

LOWER BODY SIDE STONE PROTECTION VINYL SERVICE (Continued)

2. Perform necessary repairs to correct sheet metal damage.

Abrasion Resistant Coating D9AZ-19515-A (ESB-M4G221-A) or equivalent is available in 0.947L (1 quart) cans. Approximately 1.89L (2 quarts) is required for an initial installation on a vehicle similar to a factory-applied system. The specified dry film thickness of 15 to 20 mils (0.015 to 0.020 inch) requires at least three, or possibly four, applications of coating material, with flash-off time allowed between coats. As with painting, spray coat the complete lower panel.

As the adherence of this coating to properly prepared sheet metal is excellent, the necessity of prime painting the sheet metal prior to protective coating is eliminated, saving both time and money.

NOTE: Adhesion will be adversely affected unless the sheet metal area to be covered (either repaired or new) is prepared in accordance with the following procedure.

Coating Preparation

Masking Vehicle

Suitable covers should be installed over the wheels. Mask off all upper exterior body sheet metal. Remove wheel opening stone shields and mask mouldings.

NOTE: If the vehicle has lower body side mouldings 305-355mm (12-14 inches) above the "turn under" of the rocker panel, the moulding can serve as the upper margin of the area to be coated. If the vehicle does not have suitable mouldings, a sculpture or break line in the sheet metal can be used. However, the method used in masking off the upper coating margin line will depend on the presence or absence of mouldings in this area.

Masking tape should be positioned so that the moulding lower side is also covered. Do not cover the sheet metal immediately below the moulding.

It is not necessary to mask off body door openings in the coating area as they will be uniformly coated where the door margins allow the coating to enter. However, these door opening areas should be cleaned to ensure coating adherence.

Sheet Metal

Serviced Sheet Metal

1. Scuff sand (No. 180-grit paper) to remove all of the glossy surface appearance of dry painted areas to be coated.
2. Remove sanding dust using a lint-free tack cloth and compressed air.
3. Using a clean, lint-free cloth, solvent wipe area to be coated with Multi-Purpose Paint Precleaner VC-542-A or equivalent, and allow to flash-off.

New Sheet Metal

1. Scuff sand (No. 180-grit paper) any prime paint in area to be coated.

NOTE: Do not sand through the primer.

2. Remove sanding dust using a lint-free tack cloth and compressed air.
3. Using a clean, lint-free cloth, solvent wipe area to be coated with Multi-Purpose Paint Precleaner VC-542-A or equivalent, and allow to flash-off.

Initial Installation

Tools Required:

- Rotunda Dual Action Air Sander 107-01619

NOTE: Do not sand through primer.

1. The glossy surface of paint in coating area may be scuff sanded with a D/A sander such as Rotunda Dual Action Air Sander 107-01619 or equivalent. A 220/240-Grit Disc does a good, fast job.
2. Remove sanding dust using a lint-free tack cloth and compressed air.
3. Using a clean, lint-free cloth, solvent wipe area to be coated with Multi-Purpose Paint Precleaner VC-542-A or equivalent.

Application

Coating must be applied with commercial equipment (appropriate equipment listed in this Section) by an experienced automotive painter. Coating must be thoroughly agitated and used without thinning. Since the material is reasonably heavy bodied, a pressure cup equipped spray gun is recommended. Satisfactory coating appearance (minimal orange peel and sagging) will result with gun air pressures of approximately 207 kPa (30 psi) and cup pressures of approximately 103 kPa (15 psi).

Coating Spray Procedure

To protect the lower exposed painted fender, rocker, and quarter panel down flanges, the vehicle must be elevated high enough so that the painter can spray areas effectively. When an initial installation is made, a remote 1.89L (2 quart) capacity pressure cup makes a much more efficient tool, as the spray gun can be used closer to the floor. The spray gun, fluid hose and/or cup must be cleaned immediately after use. While lacquer thinner can be used when the suggested clean-up material is unavailable, Multi-Purpose Paint Precleaner, VC-542-A or equivalent, is quicker and much more efficient. With Rotunda Spray Gun 085-01626 or an equivalent set at 207 kPa (30 psi) and Rotunda Detached Pressure Cup 085-01617 or an equivalent set at 103 kPa (15 psi), follow this procedure:

1. Apply a wet, sag-free coat. Allow 3-5 minutes flash-off time.