Group Index, Alphabetical

Section	Section Number
Complete Painting or Touch-Up Painting	98.00

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Contents

Subject	Subject Number
General Information	050
Service Operations	
Preparing for Topcoating	100
Topcoating	110
Spot Repair	120
Specifications	400

General Information

Freightliner Corporation currently applies DuPont® single-stage Imron® 5000 or two-stage (base coat and clear coat) Imron 6000 high-solids polyurethane enamel on the vehicle cab at the factory.

Black Standard Urethane or Imron 5000 is used on the vehicle chassis. The chassis includes the frame, spoke spider, running gear, and any components attached to the frame. Aluminum fuel tanks are not painted.

To meet the federal air quality regulations imposed by the EPA and local jurisdictions, these products contain lower levels of volatile organic compounds (VOCs) than earlier types (916Y, Centari®, and Imron), and are formulated free of lead and chrome.

The procedures in this section are for use with DuPont products. Unless otherwise noted, all products are manufactured by E. I. du Pont de Nemours and Company, Inc. Obtain approval from a Freightliner Regional Office for use of topcoats produced by other manufacturers.

Color-Matching

The recommended aftermarket paints for color-matching factory-applied paint are as follows:

- Cab—use Imron 5000 or Imron 6000
- Chassis—use only Imron 5000

To ensure proper gloss, durability, and color-matching of the enamel, use only Imron 5000 on panels that were previously painted with Imron 5000, and use only Imron 6000 on panels painted with Imron 6000.

To determine the correct paint number for color-matching any original finish on a vehicle, refer to the paint specification on the vehicle specification decal. Refer to the vehicle driver's manual for the location of this decal.

NOTE: The high-solids Standard Urethane applied to the chassis at the factory is sold to original equipment manufacturers (OEMs) only, and is not available for aftermarket sale. Use Imron 5000, N0001 Black, for repainting.

General Guidelines

This section provides instructions for preparing large panels or the entire cab for topcoating with DuPont® products. For spot repairs or touch-ups, see **Subject 120**.

Before topcoating, the surface must be thoroughly cleaned and sanded. Any bare areas must also be conditioned and primed.

1. Preparation materials specified for one type of surface should not be used for any other type of surface.
2. Limit intermediate coatings, such as primers, to the brand and type specified by the finish-coat manufacturer.

⚠ CAUTION

Only experienced, qualified persons using proper equipment should attempt repainting or touch-up painting. Incorrect application of chemicals or paint could damage the surface or impair the finish.

Preparation for Prime Coat

Use the cleaners and conditioners specified in each step to prepare the surface for priming. See **Specifications, 400** for a summary of the products used in this procedure.

⚠ WARNING

Do not use solvent-based cleaners on large areas of plastic or fiberglass, such as the hood. Wiping down these large areas may cause a buildup of static electricity. The resulting spark could cause a flash fire, which could result in personal injury or property damage.

1. Wash and dry the entire vehicle with a mild detergent.

⚠ WARNING

Solvents are flammable. Keep them away from heat, sparks, and open flame. Keep the container closed. Use only with adequate ventilation. Avoid breathing the vapor, or headache, nausea, and impaired reaction time and coordination may result.

2. Wipe all surfaces to be painted with a clean cloth soaked with solvent or cleaner. Remove all traces of wax, polish, grease, and silicones.
   - Metal—use DuPont Prep-Sol 3919 S.
   - Plastic—use DuPont Plastic Prep 2319 S.
   - Fiberglass—use DuPont Prep-N-Solv.

   2.1 Work on small areas at a time, wetting the surface liberally.

   2.2 Quickly wipe the surface with a clean cloth before the solvent or cleaner has a chance to dry. Change cloths frequently.
3. Feather the edge of all repaired areas, chipped surfaces, and scratches.

   3.1 Cut down the edges of broken spots with no. 220 sandpaper.

   3.2 Feather the edges by hand, using a sanding block with no. 400 sandpaper.
4. Sand the entire area to be painted. Using a sanding block and no. 400 sandpaper, remove the gloss to improve adhesion of the primer.
5. Using a clean cloth soaked with cleaner, remove any sanding dust.
   - Metal or plastic—use DuPont 3939 S lacquer and enamel cleaner.
   - Fiberglass—use a solution of one part water and one part isopropyl alcohol (IPA).
6. Treat bare metal and rusted areas.
   - Steel—use DuPont 5717 S metal conditioner.
   - Aluminum—use DuPont 225 S aluminum cleaner.

