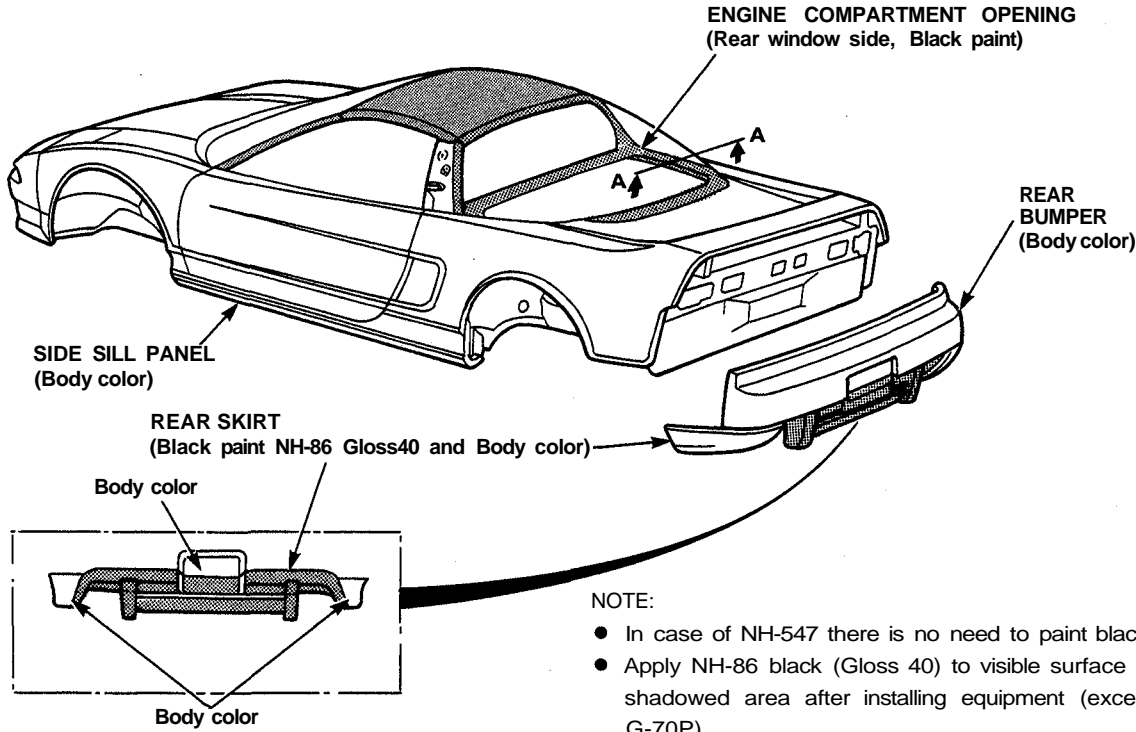
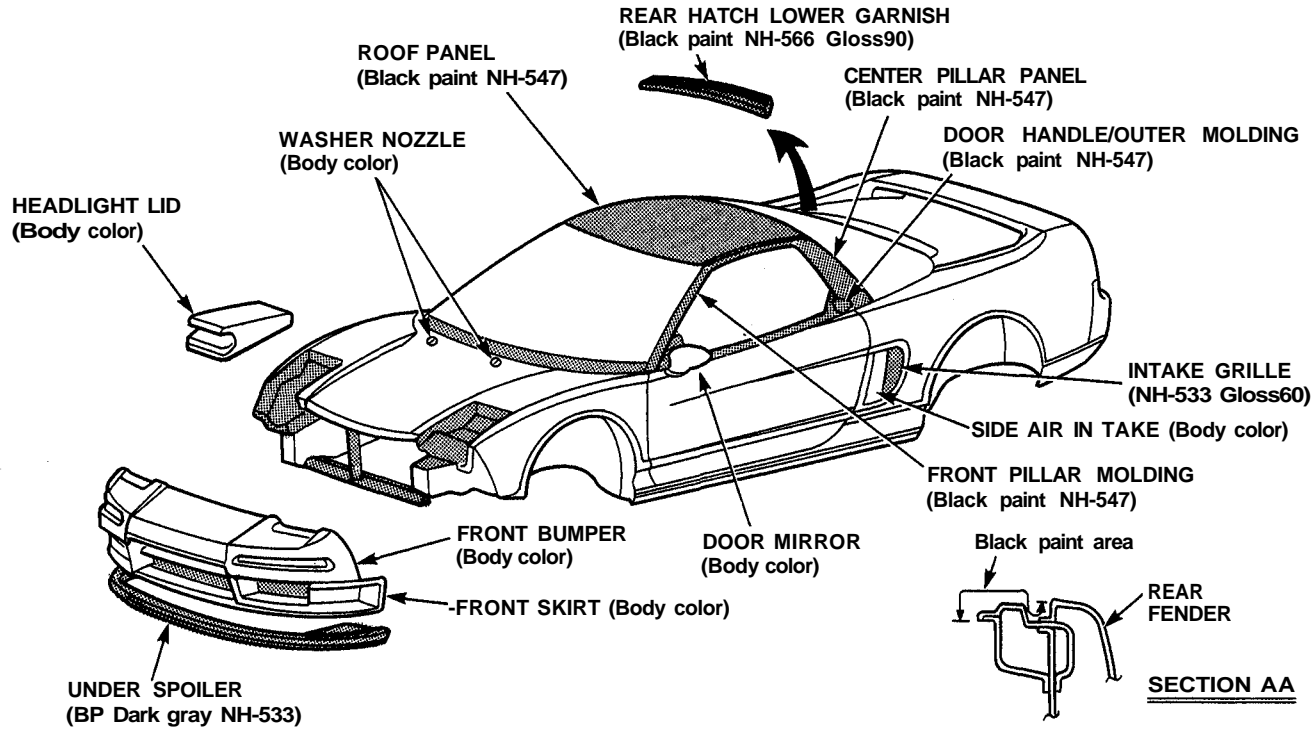


