

LOWER BODY SIDE STONE PROTECTION VINYL SERVICE (Continued)

2. Apply second wet, sag-free coat. Allow 3-5 minutes flash-off time.
3. Apply third wet, sag-free coat. Allow 3-5 minutes flash-off time.
4. Apply final wet, sag-free coat. Allow 3-5 minutes flash-off time and pull off Fine Line Tape, exposing raw upper edge of the coating.
5. Immediately clean spray equipment using Multi-Purpose Paint Precleaner VC-542-A or equivalent.
6. Allow at least two hours drying time at approximately 21°C (70°F).

Color Coat

As the complete coated area, as well as the upper raw edge, must be covered with color coat, mask off upper margin line with Fine Line Tape positioned 1.59mm (1/16-inch) above coating edge. Using appropriate repair paint and application procedures, including both prime and color coat, finish paint the protective coating.

NOTE: If damaged sheet metal extends above the protective coating area, normal prime/color paint procedures should be followed.

Materials Required

- Abrasion Resistant Coating D9AZ-19515-A (ESB-M4G221-A)
- Color Coat Paint System
- Silicone and Wax Remover
- Multi-Purpose Paint Precleaner (Spray Gun Clean-Up) VC-542-A

Suggested Equipment

- Rotunda Spray Gun 085-01626 (No. 63 Air Cap, No. SS Fluid Tip, No. 363 AN needle) or equivalent.
- Rotunda Detached Pressure Cup 085-01617, 0.946L (1 quart) (with Air Adjusting Gauge) or equivalent.
- Rotunda Dual Action Air Sander 107-01619 or equivalent.
- Rotunda Heat Gun 107-00300 or equivalent.
- No. 180-Grit Paper.
- Lint-Free Cloth.
- Tack Cloth.
- Regular Masking Tape.
- No. 80 Disc for Disc Sander.
- No. 220/240 Disc.

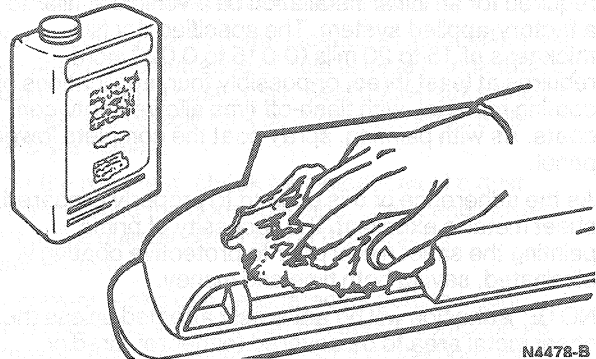
REPAIR

Tools Required:

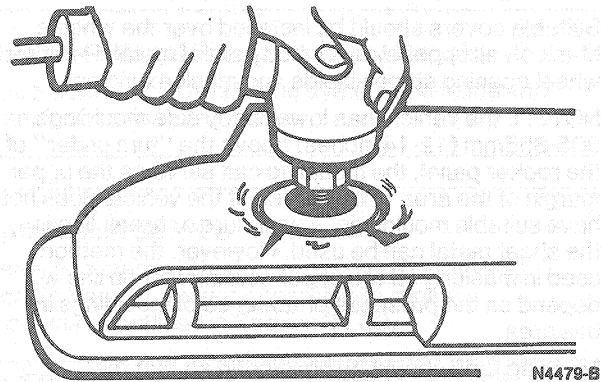
- Rotunda Dual Action Air Sander 107-01619

Procedure For Repairing Surface Damage

1. Clean the surface area with soap and water and wipe with silicone and wax remover to ensure clean surfaces.



2. Using a sander, such as Rotunda Dual Action Air Sander 107-01619 or equivalent, or sanding block with No. 36 Disc or Coarse Abrasive Paper, grind or abrade away sufficient substrate material 1-1-1/2 inches around damaged area to maximize adhesion of repair material.



3. Feather edge the paint around repair area with No. 180-grit paper disc.