   6.1 Mix one part of the cleaner with two parts of water in a plastic bucket.

   6.2 Apply the cleaner with a cloth or sponge. If corrosion is present, work the surface with a stiff plastic brush or 3M Scotch-Brite® pad. Do not use any pads containing iron.

Preparing for Topcoating

6.3 While the metal is still wet, wipe thoroughly with a clean, dry cloth. Allow the surface to dry before applying a conversion coating.

7. Apply a conversion coating to all bare metal.
   - Steel—use DuPont 5718 S metal conversion coating.
   - Zinc casings or galvanized surfaces (iron or steel)—use DuPont 5718 S metal conversion coating.
   - Aluminum—use DuPont 226 S aluminum conversion coating.

   7.1 Pour the conversion coating into a plastic container (do not dilute). Using a 3M Scotch-Brite or similar non-iron abrasive pad, apply the conversion coating to the metal surface. Work only as much area as can be coated and rinsed before the solution dries.

   7.2 Leave the coating on the surface for 2 to 5 minutes. Then, rinse off the solution with cold water, or mop with a sponge or cloth rinsed frequently in clean water.

   If the metal surface dries before rinsing, reapply the conversion coating, then repeat the previous substep.

   7.3 Wipe the surface dry with a clean cloth, or air dry.

8. With paper and tape, mask all areas that are not to be painted.

Prime Coat

Prime all bare and feathered areas before topcoating. The specified primers can be used on any surface.

1. Clean all cracks and surfaces with dry compressed air.
2. Using a tack cloth, wipe all surfaces to be painted.

⚠ WARNING

Wear a positive-pressure, supplied-air, vapor and particulate respirator, approved by NIOSH or MSHA (TC-19C) when mixing or spraying primer, and until the work area has been exhausted of all vapor and spray mist. Breathing paint fumes can cause serious personal injury.

3. Prime all bare metal and feathered areas with DuPont primer.
   - Steel and aluminum—use Corlar 824 S epoxy primer.
   - Fiberglass—use Corlar 825 S epoxy primer.

   3.1 Stir the primer thoroughly.

   3.2 Mix two parts Corlar epoxy primer with one part DuPont 826 S activator.

   3.3 Reduce three parts of this mixture with one part DuPont 3602 S lacquer thinner (viscosity reading is 18 to 22 seconds in a no. 2 Zahn cup). Stir thoroughly.

   3.4 Wait 1 to 2 hours from time of mixing before using. This provides time for complete chemical induction.

   3.5 Set the air pressure at the spray gun at 45 psi (310 kPa). For pressure feed systems, set the fluid delivery at 12 to 16 ounces (350 to 470 mL) per minute.

   3.6 Hold the spray gun about 10 to 12 inches (25 to 30 cm) from the surface.

   3.7 Spray one full wet coat to give a dry film thickness of 0.7 to 1.0 mil (18 to 25 μm).

   3.8 Clean the equipment immediately after use with DuPont 3602 S lacquer thinner.

   3.9 Air dry 2 hours or force dry 20 minutes.

4. Wet sand the primer with no. 400 grit or finer sandpaper. Feather the edge into the surrounding area.
5. Dry the surface. Using a clean cloth soaked with cleaner, remove any sanding dust.
   - Metal or plastic—use DuPont 3939 S lacquer and enamel cleaner.
   - Fiberglass—use solution of 1 part water and 1 part isopropyl alcohol (IPA).

NOTE: See **Subject 110** for topcoating instructions.

General Guidelines

This section provides instructions for applying a topcoat of DuPont® enamel to full panels or the entire cab. For spot repairs or touch-ups, see **Subject 120**.

⚠ CAUTION

Only experienced, qualified persons using proper equipment should attempt repainting or touch-up painting. Incorrect application of chemicals or paint could damage the surface or impair the finish.