# Color Chart Painting Specifications

Honda code		NH-547	NH-552M	R-77	NH-565	G-70P
Color name		Berlina Black	Sebring Silver Metallic	Formula Red	Grand Prix White	Chariot Green Pearl
Body color	USA	○	○	○	○	○
	Canada	○	○	○	○	○



**NOTE:**

- In case of NH-547 there is no need to paint black.
- Apply NH-86 black (Gloss 40) to visible surface of shadowed area after installing equipment (except G-70P).

# 4C•4B (4-Coat•4-Bake) Paint

## General

4C•4B paint finish gives the NSX a deep gloss and stunning finish. This manual provides information on paint defect repair and refinishing. Throughout, the objective has been to explain in a simple yet comprehensive manner the basic items you should know about paint repairs. Select the correct material for the defect and repaint or refinish in the correct manner as described in this manual.

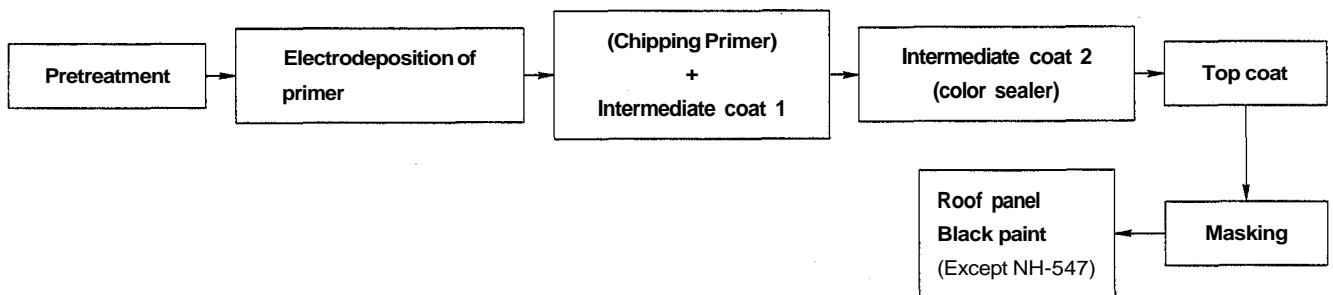
### ⚠ WARNING

- Most paints contain substances that are harmful if inhaled or swallowed. Read the paint label before opening the container. Spray paint only in a well ventilated area.
- Cover spilled paint with sand, or wipe it up at once.
- Wear an approved respirator, gloves, eye protection and appropriate clothing when painting. Avoid contact with skin.
- If paint gets in your mouth or on your skin, rinse or wash thoroughly with water. If paint gets in your eyes, flush with water and get prompt medical attention.
- Paint is flammable. Store it in a safe place, and keep it away from sparks, flames or cigarettes.

### Basic Rules in Repairing a 4C•4B paint finish

To repair paint damage, always use the 2-part acrylic urethane paints designated; polish and bake each of the four coats, as in production, to maintain the original film thickness, and to assure the same quality as the original finish.

