

# 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 manufacture'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 cause injury. 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 cause injury. 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.