Do not mix additives with the finish coats unless they are specified by the finish-coat manufacturer. See **Specifications, 400** for a summary of the products used in this procedure.

Before applying any topcoat:

1. Prepare the surface for topcoating. See **Subject 100** for instructions.
2. Clean all cracks and surfaces with dry compressed air.
3. Using a tack cloth, wipe all surfaces to be painted.

After topcoating, remove the masking as follows:

- After normal air drying—remove all masking when the surface is reasonably dry.
- After forced drying—remove the masking immediately after the finish has been baked.
- After two-toning—remove the masking used for the first coat as soon as it has set up, usually in about 35 to 40 minutes. Follow the same procedure for the second color.

Imron 5000 Topcoating

Imron 5000 is a single-stage, low VOC, high-solids polyurethane enamel. It provides a durable, high-gloss surface with good chemical resistance. It requires the addition of an activator.

⚠ WARNING

Wear a positive-pressure, supplied-air, vapor and particulate respirator approved by NIOSH or MSHA (TC-19C), while spraying Imron 5000, and until the work area has been exhausted of all vapor and spray mist. Breathing paint vapor or spray mist can cause personal injury.

MIXING

1. Stir the Imron 5000 enamel thoroughly.
2. Mix three parts Imron 5000 enamel with one part of DuPont 193 S or 194 S activator. No further reduction is necessary for application.

NOTE: The pot life of the mixture is about 2 to 4 hours at 70°F (21°C), unless an accelerator is added.

3. If faster curing time is desired, add DuPont 389 S fast-dry accelerator. Add up to 2 ounces (60 mL) to 1 gallon (3.8 L) of mixed material.
4. Mix thoroughly and strain.

NOTE: The viscosity of the mixture is about 9 to 20 seconds in a no. 3 Zahn cup, depending on the color. Adding reducer could affect the color match on some metallics.

APPLICATION

1. Set the air pressure at the spray gun to 60 to 65 psi (410 to 450 kPa). For pressure feed systems, set the fluid delivery at 12 to 16 ounces (350 to 470 mL) per minute.
2. Apply the topcoating.
   - 2.1 Hold the spray gun about 10 to 12 inches (25 to 30 cm) from the surface.
   - 2.2 Using a cross-coat technique, spray one medium-wet coat in a north-to-south direction
   - 2.3 Allow 5 to 10 minutes drying time between each application. Do not sand.
   - 2.4 Apply a second medium-wet coat in an east-to-west direction.
   - 2.5 A third medium-wet coat may be needed for good coverage of some colors.
3. To air dry, allow 2 to 4 hours with accelerator 389 S, and 6 to 8 hours without the accelerator.

   To force dry, wait 15 minutes following the application of the final coat, then dry for 30 minutes at 140 to 180°F (60 to 82°C).

4. To prevent tape marking, remove all masking tape and paper immediately after the final coat is applied. Avoid contacting the freshly painted surface with masking paper.
5. Clean the equipment immediately after use with DuPont 3602 S lacquer thinner or 8685 S reducer.

RECOATING OR DECORATING

Two-toning, striping, or lettering may be applied in 4 to 6 hours if DuPont 389 S accelerator is used. Wait 10 to 12 hours if no accelerator is used.

Decals may be applied in 12 to 16 hours if 389 S accelerator is used. Wait 24 hours if no accelerator is used.

For topcoats cured over 72 hours, scuff-sand with no. 400 grit sandpaper and wipe with a clean tack cloth before recoating, striping, lettering, or applying decals.

Imron 6000 Topcoating

Imron 6000 is a two-stage, high-solids polyurethane enamel. It provides good cover with one cross-coat of the base color followed by one coat of Imron 6000 clear coat. Both the base color and clear coat require the addition of an activator.

⚠ WARNING

Wear a positive-pressure, supplied-air, vapor and particulate respirator approved by NIOSH or MSHA (TC-19C), while spraying Imron 6000, and until the work area has been exhausted of all vapor and spray mist. Breathing paint vapor or spray mist can cause personal injury.

MIXING

1. Stir the Imron 6000 base color thoroughly.
2. Mix three parts Imron 6000 base color with one part DuPont 193 S or 194 S activator. No further reduction is necessary for application.

