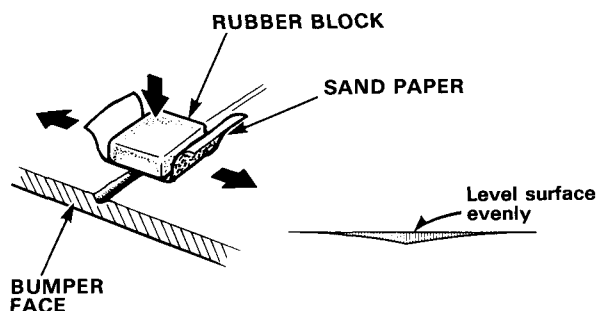


Front and Rear Bumpers

Refinishing Procedures

1. Sanding damaged area

NOTE: Use a rubber block and sandpaper until surface is flat and smooth.
Sand evenly.



Shallow scratch (External damage):

Wet-sand the damaged section with #600 - #1200 sandpaper.

Damage to base material:

Wet-sand the damaged section with #600 sandpaper.

Deep scratches, when applying filler:

- Level and finish burrs and other irregularities with #180 sandpaper.
- Wet-sand the damaged section with #280 sandpaper.

Repaint or paint replacement part

Wet sand the top coat or intermediate coat (gray) surface flat and smooth with #600 - #800 sandpaper.

2. Degreasing/Cleaning

⚠ WARNING

- Do not use high air pressure; use only an approved, 210kPa (2.1 kg/cm², 30 psi) air nozzle.
- Wear goggles or safety glasses to prevent eye injury.
- Wipe off all lint and other foreign particles from the surface with a tack cloth.

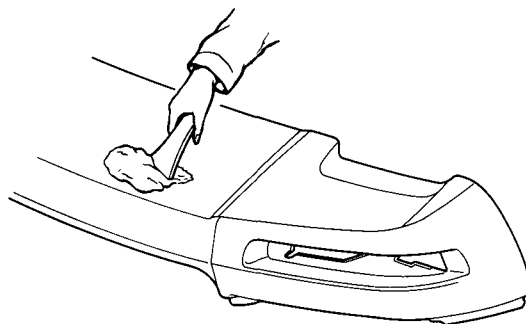
NOTE: Be sure to use a tack cloth to clean the surface as dust and dirt are electrostatically drawn to the surface.

3. Applying filler

- Degrease surfaces thoroughly with wax and grease remover.
- Thoroughly mix the filler and hardener.

NOTE:

- Mix the filler and hardener in the proper ratio.
- Follow the filler manufacturer's instructions.



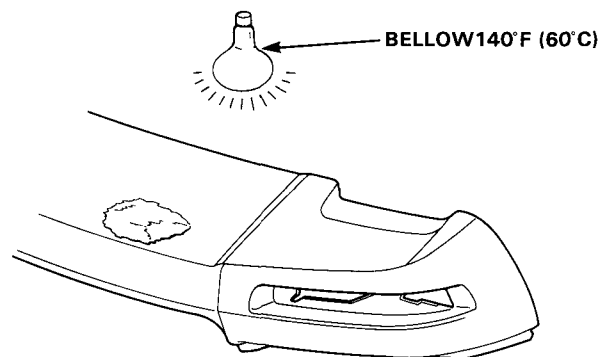
4. Drying filler

Air dry to 5 minutes, then heat to 140°F (60°C) for ID-20 minutes with a dryer.

⚠ WARNING

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

NOTE: Use care when heating to prevent deformation.

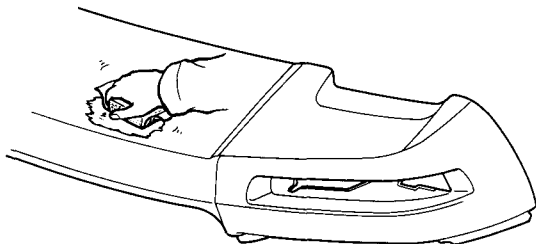


5. Sanding filler

- Sand with double action sander and #180 or #240 sandpaper until the surface is flat and smooth.

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

- Use a rubber or wooden block back plate when the surface is to be wet or dry sanded by hand, with #280 sandpaper.
- Wet-sand with #400 - #600 to where primer and primer surfacer are to be applied.



6. Degreasing/Cleaning

- Clean with wax and grease remover and blow with compressed air.

⚠ WARNING

- Do not use high air pressure; use only an approved, 210kPa (2.1 kg/cm², 30 psi) air nozzle.
- Wear goggles or safety glasses to prevent eye injury.
- Wipe off all lint and other foreign particles from the surface with a tack cloth.

