasing

Blow the entire area that is to be coated with primer surfacer with compressed air, then clean with wax and grease remover.

### ⚠ WARNING

- Do not use high air pressure; use only an approved, 210kPa (2.1 kg/cm<sup>2</sup>, 30 psi) air nozzle.
- Wear goggles of safety glasses to prevent eye injury.

NOTE: Also wipe the masking area to help the masking tape adhere securely.

## 7. Masking

- Mask the area that should not be sprayed with the primer surfacer.
- Use the masking tape and paper to mask.

## 8. Coating with primer surfacer and drying

- Spray the two primer surfacer over the filled area.
- The spray guideline should be 20-25 microns..

NOTE: Follow the primer surfacer manufacturer's instructions.

- After coating with the primer surfacer, let the primer surfacer dry naturally for 5 to 10 minutes, then dry with an infrared dryer.

### ⚠ WARNING

**Body parts being dried with an industrial dryer can get hot enough to burn. Do not touch parts being dried.**

- While drying with the dryer, be sure to keep the dryer 40-50 cm (16-20 in) away from the paint film.

## 9. Sanding, and cleaning

Lightly wet-sand the whole area to be painted with # 600 sandpaper. Blow off with compressed air, then clean with wax and grease remover.

## 10. Top coating

- Remove dust with a tack cloth before top coating.
- Spray the top coat paint.  
Spray until the primer surfacer is covered. The spray guideline should be 30-35 microns.

### ⚠ WARNING

- Ventilate when spraying paint. Most paint contains substances that are harmful if inhaled or swallowed. Read the paint label before opening paint container.
- Avoid contact with skin. Wear an approved respirator, gloves, eye protection and appropriate clothing when painting.
- Paint is flammable. Store in a safe place, and keep it away from sparks, flames or cigarettes.
- Do not use high air pressure; use only an approved, 210kPa (2.1 kg/cm<sup>2</sup>, 30 psi) air nozzle.
- Wear goggles or safety glasses to prevent eye injury.

NOTE: For the recommended top coat paint, refer to the "4. Top coat" of "Example of repair materials".

Solid: Color enamel + color clear coat  
Metallic: Metallic enamel + clear coat  
Pearl: Pearl enamel + clear coat

## 11. Drying

After top coating about 10 minutes, then dry with an infrared dryer.

NOTE: Follow the paint manufacturer's specification to dry properly.

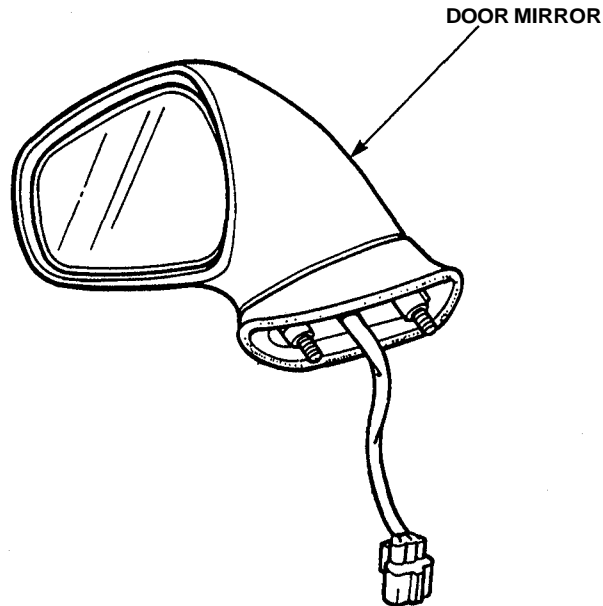
# Door Mirror

## General

The door mirror housing are made of ABS resin.

They can be repaired if the damage or deformation is minor in nature. This section covers ABS repair. Repairing ABS is different from other resins such as PP and urethane.

NOTE: The ABS resin is the copolymer resin consisting of the three monomers of acrylonitrile, butadiene, and styrene.



## Repair Materials (Example)

Adhesive and filler: Epoxy

- Kemit TE2301 bond quick mender

Filler:

- RM Stop zinc (R-M)
- 3M 5900 Repair Material (Akzo)

NOTE: Follow the manufacturer's specification.

Top coat:

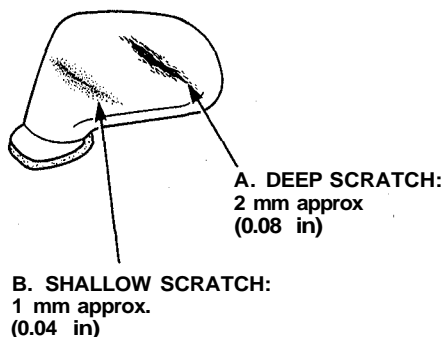
- Super ponacle II, Solo de Diamont, Diamont (R-M)
- Autocryl Auto base (Akzo)
- Super Centari (DuPont)

Primer/Primer surfacer:

Use when the resin material is exposed.