NOTE: The pot life of the mixture is about 2 to 4 hours at 70°F (21°C), unless an accelerator is added.

3. If faster curing time is desired, add DuPont 389 S fast-dry accelerator. Add up to 2 ounces (60 mL) to 1 gallon (3.8 L) of mixed material.
4. Mix thoroughly and strain.

NOTE: For solids, the viscosity of the mixture is about 20 seconds in a DuPont M-222 (M-50) cup; for metallics, it is about 18 seconds.

APPLICATION

1. Set the air pressure at the spray gun to 60 to 65 psi (410 to 450 kPa). For pressure feed systems, set the fluid delivery at 12 to 16 ounces (350 to 470 mL) per minute.
2. Apply the topcoating.
   - 2.1 Hold the spray gun about 10 to 12 inches (25 to 30 cm) from the surface.
   - 2.2 Apply one cross-coat of the Imron 6000 base color.
   - 2.3 Flash 10 minutes minimum. Do not sand.
   - 2.4 Mix three parts DuPont 3440 S or 3480 S clear with one part DuPont 193 S or 194 S activator.
   - 2.5 Apply one coat of the activated DuPont 3440 S or 3480 S clear.
3. To air dry, allow 2 to 4 hours if DuPont 389 S accelerator is used, and 6 to 8 hours if no accelerator is used.

   To force dry, wait 15 minutes following the application of the clear coat, then dry for 30 minutes at 140 to 180°F (60 to 82°C).
4. To prevent tape marking, remove all masking tape and paper immediately after the final coat is applied. Avoid contacting the freshly painted surface with masking paper.
5. Clean the equipment immediately after use with DuPont 3602 S lacquer thinner or 8685 S reducer.

RECOATING OR DECORATING

Two-toning, striping, and lettering may be applied in 4 to 6 hours if DuPont 389 S accelerator is used. Wait 10 to 12 hours if no accelerator is used.

Decals may be applied in 12 to 16 hours if 389 S accelerator is used. Wait 24 hours if no accelerator is used.

For topcoats cured over 72 hours, scuff-sand with no. 400 grit sandpaper and wipe with a clean tack cloth before recoating, striping, lettering, or applying decals.

General Guidelines

This section provides instructions for making spot repairs or touch-ups with DuPont® enamels. Buffing may correct minor imperfections; more serious repairs require surface preparation before a topcoating can be applied. For striping, lettering, or decal application after the repair is complete, see **Subject 110**.

1. Preparation materials specified for one type of surface should not be used for any other type of surface. See **Specifications, 400** for a summary of the materials used in this section.
2. Limit intermediate coatings, such as primers, to the brand and type specified by the finish-coat manufacturer.
3. Do not mix additives with the finish coats unless they are specified by the finish-coat manufacturer.

⚠ CAUTION

Only experienced, qualified persons using proper equipment should attempt repainting or touch-up painting. Incorrect application of chemicals or paint could damage the surface or impair the finish.

Buffing Minor Imperfections

1. Clean the area carefully with a mild detergent and rinse.
2. Remove imperfections using ultra-fine or micro-fine sandpaper (1500 or 2000 grit) and water. Rinse the area with clean water, then dry.
3. Buff the area.
   - 3.1 Use a clean foam pad at low speed (about 1600 rpm) with one of the following products:
     - DuPont 1500 S
     - Meguiar's No. 2
     - 3M Finesset Two 5928
   - 3.2 Using medium pressure, buff slowly in an overlapping pattern until the imperfection has been eliminated. Repeat as necessary.
   - 3.3 Rinse the area with clean water, then dry.
4. Polish the area.
   - 4.1 Apply one of the following products with a clean pad (3M Waffle Pad):
     - DuPont 3000 S
     - Meguiar's No. 9
     - 3M 5996
   - 4.2 Using medium pressure, work small areas using an even, overlapping pattern until the gloss is restored. As the polish dries and the gloss appears, ease the pressure on the polishing pad. Repeat as necessary.

