Front and Rear Bumpers

Mass Production Coating Table (Reference)

Paint name	Type	Make	Main Component	Hardener	Solvent (Thinner)	Mixing Ratio			Application
						A	B	C	
Resin Primer	Polyester Urethane	N.B.C	RB-245	R-230 (Special)	T-868 (Special)	100	3	150	Baked: 176°F (80°C) ×30 min.
Intermediate coat (Color sealer)	Acrylic polyester	↑	Soflex KP−30	KP−30 (Special)	KP−30 (Special)	100	19.4	19	↑
Top coat Metallic enamel	Urethane	↑	Soflex WT−330 X−2	−	−	100	−	−	Spraying enamel base ⇩ Baked: 176°F (80°C) ×10 min. ⇩ Spraying top coat clear ⇩ Baked: 248°F (120°C) ×30 min.
Top coat (Metallic) Top clear coat	↑	↑	Soflex 500HX−2	500HX−2 (Special)	500HX−2 (Special)	100	15	15	
Top coat Undercoat enamel	↑	↑	Soflex WT−300 X−2	−	−	100	−	−	
Top coat (Solid) Top clear coat	↑	↑	Soflex 500HX−2	500HX−2 (Special)	500HX−2 (Special)	100	15	15	

NOTE: Mixing ratio
A: Main component
B: Hardener
C: Thinner

For top coats to be applied to solid and metallic enamel base, use the same paints specified for the aluminum body (water soluble enamel) having the following properties:

- Ability to harden at high temperature 248°F (120°C)
- To be flexible enough at low temperature -77°F (-25°C) and free of harmful effects on resin base
- Resistance to abrasion or wear

Processes: