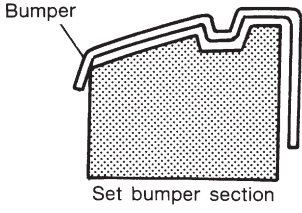


## 6. Coating Method for PP Bumper

## 1. PROCESS STEPS

Process No.	Process name	Job contents	
1	Bumper mounting	Set bumper on paint work table if required. Use paint work table conforming to inner shape of bumper when possible.	 <p style="text-align: right;">G5M0164</p>
2	Masking	Mask specified part (black base) with masking tape. Use masking tape for PP (e.g., Nichiban No. 533, etc.).	
3	Degreasing, cleaning	Clean all parts to be painted with white gasoline, normal alcohol, etc. to remove dirt, oil, fat, etc.	
4	Primer paint	First, apply one coat of primer to all parts to be painted, using air gun. Use primer (clear).	
5	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.	
6	Top coat paint (I)	Solid color	Metallic color
		Use section (block) paint for top coat. <ul style="list-style-type: none"> <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 (2.5 — 3.5 kg/cm<sup>2</sup>, 36 — 50 psi)</li> </ul>	Use section (block) paint for top coat. <ul style="list-style-type: none"> <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 (2.5 — 3.5 kg/cm<sup>2</sup>, 36 — 50 psi)</li> </ul>
7	Drying	Not required.	Dry at normal temperature [10 min. or more at 20°C (68°F)]. In half-dried condition, avoid dust, dirt.
8	Top coat paint (II)	Not required.	Apply a clear coat to parts with top coat paint (I), three times, at 5 — 7 minutes intervals. <ul style="list-style-type: none"> <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 (2.5 — 3.5 kg/cm<sup>2</sup>, 36 — 50 psi)</li> </ul>
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.	