

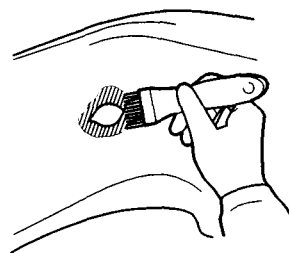
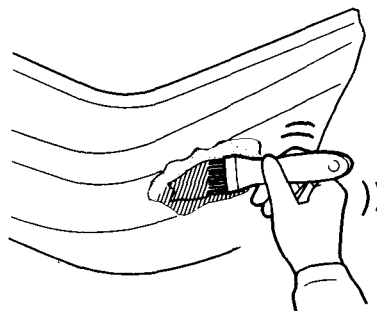
Undercoating

1. Spraying primer

Primer is used to fill cavities in the putty and primer surfacer.

- Spray primer on the exposed area.
- Spray the 2-3 coats of primer on 2-3 coats over the area you applied putty.
- Apply primer to the back of the bumper if the damage is a tear or hole.

- Bumper primer (Reference)
- Warm the primer if the ambient temperature is below 50°F (10°C).
- Follow the bumper primer manufacturer's instructions.
- Use the spray gun and brush.



Drying

NOTE: Take care not to let the heat lamp deform the bumper during the drying process.

Dry the bumper primer thoroughly with an infrared dryer or other suitable method.

Drying Time:

Air dry 68°F (20°C)	20 minutes
Force dry 140°F (60°C)	10 minutes

(cont'd)

Plastic Parts Paint

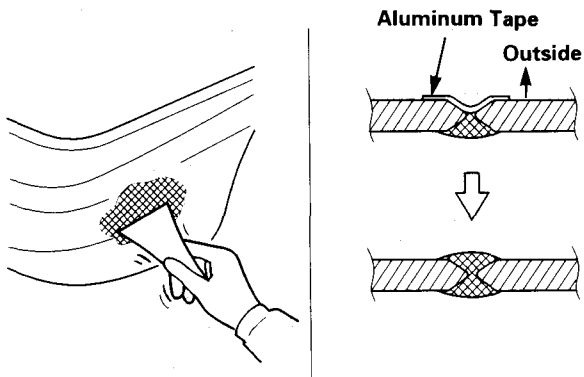
Under Coating (cont'd)

2. Filling /Sanding

Apply putty to repair any holes or deep gouges.

- Apply the putty on the damaged area in 2-3 steps.
- Glue aluminum tape on the outside of the bumper, and apply putty from the other side of the bumper.
- Remove the aluminum tape after the putty dries, apply putty from the outside, and fill the hole.

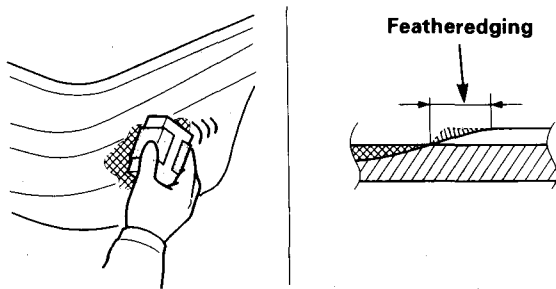
Use a special polyester putty (Reference) and a putty knife.



3. Sanding

Sand the surface evenly, particularly at the area where the PP material and putty meet.

Use a flexible block and #240-#400-#600 sandpaper.



4. Air blowing /degreasing

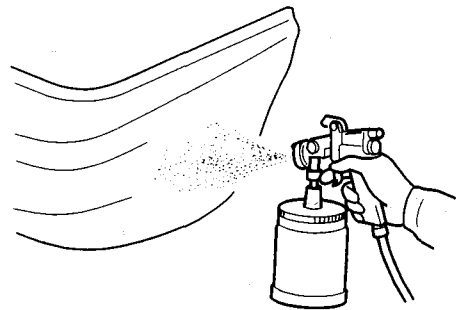
Use alcohol, a tack cloth, and wax and grease remover.

5. Spraying primer surfacer

NOTE: Spray the bumper primer (see page 6-13) on the area where the PP material was exposed and the around the putty.

- Spray the primer surface wider than the putty and painted surfaces of bumper primer.
- Spray 2-3 coats to get 20-30 microns of thickness.

- Use the 2-component type primer surfacer (gray) and a spray gun.
- Follow the materials manufacturer's instructions.



Drying

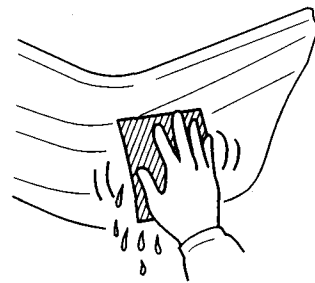
NOTE: Take care not to let the heat lamp deform the bumper during the drying process.

6. Sanding

After drying, wet sand the area of the intermediate coat.

Use the #600 sandpaper.

NOTE: Do not use #600 or less.



7. Air blowing /degreasing

Use alcohol, a tack cloth, and wax and grease remover.

Also clean and degrease the surfaces where the masking tape will be attached.