

Soft Chipping Guard Primer Coat

General

The removal of paint and undercoating by stones chips immediately exposes metal to the atmosphere, causing it to oxidize. The thickness of this oxidation increases if the process continues unchecked. The soft chipping guard primer protects against damage due to the impact of such objects.

Sectional View of Paint Coats:

Top coat
Intermediate coat +
Chipping guard primer
Electrodeposition of primer
Base metal

- The soft chipping guard primer coat is applied over the E.D. (Electrostatically Deposited) primer. It is followed by guide coating and top coating.
- The soft chipping guard primer produces a smooth surface when dry. It should be sprayed so the thickness of the protective film is 20 microns.

Basic Rules for Repairing a Soft Chipping Guard Primer Coat:

- Soft chipping guard primer coat is then applied to the most susceptible area (see page 5-14).
- Spray the primer surface (2-part urethane primer surfacer) on the soft chipping guard primer coating areas when you replaced parts using soft chipping guard primer coat.

⚠ WARNING

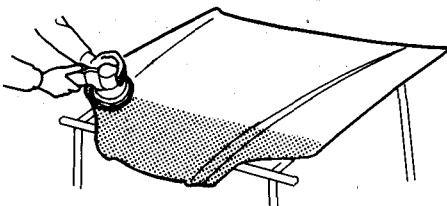
- Wear goggles or safety glasses to prevent eye injury.
- Ventilate when spraying undercoat.

1. Sanding the replacement part.

NOTE:

- Do not oversand the edges of corners of the part.
- Do not expose base metal.

Use the double action sander and #400 disc paper.



2. Air blowing/degreasing

Use alcohol, wax and grease remover.

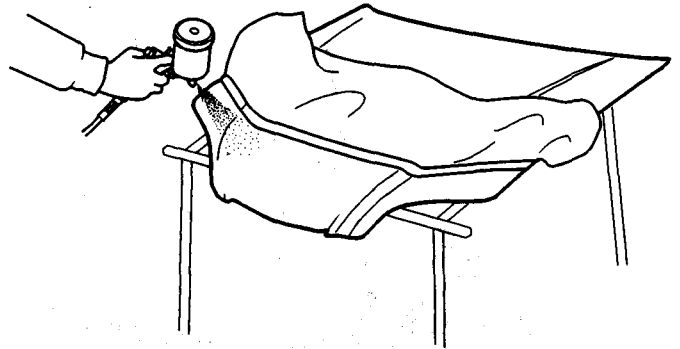
3. Masking

Use masking tape and paper.

4. Spraying primer surfacer

- Spray coat 4-5 coats get 20 microns of thickness, as one coat deposits 5-7 microns.
- Do not try to cover the surface with one heavy coat.
- Apply several thin coats.

- Use the 2-part urethane primer surfacer and spray gun.
- Mix the primer surface with the additive and solvent, and in the correct ratio.
- Follow the primer surface manufacturer's instructions.



5. Drying

After spraying primer surface, allow for 7-10 minutes drying time, then force dry it with infrared lamps or other industrial dryer.

6. Polishing

Check the primer surfacer has dried thoroughly, then sand the primer surfacer.

Use the double action sander and #400~#600 disc paper.

7. Intermediate coating and top coating

Refer to pages 8-10 of this body repair manual (section 6) for the painting procedure.