Preparing for Topcoating

1. Wash the entire panel with mild detergent. Dry with a clean, lint-free cloth.

⚠ WARNING

Solvents are flammable. Keep them away from heat, sparks, and open flame. Keep the container closed. Use only with adequate ventilation. Avoid breathing the vapor, or headache, nausea, and impaired reaction time and coordination may result.

2. Clean the area to be repaired with DuPont 3939 S solvent and quickly wipe the surface with a clean, lint-free cloth before the solvent dries. Remove all traces of wax, polish, grease, and silicones.
3. Sand or grind all dents and scratches.
4. Wet sand and the area being repaired with no. 320 grit or finer sandpaper, or a 3M Scotch-Brite® or similar non-iron abrasive pad. Feather the edge.
5. Remove the sanding dust. Use the same solvent and wipe-on, wipe-off method used earlier to clean the area.
6. Mask all areas that will not be painted.
7. Clean all cracks and surfaces with dry compressed air.
8. Using a tack cloth, wipe all surfaces to be painted.

Spot Repair

⚠ WARNING

Wear a positive-pressure, supplied-air, vapor and particulate respirator, approved by NIOSH or MSHA (TC-19C) when mixing or spraying primer, and until the work area has been exhausted of all vapor and spray mist. Breathing paint fumes can cause serious personal injury.

9. Prime all bare metal and feathered areas with DuPont primer. See **Fig. 1.**
   - Steel and aluminum—use Corlar 824 S epoxy primer.
   - Fiberglass—use Corlar 825 S epoxy primer.

   9.1 Stir primer thoroughly.

   9.2 Mix two parts Corlar epoxy primer with one part DuPont 826 S activator.

   9.3 Reduce three parts of this mixture with one part DuPont 3602 S lacquer thinner (viscosity reading is 18 to 22 seconds in a no. 2 Zahn cup). Stir thoroughly.

   9.4 Wait 1 to 2 hours from time of mixing before using. This provides time for complete chemical induction.

   9.5 Set the air pressure at the spray gun to 45 psi (310 kPa). For pressure feed systems, set the fluid delivery at 12 to 16 ounces (350 to 470 mL) per minute.

   9.6 Hold the spray gun about 10 to 12 inches (25 to 30 cm) from the surface.

   9.7 Spray one wet coat to give a dry film thickness of 0.7 to 1.0 mil (18 to 25 μm).

   9.8 Clean the equipment immediately after use with DuPont 3602 S lacquer thinner.

   9.9 Air dry 2 to 4 hours or force dry 20 minutes.

10. Wet sand the primer with no. 400 grit or finer sandpaper. Feather the edge into the surrounding area.

11. If the original paint was Imron 6000, hand-rub the area around the spot repair with a medium grade compound to ensure a seamless finish.

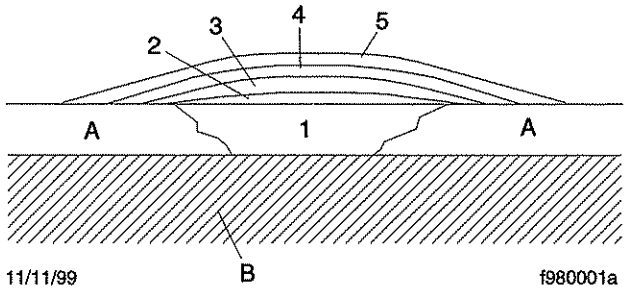
12. Remove the sanding dust. Use the same solvent and wipe-on, wipe-off method used earlier to clean the area.

13. Wipe the repair area with a tack cloth.

14. If the finish is old, apply one coat of DuPont 222 S adhesion promoter over the entire repair area.

    14.1 Set the air pressure to 35 psi (240 kPa) at the spray gun.

    14.2 Flash for 5 to 10 minutes at 70°F (21°C) before topcoating.



NOTE: Scale exaggerated for clarity. The number of layers depends on the specific application.

A. Existing Paint
B. Panel Material (substrate)
1. Primer
2. First Color Topcoat
3. Second Color Topcoat
4. Third Color Topcoat
5. Clear Coat

Fig. 1, Spot Repair Cross-Section

Topcoating a Spot Repair

⚠ WARNING

Wear a positive-pressure, supplied-air, vapor and particulate respirator approved by NIOSH or MSHA (TC-19C), while spraying topcoating, and until the work area has been exhausted of all vapor and spray mist. Breathing topcoating vapor or spray mist can cause personal injury.