### Outline of Factory Painting Process:



### Features in Each Work Process

#### 1. Pretreatment and Electrodeposition

In the pretreatment process, the entire body is degreased, cleaned, and coated with zinc phosphate by dipping after being. After the body has been cleaned with pure water, it is placed in an electrolytic bath of soluble primer (Cationic Electrodeposition). This will produce a thorough corrosion inhibiting coating on the inner surfaces and corners of the body, pillars, sills or panel joints. Chipping primer is then applied to the most susceptible area ([see page 8-11](#)).

#### 2. Intermediate coat 1

The intermediate coat 1 is applied to the prepared surface in for further protection against damages.

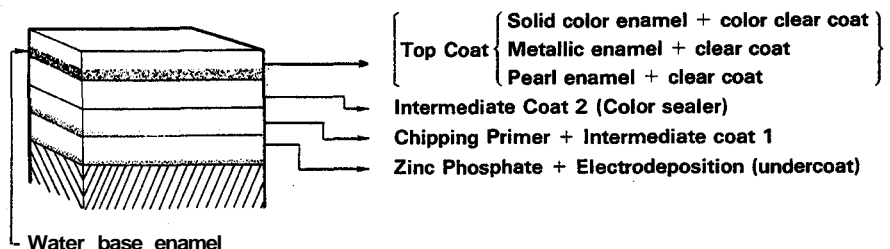
#### 3. Intermediate coat 2

The intermediate coat is matched to the color of the top coat.

#### 4. Top coat

Water base enamel paint and either polyester or acrylic resin paint is used in the top coat for higher solidity, smoothness, brightness, and weather resistance.

### Sectional View of Paint Coats:



# 4C•4B (4-Coat•4-Bake) Paint

## Color Matching

The intermediate coat will determine the color and quality of the paint finish (smoothness, gloss, brightness and thickness). Be sure to follow mixing instructions explicitly and measure the paint accurately.

### Combination Table:

Top Coat	Intermediate Coat 2		Intermediate Coat 1	
	Color 1 (N9.0)	Color 2 (N3.0)	Color 1 (N8.0)	Color 2 (N4.5)
NH-547 Berlina Black		○		○
R-77 Formula Red	Exclusive color (Red color base)			○
NH-552M Sebring Silver Metallic	○		○	
NH-565 Grand Prix White	○		○	
G-70P Chariot Green Pearl	Exclusive color (Black color base)			○
For Mass Production	Polyester or Urethane Paints N9.0: White N3.0: Dark Gray		Polyester or Urethane Paints N8.0: White N4.5: Dark Gray	
For Repair	1. Enamel paint for top coat is used as intermediate coat 2 (Acrylic urethane paint)  2. Exclusive color: Use the same hue as the exclusive color. (Acrylic urethane paint)		Present epoxy two-part primer surfacer (gray) may be used.	

## Paint Refinishing

Paint damage can appear in any form. Before making a repair, check the damaged area carefully, and determine the procedure best suited to the type of damage. The following relates paint refinishing methods to various types of paint damage or defects.

## Defects and Refinishing Processes

### ⚠ 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.

### A. Damage or defects that have gone through to the aluminum alloy base surface

Oxidation or deformation:

Steps:

- ① Featheredging
- ② Preparation of the aluminum alloy base
- ③ Apply of chemical coating to metal surface  
Metal conditioner, aluminum alloy treatment.
- ④ Apply undercoat (primer surfacer)
- ⑤ Apply intermediate coat 1 (surfacers and primer surfacer)
- ⑥ Apply intermediate coat 2 (color matched to top enamel paint)
- ⑦ Apply of top coat (body color paint)  
Solid color: Color enamel + color clear coat  
Metallic color: Metallic enamel + clear coat  
Pearl color: Pearl enamel + clear coat

### B. Damage or defects up to undercoat or intermediate coat 1

External damage or blisters:

- (1) Perform Steps ④ through ⑦ under Item A.

### C. Damage defects up to intermediate coat 2

External damage:

- (1) Perform Steps ⑥ through ⑦ under Item A.

### D. Damage or defects which have not gone through to intermediate coats (only in top coat)

Shallow scratches or score marks:

- (1) If damage has gone through to the metallic paint and pearl paint, spray metallic enamel and pearl enamel, then apply top coat wet on wet.
- (2) If damage has not reached the metallic and pearl paints and remained in the clear top coat, polish the damaged surface or spray clear top coat alone.

NOTE: Try to repair by polishing as much as possible if the damage has not reached metallic and pearl paints.

### E. Replacement of Parts

#### -1 Welded parts

Front side frame, etc.

