

Lacquer and Enamel Primer

Both air drying and oven drying synthetic enamels can be applied over lacquer and synthetic enamel primer paint.

A — Synthetic Enamel Primer

— Remove old paint using paint remover.

— Thoroughly clean paint rests, paint remover, and rust traces from the body surface. Use only solvents designed for metal preparation to remove grease and paint rests. Do not use gasoline or other fuels.

Spraying Paint

Prepare the car for spraying by draining all water from the seams and spaces and remove all dust using a tack cloth.

— Apply two coats of thinned synthetic enamel of the desired color using the type of paint best suited for the facilities and extent of spraying.

Do not apply too thick a coat of paint (max. 40 μ = .0016 in.).

Spraying Primer

— Using thinned primer, spray one uniform coat of 3 to 4 passes with the spray gun.
Air drying: 4 to 5 hours.
Oven drying: approx. 40 min. at 70 to 80° C (160 to 175° F).
(Allow primer to set 15 min. before placing in oven.)

— Smooth putty work using No. 240 wet sand paper.

— Spray two passes of spray filler over the entire body. Apply two to three coats as required.
Air drying: 6 to 8 hours.
Oven drying: approx. 60 min. at 70 to 80° C (160 to 175° F).
(Allow filler to set 15 min. before placing in oven.)

Note

Metallic colors require an additional coat. The spray gun must be held at a slightly greater distance from the surface being sprayed to produce a dryer spray, preventing floatation of the metallic particles.

Air drying: 12 hours.

Oven drying: 1 to 1½ hours (allow paint to set 15 min. before placing in oven).

Note

Complete hardening of the paint surface occurs after several days. It is therefore important that the above mentioned drying time be extended as much as practical. The car should then be polished with a protective material which will prevent damage through moisture or abrasive dust. This polish should be applied with clean pure cotton and then polished with a new piece of cotton.

Do not use a buffer or polishing rags.

Sanding

— Wet sand the entire surface after the filler dried using No. 320 and finishing with No. 400.

— Wash primer dust from the surface and dry until all moisture is evaporated.