Imron 5000 Topcoating

1. Mix the Imron 5000 polyurethane enamel.

   1.1 Stir the Imron 5000 enamel thoroughly.

   1.2 Mix three parts Imron 5000 base color with one part DuPont 193 S or 194 S

activator. No further reduction is necessary for application.

1.3 Mix thoroughly and strain.

2. Set the air pressure at the spray gun at 60 to 65 psi (410 to 450 kPa). For pressure feed systems, set the fluid delivery at 12 to 16 ounces (350 to 470 mL) per minute.

3. For metallic topcoats only, apply one coat of DuPont 500 S urethane clear.

   3.1 Mix eight parts of 500 S urethane with one part 193 activator.

   3.2 Reduce the activated 500 S urethane mixture 50 percent with 8685 S reducer.

   3.3 Apply a medium-wet coat of the reduced 500 S urethane over the entire repair area, and well beyond where the color will be applied.

   3.4 Flash 3 minutes before applying the Imron 5000 topcoat.

4. Apply the solid color or metallic topcoating.

   4.1 Hold the spray gun about 10 to 12 inches (25 to 30 cm) from the surface.

   4.2 Spray one medium-wet coat over the primed area.

   4.3 Flash 5 to 10 minutes.

   4.4 Apply a second medium-wet coat. Extend the spray area slightly to taper the edge and avoid a visible ring.

   4.5 A third medium-wet coat may be needed for good coverage of some colors. Allow each coat to flash before applying the next coat.

NOTE: A mist coat of five parts of color to three parts of 8022 S is recommended when applying metallics. Hold the gun about 18 inches (45 cm) from the surface.

5. Blend the repair area into the OEM finish.

   5.1 Lower the air pressure to 15 to 20 psi (100 to 140 kPa) at the spray gun.

   5.2 Empty the spray cup and refill it with DuPont 8022 S reducer or a blend of 8022 S and 8093 S.

   5.3 Carefully blend the edge of the repair with even coats to melt in the overspray.

   5.4 Spray one or two medium coats of the reducer over the entire area.

   5.5 If a haze appears around the edge after the reducer has dried, lightly rub the edge with DuPont 1500 S one-step polish.

6. To air dry, allow 2 to 4 hours if DuPont 389 S accelerator is used, and 6 to 8 hours if no accelerator is used.

   To force dry, wait 15 minutes following the application of the final coat, then dry for 30 minutes at 140 to 180°F (60 to 82°C).

7. To prevent tape marking, remove all masking tape and paper immediately after the final coat is applied. Avoid contacting the freshly painted surface with masking paper.

8. Clean the equipment immediately after use with DuPont 3602 S lacquer thinner or 8685 S reducer.

Imron 6000 Topcoating

1. Mix the Imron 6000 polyurethane enamel.

   1.1 Stir the Imron 6000 base color thoroughly.

   1.2 Mix three parts Imron 6000 base color with one part DuPont 193 S or 194 S activator. No further reduction is necessary for application.

   1.3 Mix thoroughly and strain.

2. Set the air pressure at the spray gun at 60 to 65 psi (410 to 450 kPa). For pressure feed systems, set the fluid delivery at 12 to 16 ounces (350 to 470 mL) per minute.

3. Apply the topcoating.

   3.1 Hold the spray gun about 10 to 12 inches (25 to 30 cm) from the surface.

   3.2 Apply one cross-coat of the Imron 6000 base color over the primed area. No flash time is required before applying a clear coat.

   3.3 Flash 10 minutes minimum. Do not sand.

Spot Repair

3.4 Mix three parts DuPont 3440 S or 3480 S clear with one part DuPont 193 S or 194 S activator.

NOTE: For best results, apply the clear coat over the entire panel. If a blend of the repair area is attempted, apply the clear coat only over the repair area, overspraying the edge slightly.

