## 6. Coating Method for PP Bumper

## 1. PROCESS STEPS

2 Masking Say, etc.).  3 Degreasing, cleaning 4 Primer paint 5 Drying 6 Drying 6 Top coat paint (I) 7 Drying 8 Top coat paint (II) 8 Top coat paint (III) 9 Not required. 9 Mask specified part (black base) with masking tape. Use masking tape for PP (e.g., Nichiban 533, etc.).  Clean all parts to be painted, with white gasoline, normal alcohol, etc. to remove dirt, oil, fat, etc.  Clean all parts to be painted with white gasoline, normal alcohol, etc. to remove dirt, oil, fat, etc.  Dry at normal temperature [10 to 15 min. at 20°C (68°F)].  In half-dried condition, PP primer paint is dissolved by solvent, e.g. thinner, etc.  Therefore, if dust or dirt must be removed, use ordinary alcohol, etc.  Solid color  Use section (block) paint for top coat.  Paint in use (for each color):  Metallic color  Use section (block) paint for top coat.  Paint in use (for each color):  Metallic color  Main agent vs. hardener = 10:1  Viscosity: 10 — 13 sec/20°C (68°F)  Film thickness: 15 — 20µ  Spraying pressure: 245 — 343 kPa  (2.5 — 3.5 kg/cm², 36 — 50 psi)  Dry at normal temperature [10 min. or mon 20°C (68°F)].  In half-dried condition, avoid dust, dirt.  Apply a clear coat to parts with top coat parts with top coat parts with top coat parts in use:  Metallic paint hardener PB  Thinner T-301  Mixing ratio:  Main agent vs. hardener = 6:1  Viscosity: 10 — 13 sec/20°C (68°F)  Film thickness: 25 — 30µ  Spraying pressure: 245 — 343 kPa  (2.5 — 3.5 kg/cm², 36 — 50 psi)  Dry at normal temperature [10 min. or mon 20°C (18°F).  Viscosity: 14 — 16 sec/20°C (68°F)  Film thickness: 25 — 30µ  Spraying pressure: 245 — 343 kPa  (2.5 — 3.5 kg/cm², 36 — 50 psi)	Process No.	Process name	Job contents		
2 Masking Sas, etc.).  3 Degreasing, cleaning 4 Primer paint 5 Drying 5 Drying 6 Top coat paint (I) 7 Drying 8 Top coat paint (II) 8 Top coat paint (II) 8 Top coat paint (III) 9 Drying 7 Drying 8 Top coat paint (III) 8 Top coat paint (III) 8 Top coat paint (III) 8 Top coat paint (IIII) 8 Top coat paint (IIII) 8 Top coat paint (IIIIIIIIIIIIIIIIIIIIIIIIIIIIIIIIIIII	1	Bumper mounting	paint work table conforming to inner shape of		
Primer paint   First, apply one coat of primer to all parts to be painted, using air gun. Use primer (clear).	2	Masking	Mask specified part (black base) with masking tape. Use masking tape for PP (e.g., Nichiban No.		
Drying Dry at normal temperature [10 to 15 min. at 20°C (68°F)]. In half-dried condition, PP primer paint is dissolved by solvent, e.g. thinner, etc. Therefore, if dust or dirt must be removed, use ordinary alcohol, etc.    Solid color	3	l	Clean all parts to be painted with white gasoline, normal alcohol, etc. to remove dirt, oil, fat, etc.		
In half-dried condition, PP primer paint is dissolved by solvent, e.g. thinner, etc. Therefore, if dust or dirt must be removed, use ordinary alcohol, etc.    Solid color	4	Primer paint	First, apply one coat of primer to all parts to be painted, using air gun. Use primer (clear).		
Use section (block) paint for top coat.  Paint in use (for each color): Solid paint Hardener PB Thinner T-301 Mixing ratio: Main agent vs. hardener = 4:1 Viscosity: 10 — 13 sec/20°C (68°F) Film thickness: 35 — 45µ Spraying pressure: 245 — 343 kPa (2.5 — 3.5 kg/cm², 36 — 50 psi)  Top coat paint (II)  Not required.  Use section (block) paint for top coat. Paint in use (for each color): Metallic paint Hardener PB Thinner T-306 Mixing ratio: Main agent vs. hardener = 10:1 Viscosity: 10 — 13 sec/20°C (68°F) Film thickness: 35 — 45µ Spraying pressure: 245 — 343 kPa (2.5 — 3.5 kg/cm², 36 — 50 psi)  Prying  Not required.  Dry at normal temperature [10 min. or mor 20°C (68°F)]. In half-dried condition, avoid dust, dirt.  Apply a clear coat to parts with top coat p three times, at 5 — 7 minutes intervals. Paint in use: Metallic paint Hardener PB Thinner T-306 Mixing ratio: Apply a clear coat to parts with top coat p three times, at 5 — 7 minutes intervals. Paint in use: Metallic paint Hardener PB Thinner T-306 Mixing ratio: Apply a clear coat to parts with top coat p three times, at 5 — 7 minutes intervals. Paint in use: Metallic paint Hardener PB Thinner T-301 Mixing ratio: Clear vs. hardener = 6:1 Viscosity: 14 — 16 sec/20°C (68°F) Film thickness: 25 — 30µ Spraying pressure: 245 — 343 kPa (2.5 — 3.5 kg/cm², 36 — 50 psi)  Prying  Drying  O°C (140°F), 60 min. or 80°C (176°F), 30 min. If higher than 80°C (176°F), PP may be deformed. Keep maximum temperature of 80°C (176°F)	5	Drying	In half-dried condition, PP primer paint is dissolved by solvent, e.g. thinner, etc.		
