

4C 4B (4-Coat4-Bake) Paint

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. 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).