3.5 Apply one coat of the activated DuPont 3440 S or 3480 S clear.

4. Blend the 3440 S or 3480 S clear into the surrounding topcoat.

   4.1 Set the air pressure to 25 psi (170 kPa) at the spray gun.

   4.2 Apply one coat of 3401 S blending clear over the repair area only to the overspray edge.

   4.3 Flash 2 minutes. Repeat if necessary.

5. To air dry, allow 2 to 4 hours if DuPont 389 S accelerator is used, and 6 to 8 hours if no accelerator is used.

   To force dry, wait 15 minutes following the application of the final coat, then dry for 30 minutes at 140 to 180°F (60 to 82°C).

6. To prevent tape marking, remove all masking tape and paper immediately after the final coat is applied. Avoid contacting the freshly painted surface with masking paper.

7. Clean the equipment immediately after use with DuPont 3602 S lacquer thinner or 8685 S reducer.

Equipment Application Parameters

Equipment Application Parameters		
Parameter	**English Units**	**Metric Units**
Atomizing Air		
Primer	45 psi	310 kPa
Enamel	60–65 psi	410–450 kPa
Fluid Delivery	12–16 oz/min	350–470 mL/min
Booth Temperature	75°F	23°C
Spray Gun Distance	10–12 in	25–30 cm

DuPont Surface Preparation Materials

Step	Surface Preparation Materials			
	Steel	**Aluminum**	**Plastic**	**Fiberglass**
Wash and dry	Mild detergent (such as diswashing detergent)			
Wipe with cleaner	Prep-Sol 3919 S	Prep-Sol 3919 S	Plastic Prep 2319 S	Prep-N-Solv
Sand and feather	220 grit, then 400 grit			320 grit
Remove sanding dust	3939 S lacquer and enamel cleaner			Mix: - 1 part water - 1 part isopropyl alcohol
Treat bare metal	5717 S metal conditioner	225 S aluminum cleaner	—	—
Apply conversion coating to bare metal	5718 S metal conversion coating	226 S aluminum conversion coating	—	—
Apply sealer primer	Mix: - 2 parts Corlar 824 S primer with 1 part DuPont 826 S activator - reduce 3 parts of mixture with 1 part DuPont 3602 S lacquer thinner		Mix: - 2 parts Corlar 825 S primer with 1 part DuPont 826 S activator - reduce 3 parts of mixture with 1 part DuPont 3602 S lacquer thinner	

DuPont Topcoating Materials

Step	Topcoating Materials	
	Imron 6000	**Imron 5000**
Mix enamel	Mix: - 3 parts Imron 6000 - 1 part 193 S or 194 S activator	Mix: - 3 parts Imron 5000 - 1 part 193 S or 194 S activator
Add accelerator (optional)	389 S accelerator (up to 2 oz/gal of activated enamel)	
Mix clear coat	Mix: - 3 parts 3440 S or 3480 S clear - 1 part 193 S or 194 S activator	—

Specifications

Step	Topcoating Materials	
	Imron 6000	Imron 5000
Pressure at gun	60–65 psi (414–448 kPa)	60 psi (414 kPa)
Equipment cleanup	3939 S lacquer and enamel cleaner or 8685 S reducer	

DuPont Spot Repair Materials

Step	Spot Repair Materials	
	Imron 6000	Imron 5000
Cleaning	3939 S lacquer and enamel cleaner	
Sanding	320 grit or finer	
Sealer primer	Mix: - 2 parts Corlar 824 S primer with 1 part DuPont 826 S activator - reduce 3 parts of mixture with 1 part DuPont 3602 S lacquer thinner	
Compound	Medium grade compound	—
Adhesion promoter	222 S adhesion promoter	
Topcoat	1 coat Imron 6000: - 3 parts base color - 1 part 193 S or 194 S activator	2 coats Imron 5000: - 3 parts enamel - 1 part 193 S or 194 S activator
Topcoat viscosity	Solids: 20 sec; Metallics: 18 sec (#2 Zahn cup)	9–20 sec (#3 Zahn cup)
Clear coat	Mix: - 3 parts 3440 S or 3480 S clear - 1 part 193 S or 194 S activator	—
Accelerator (optional)	389 S accelerator	
Blending clear	1 coat 3401 S blending clear	
Equipment cleanup	3939 S lacquer and enamel cleaner or 8685 S reducer	