Paint in use (for each color): Solid paint Hardener PB Thinner T-301 Mixing ratio: Main agent vs. hardener = 4:1 Viscosity: 10 — 13 sec/20°C (68°F) Film thickness: 35 — 45µ Spraying pressure: 245 — 343 kPa (2.5 — 3.5 kg/cm², 36 — 50 psi)  7 Drying  Not required.  Not required.  Paint in use (for each color): Metallic paint Hardener PB Thinner T-306 Mixing ratio: Main agent vs. hardener = 10:1 Viscosity: 10 — 13 sec/20°C (68°F) Film thickness: 35 — 45µ Spraying pressure: 245 — 343 kPa (2.5 — 3.5 kg/cm², 36 — 50 psi)  Dry at normal temperature [10 min. or mo 20°C (68°F)]. In half-dried condition, avoid dust, dirt.  Apply a clear coat to parts with top coat p three times, at 5 — 7 minutes intervals. Paint in use: Metallic paint Hardener PB Thinner T-301 Mixing ratio: Main agent vs. hardener = 10:1 Viscosity: 10 — 13 sec/20°C (68°F) Film thickness: 15 — 20µ Spraying pressure: 245 — 343 kPa (2.5 — 3.5 kg/cm², 36 — 50 psi)  Not required.  Keep maximum temperature of 80°C (176°F), PP may be deformed. Keep maximum temperature of 80°C (176°F)			Solid color	Metallic color	
7 Drying Not required.  20°C (68°F)]. In half-dried condition, avoid dust, dirt.  Apply a clear coat to parts with top coat p three times, at 5 — 7 minutes intervals.  • Paint in use: Metallic paint Hardener PB Thinner T-301 • Mixing ratio: Clear vs. hardener = 6:1 • Viscosity: 14 — 16 sec/20°C (68°F) • Film thickness: 25 — 30μ • Spraying pressure: 245 — 343 kPa (2.5 — 3.5 kg/cm², 36 — 50 psi)  9 Drying  60°C (140°F), 60 min. or 80°C (176°F), 30 min. If higher than 80°C (176°F), PP may be deformed. Keep maximum temperature of 80°C (176°F)	6	Top coat paint (I)	<ul> <li>Paint in use (for each color): Solid paint Hardener PB Thinner T-301</li> <li>Mixing ratio: Main agent vs. hardener = 4:1</li> <li>Viscosity: 10 — 13 sec/20°C (68°F)</li> <li>Film thickness: 35 — 45µ</li> <li>Spraying pressure: 245 — 343 kPa</li> </ul>	<ul> <li>Paint in use (for each color): Metallic paint Hardener PB Thinner T-306</li> <li>Mixing ratio: Main agent vs. hardener = 10:1</li> <li>Viscosity: 10 — 13 sec/20°C (68°F)</li> <li>Film thickness: 15 — 20µ</li> <li>Spraying pressure: 245 — 343 kPa</li> </ul>	
three times, at 5 — 7 minutes intervals.  Paint in use: Metallic paint Hardener PB Thinner T-301  Mixing ratio: Clear vs. hardener = 6:1 Viscosity: 14 — 16 sec/20°C (68°F) Film thickness: 25 — 30µ Spraying pressure: 245 — 343 kPa (2.5 — 3.5 kg/cm², 36 — 50 psi)  Drying  Drying  otherwise times, at 5 — 7 minutes intervals.  Paint in use: Metallic paint Hardener PB Thinner T-301  Not required.  film thickness: 25 — 30µ Spraying pressure: 245 — 343 kPa (2.5 — 3.5 kg/cm², 36 — 50 psi)  film thigher than 80°C (176°F), 9P may be deformed. Keep maximum temperature of 80°C (176°F).	7	Drying	Not required.		
If higher than 80°C (176°F), PP may be deformed. Keep maximum temperature of 80°C (176°C)	8	Top coat paint (II)	Not required.	<ul> <li>Paint in use: Metallic paint Hardener PB Thinner T-301</li> <li>Mixing ratio: Clear vs. hardener = 6:1</li> <li>Viscosity: 14 — 16 sec/20°C (68°F)</li> <li>Film thickness: 25 — 30µ</li> <li>Spraying pressure: 245 — 343 kPa</li> </ul>	
10 Inspection Paint check	9	Drying		60°C (140°F), 60 min. or 80°C (176°F), 30 min.  If higher than 80°C (176°F), PP may be deformed. Keep maximum temperature of 80°C (176°F).	
	10	Inspection	Paint check		
11 Masking removal Remove masking in process No. 2.	11	Masking removal	Remove masking in process No. 2.		