NOTE: Be sure to use a tack cloth to clean the surface as dust and dirt are electrostatically drawn to the surface.

7. Spraying primer and primer surfacer

⚠ 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 safe place, and keep it away from sparks, flames or cigarettes.
- Pour the necessary amount of primer or primer surfacer into a beaker.
- Add hardener and thinner to the primer or primer surfacer in the correct ratio.

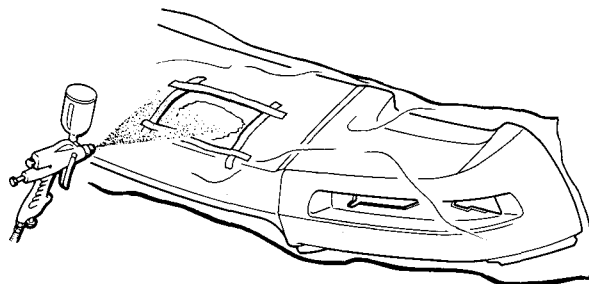
NOTE:

- Before pouring, stir contents thoroughly.
- Follow the primer/primer surfacer manufacturer's instructions.
- Fill the cup with primer/primer surfacer adjust nozzle and pressure, and test spray pattern.

⚠ WARNING

- Do not use high air pressure; use only an approved, 210kPa (2.1 kg/cm², 30 psi) air nozzle.
- Wear goggles or safety glasses to prevent eye injury.
- Spray primer or primer surfacer as required.

NOTE: Avoid heavy application of primer/primer surfacer at one time. Allow each coat to flash-off before applying another coat.



(cont'd)

Front and Rear Bumpers

Refinishing Procedures (cont'd)

8. Drying primer

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

Air dry for 5-10 minutes, then force dry with a infrared dryer.

NOTE:

- Use constant care when force drying to prevent deformation.
- Follow the paint manufacturer's instructions.
- After drying, wet sand the surface with #600 sandpaper and air blow.

⚠ WARNING

- Do not use high air pressure; use only an approved, 210kPa (2.1 kg/cm², 30 psi) air nozzle.
- Wear goggles or safety glasses to prevent eye injury.

9. Applying the spot filler

Check the surface and apply spot filler to cavities or flaws in the surface.

NOTE:

- Apply spot filler evenly.
- Follow the paint manufacturer's instructions.

10. Drying and sanding spot filler

- Air dry for 5 minutes, then heat to 140°F (60°C) for 20-30 minutes with a dryer.

⚠ WARNING

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

NOTE: Use care when heating to prevent deformation.

- After drying, wet sand the surface with #600 sandpaper.
- Wet-sand with #400 - #600 to where intermediate coating area.
- Clean, air blow, and degrease thoroughly.

11. Intermediate coat

- Use top coat enamel base.

⚠ 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.
- Pour the necessary amount of top coat enamel into a beaker.
- Add additive and hardener to the paint and mix.

NOTE: Follow the paint manufacturer's instructions.

- Adjust viscosity with thinner, then pour into cup after filtering.
- Adjust delivery and pressure, and test spray.
- Clean the surface with tack cloth and air blow.
- Spray until the primer or primer surfacer is completely covered.

NOTE:

- Avoid heavy application of paint at one time.
- Allow each coat to flash-off before applying another coat.

12. Drying and sanding

⚠ WARNING

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

- Air dry for 10-15 minutes before force drying.

NOTE:

- Follow the paint manufacturer's instructions.
- Use constant care while force drying to prevent deformation.

- After drying, wet sand the top coating area with #600 - #800 sandpaper.

NOTE: Use a rubber block and sand flat and smooth.

- Clean and air blow

13. Masking

Mask the surface around the repair to keep over spray off.

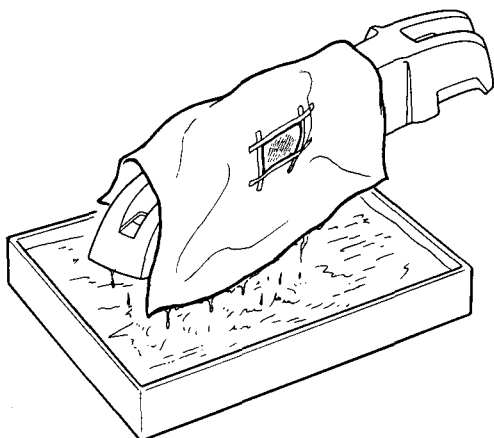
NOTE:

- Mask as much of the surface as possible.
- Use masking paper which is free of fiber dust. Use of polyethylene sheet is recommended.