- RM fast filler + RM flex primer (R-M)
- Plasto flex primer II coat (Akzo)
- 1220RH-S filler primer (DuPont)

## Repair Procedures



### A. Deep scratches, when filling:

- (1) Sand the damage section. (#120~#240)
- (2) Apply the filler and dry.
- (3) Sand the filler (#240~#400)
- (4) Coat with the primer/primer surfacer and dry.
- (5) Sand the primer surfacer. (#600~#800).
- (6) Top coating.

### B. Shallow scratches:

- (1) Coat with the primer/primer surfacer.
- (2) Sand the primer surfacer. (#600~#800).
- (3) Top coating.

### C. Repaint:

- (1) Sand the primer surfacer. (#600~#800)
- (2) Top coating.

## Refinishing Procedures

### 1. Base material reconditioning (sanding)

- 1. Repaint and replacement part lightly sand the part with #400, #600 or #800.
- 2. Slight scores or scratches  
Use a flexible sanding block and wet sand the damaged section with #400, #600.  
NOTE: Sand level to remove damage.
- 3. Deep scratches, when filling.  
Use a flexible sanding block and wet sand the damaged section with #240, #400.

### 2. Degreasing and cleaning

Clean the repaired area with wax and grease remover, then blow with air dry.

#### ▲ WARNING

- Do not use high air pressure; use only an approved, 210 kPa (2.1 kg/cm<sup>2</sup>, 30 psi) air nozzle.
- Wear goggles or safety glasses to prevent eye injury.

NOTE: Wipe dust off surface with a tack cloth.

### 3. Filling, drying and sanding

Apply the filler in several thin coats.

NOTE: Mix and apply the filler according to the manufacturer's instructions.

- 1. Dry the filler with an infrared dryer for 5 or 6 minutes  
Be sure to keep the dryer 40-50 cm (16-20 in) away from the surface.
- 2. Scratch the filled surface with your nail. If the surface is white when scratched, dry sand and wet sand with the #240-#400 paper. Be sure to sand level.

### 4. Cleaning with compressed air, and degreasing

Blow the entire area to be coated with compressed air, then clean with wax and grease remover.

#### ▲ WARNING

- Do not use high air pressure; use only an approved, 210 kPa (2.1 kg/cm<sup>2</sup>, 30 psi) air nozzle.
- Wear goggles or safety glasses to prevent eye injury.

NOTE: Clean the whole surface to help the masking tape adhere securely.

(cont'd)



# Door Mirror

## Refinishing Procedures (cont'd)

### 5. Masking

Use the masking tape and paper to mask the area that should not be sprayed.

### 6. Coat with primer/primer surfacer, drying and sanding.

- Spray the primer surfacer over the filled area.

#### ⚠ WARNING

- Ventilate when spraying paint. Most paint contains substances that are harmful if inhaled or swallowed. Read the paint label before opening the paint container.
- Avoid contact with skin. Wear an approved respirator, gloves, eye protection and appropriate clothing when painting.
- Paint is flammable. Store it in a safe place, and keep it away from sparks, flames or cigarettes.
- Do not use high air pressure; use only an approved, 210 kPa (2.1 kg/cm<sup>2</sup>, 30 psi) air nozzle.
- Wear goggles or safety glasses to prevent eye injury.
- The coating thickness should be 20-25 microns.

NOTE: Follow the primer/primer surfacer manufacturer's instructions.

#### -1. Drying

- Let the primer surfacer dry naturally for 5 to 10 minutes, then dry with a infrared dryer.

#### ⚠ WARNING

Body parts being dried with an industrial dryer can get hot enough to cause injury. Do not touch parts being dried.

- Be sure to keep the dryer 40-50 cm (16-20 in) away from the paint film.

#### -2. Sanding

Lightly dry sand the whole area to be painted with #600, #800 sandpaper.

### 7. Blow off with compressed air, then clean with wax and grease remover.

#### ⚠ WARNING

- Do not use high air pressure; use only an approved, 210 kPa (2.1 kg/cm<sup>2</sup>, 30 psi) air nozzle.
- Wear goggles or safety glasses to prevent eye injury.

NOTE: Clean the whole surface to help the masking tape adhere securely.

### 8. Top coating

- Remove dust with a tack cloth before spraying.
- Spray the top coating. Spray until the primer surfacer is covered.
- The coating thickness should be 30-35 microns.

#### ⚠ WARNING

- Ventilate when spraying paint. Most paint contains substances that are harmful if inhaled or swallowed. Read the paint label before opening the paint container.
- Avoid contact with skin. Wear an approved respirator, gloves, eye protection and appropriate clothing when painting.
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- Do not use high air pressure; use only an approved, 210 kPa (2.1 kg/cm<sup>2</sup>, 30 psi) air nozzle.
- Wear goggles or safety glasses to prevent eye injury.

NOTE: For the recommended top coat paint, refer to "Example of repair materials".

Solid color: Color enamel + color clear coat

Metallic : Metallic enamel + clear coat

Pearl : Pearl enamel + clear coat

### 9. Drying

After top coating for about 10 minutes, then dry with an infrared dryer.

NOTE: Follow the paint manufacturer's specification to dry properly.