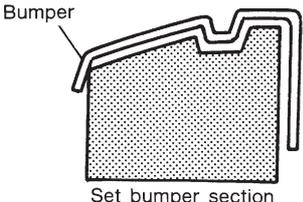


6. Coating Method for PP Bumper

A: 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>Bumper</p> <p>Set bumper section</p> <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"> ● 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) | Use section (block) paint for top coat. <ul style="list-style-type: none"> ● 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: 15 — 20μ ● Spraying pressure: 245 — 343 kPa (2.5 — 3.5 kg/cm², 36 — 50 psi) |
| 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"> ● 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). | |
| 10 | Inspection | Paint check | |
| 11 | Masking removal | Remove masking in process No. 2. | |