14. Surface discharging

NOTE: Wear safety goggles, rubber gloves and face mask. Follow the manufacturer's instructions.

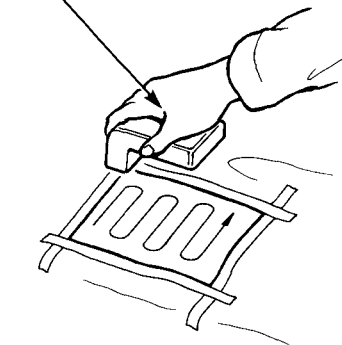
- By alkaline degreasing agent/surface active agent.
- 1. Degrease with alkaline degreasing agent and rinse well with water.
Degreasing agent: LIDOLIN 24 (Nippon Paint) or equivalent.
- 2. Treat with surface active agent and rinse well with cold or hot water.
Surface active agent: LIDOSOLE 501 (Nippon Paint) or equivalent.



- By surface discharger
Use a surface discharger to negatively ionize the surface to be painted.

Discharger: ES Gas + Power Unit (Nippon
Lansburge)
Surface discharger (National)

SURFACE DISCHARGER



15. Top coating

⚠ 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/cm², 30 psi) air nozzle.
- Wear goggles or safety glasses to prevent eye injury.
- Pour paint into a beaker.
- Add additive and hardener to the paint and mix.

NOTE: Follow the paint manufacturer's instructions.

- Adjust viscosity with thinner, then pour into cup after filtering.
- Adjust delivery and pressure, and test spray pattern.

(cont'd)

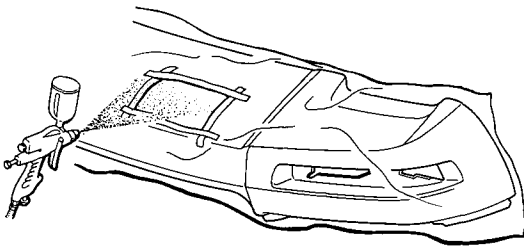
Front and Rear Bumpers

Refinishing Procedures(cont'd)

- Clean the surface with tack cloth and air blow.
- Spray until the intermediate coat is completely covered.

NOTE:

- Avoid heavy application of paint at one time.
- Allow each coat to flash-off before applying another coat.
- With solid color or metallic enamel, allow final coat to flash-off (5-20 minutes) before applying clear coat.



16. Drying

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

Air dry for 10-15 minutes before force drying.

NOTE:

- Follow the paint manufacturer's instructions.
- Use constant care while force drying to prevent deformation.

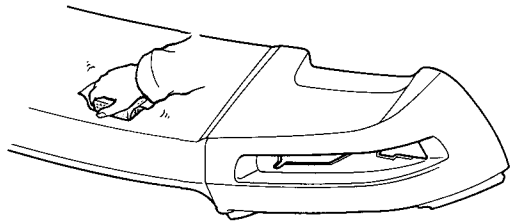
17. Polishing and buffing

If dirt, sanding dust, lint or pigment adheres to the surface or becomes embedded, the surface should be treated as follows:

- Lightly sand off with #2000 sandpaper and polish with soapy water.

NOTE: Use a rubber or wooden block and sand the surface evenly. Clean dirt and dust off thoroughly.

- Wipe the surface clean and air blow.
- Polish with a sponge buff using very fine compound. Move the polisher up and down and right and left using light pressure.

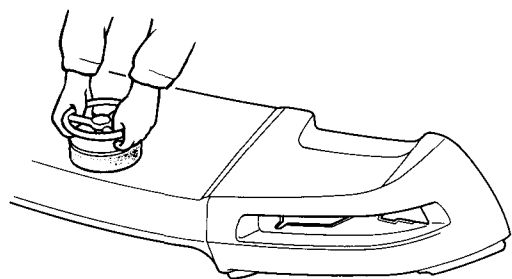


NOTE: To prevent off-color or fading, observe the following:

- Do not use air polishers. Use an electric polisher at 1,500 rpm.
- Use a sponge buff to polish the surface. Woolen buffs may cause the surface to become heated and scratches may result.
- Use very fine compound which is soluble in water.
- Polish until sanding marks disappear.
- Polish again with very fine compound.

NOTE:

- Do not use excessive force to hold the polisher against the surface.
- Do not overheat the surface.



- Apply wax (hard).

