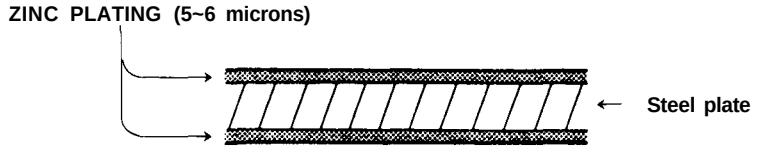
General Information

Zinc-plated Steel Plate Repair

The zinc-plated steel plate used in some panels of the Acura 2.5TL/3.2TL requires different repair techniques than ordinary steel plate. Refer to "Body Construction" (see page 4-2) for the location of the zinc-plated panels.



1. Before spot welding the zinc-plated steel plate, remove the paint from both sides of the flange to be welded. Apply sealer to the flange after welding.

   ⚠WARNING To prevent eye injury, wear goggles or safety glasses whenever sanding, cutting or grinding.
   NOTE: Seal the sanded surfaces thoroughly to prevent rust.

2. The electric continuity properties of zinc-plated steel plate is different from ordinary steel plate. When spot welding, increase the current by 10-20%, or increase the resistance welding time.
   Increase the number of weld spots by 10-20% also.

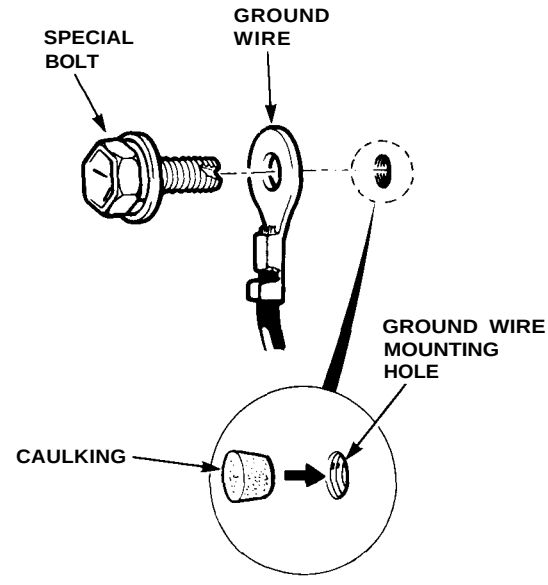
   NOTE: The MIG welding procedures for zinc-plated steel plate are the same as for ordinary steel plate.

   ⚠WARNING To prevent eye injury and burns when welding, wear an approved welding helmet, gloves and safety shoes.

3. Before applying putty or body filler to the zinc-plated steel plate, sand the zinc plating thoroughly to promote adhesion and prevent blistering.

   NOTE:
   - Use only epoxy-based putties and fillers on zinc-plated steel plate.
   - Follow the manufacturer's specification.

4. When performing paint work, apply caulking to the ground wire mounting position to mask the body.



Avoid puttying as much as possible when repairing a new car. Use alternative methods as much as possible.

⚠ WARNING

- **Most paints contain substances that are harmful if inhaled or swallowed. Read the paint label before opening the container. Spray paint only in a well ventilated area.**
- **Cover spilled paint with sand, or wipe it up at once.**
- **Wear an approved respirator, gloves, eye protection and appropriate clothing when painting. Avoid contact with skin.**
- **If paint gets in your mouth or on your skin, rinse or wash thoroughly with water. If paint gets in your eyes, flush with water and get prompt medical attention.**
- **Paint is flammable. Store it in a safe place, and keep it away from sparks, flames or cigarettes.**

Operation	Tools/Materials	Procedure	Remarks
1. Prep the repair area.	Double-action sander, #80 sandpaper.	Sand the area with a double-action sander and #80 sandpaper. Clean with wax and grease remover.	
2. Apply putty. NOTE: Putty can be applied after priming as described in step 4.	Epoxy-based putty. ● Mix the putty and hardener according to the manufacturer's directions. Polyester resin putty. Body filler.	Apply in several thin coats if necessary. Try to avoid leaving pinholes in the putty. ● Follow the manufacturer's recommendations for preparation.	
3. Sand and clean the puttied area.	Double-action sander, orbital sander, hand sanding file, #80, #120, # 240 sandpaper, wax and grease remover, shop towels.	Rough-sand the area with a double-action sander and #80 sandpaper, then sand with #120 sandpaper. Featheredge with #240 sandpaper. Clean with wax and grease remover.	
4. Coat with primer. NOTE: Apply to bare sheet metal and puttied area.	Epoxy-based primer and hardener, epoxy thinner. ● Mix and thin the primer according to the manufacturer's directions.	Apply 2–4 coats, allowing sufficient flash time between coats. Force dry at 140–158°F (60–70°C) for at least 30 minutes.	Spray to a thickness of 30–35 microns
5. Sand and clean the whole area.	Double-action sander, #300, #400 sandpaper, wax and grease remover, shop towels.	Sand the repair area by hand with #300, # 400 sandpaper. Blow off with compressed air. Clean with wax and grease remover.	
6. Apply intermediate coat to the whole area to be repainted.	Polyester/urethane resin primer/surfacer or top-coat enamel. ● Mix and thin the primer according to the manufacturer's directions.	Apply 2–4 coats, allowing sufficient flash time between coats. Force dry at 140–158°F (60–70°C) for at least 30 minutes.	Spray to a thickness of 30–35 microns
7. Sand and clean the whole area to be repainted.	Hand sanding file, double-action sander, #400, #600 sandpaper, wax and grease remover, shop towels.	Sand the repair area by hand with #400 sandpaper until it's level. Sand the whole area to repainted with #400–600 sandpaper. Clean with wax and grease remover.	
8. Top-coat the whole area to repainted.	Acrylic urethane resin top coat paint, hardener, and thinner. ● Mix and thin the paint according to the manufacturer's directions.	Apply 2–4 coats allowing sufficient flash time between coats. Force dry at 140–158°F (60–70°C) for at least 30 minutes.	Spray to a thickness of 40–50 microns