- (1) Perform Step ① through ⑦ if the damaged area is covered with filler or welded with reinforcement plate.
- (2) Perform Step ⑥ through ⑦ for undercoats except those on joints (Intermediate coat 1 for replacement parts).
- (3) On back of parts, apply paint to where undercoats are burned by heat of welding. Follow this with a rust preventive treatment (see section 7).


#### -2 Single Parts





Painting of outer and inner hood, door, trunk lid etc.

- Painting of inside of the front fender and rear fender.
- (1) Perform Step ⑤ through ⑦ of Item A.
  - (2) Perform Steps ⑥ and ⑦ of Item A.
    - Spray metallic and pearl enamel paints to door and other parts.
  - (3) Only enamel top coat paint may be used.
    - Solid color enamel
    - Metallic enamel
    - Pearl enamel
  - (4) After spraying enamel paint, perform rust preventive treatment (apply inner or outer rust preventive agent).

# 4C•4B (4-Coat•4-Bake) Paint

## Refinishing Processes

NOTE: (  ): Indicates steps which may be required according to the degree of damage)

Refinishing Processing	Damage	To aluminum alloy base	To under/intermediate, coats	To intermediate coat 2	To top coat	Replacement Parts	
						Welded part	Single part
1. Featheredging (polishing damaged surface)		↑				↑	
2. Preparation of aluminum alloy base							
3. Air blowing/Degreasing							
4. Treatment of aluminum alloy base							
5. Filling/drying/Polishing							
6. Air blowing/Degreasing							
7. Masking (part)							
8. Undercoating/Drying							
9. Polishing undercoat							
10. Air blowing/Degreasing							
11. Masking							
12. Spraying intermediate coat 1/Drying							
13. Polishing intermediate coat 1							
14. Air blowing/Degreasing							
15. Masking (reinforcement)							
16. Spraying intermediate coat 2/Drying							
17. Polishing intermediate coat 2/Top coat					↑		
18. Air blowing/Degreasing							
19. Masking							
20. Spraying top coat/Drying (Black painting of roof panel)							
21. Polishing/Buffering							

## Refinishing Procedures

### 1. Featheredging (polishing damaged areas)

-1. Damage to aluminum alloy base

- Sand the damaged area flat and smooth with a double action sander and #60 or #80 disc paper.
- Sand the boundary between the metal surface and undercoat with a double action sander and #180 or #280 disc paper. Try to sand a larger area than the damage.

#### NOTE:

- Make sure there is not height difference between the metal surface and undercoat.
- If double action sander is not available, use a rubber block and wrap sandpaper around it to sand the surface.

**⚠ WARNING** To prevent eye injury, wear goggles or safety glasses whenever sanding, cutting or grinding.

-2. Damage to Undercoat

Intermediate coat 1

Intermediate coat 2

Top coat

Paint coat on replacement parts

Sand the damaged surface flat and smooth with a double action sander and #280 or #320 paper.

#### NOTE:

- If double action sander is not available, use a rubber pad and wet or dry sand the surface with #280, #320, #400 or #600 sandpaper.
- After sanding, check that the surface is flat and smooth.
- Perform the operations in Item 1-1 above for the areas where parts are welded to the body.

### 2. Preparation of aluminum alloy base surface

Remove all corrosion from the damaged area using #180 or #280 paper.

### 3. Air Blowing/Degreasing

Air blow the sanded area, then degrease with a wax and grease remover (for USA usage-DuPont 38125 Enamel Reducer).

### 4. Treatment of aluminum alloy base

- Brush or spray a solution of chrome phosphate or washer primer to the exposed aluminum alloy base.
- Use the following materials to treat the aluminum alloy base:
  - KAR washer primer (Kansai Paint) (for usage-DuPont)
  - 110 active primer Agent (Nippon Paint)
  - G113 treatment (Isam Paint) (for USA usage-DuPont)

#### NOTE:

- Follow the manufacturer's instructions.
- Treat the aluminum alloy base surface, as much as possible, to provide a better bonding surface for the subsequent paint.

### 5. Application of Filler

#### Drying Sanding

- Small cracks or pinholes in the aluminum alloy base should be repaired with a filler and sanded flat and smooth.

#### NOTE:

- Mix the filler to the hardener in the correct ratio.
- Follow the filler manufacturer's instructions.

#### ⚠ WARNING

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

- Allow the filler to air dry for about 5-6 minutes, then force dry with an infrared lamp.

NOTE: Keep a 40-50 cm (16~20 in) from the filler while drying.

- Stop drying the filler if a white mark appears when the surface is scratched with your nail. Wet or dry sand the surface flat and smooth with a #280 or #320 paper.

(cont'd)