

# Soft Chipping Guard Primer Coat

## Coating Procedures

NOTE: This section covers the application of the soft chipping primer to the replacement part.

### 1. Sanding the replacement part

**⚠ WARNING** Wear goggles or safety glasses to prevent eye injury.

Sand the area to be painted with #240-#400 sandpaper.

NOTE:

- Do not oversand the edges or corners of the part.
- Do not expose bare metal.

### 2. Air blowing/degreasing

**⚠ WARNING**

- Do not use high air pressure; use only an approved, 210 kPa (2.1 kgf/cm<sup>2</sup>, 30 psi) air nozzle.
- Wear goggles or safety glasses to prevent eye injury.
- Paint thinner is flammable. Store it in a safe place, and keep it away from sparks, flames or cigarettes.

Clean the surface with compressed air and wax and grease remover.

### 3. Masking

- Place masking tape or paper around the surface to be painted.
- Cover as wide an area as possible with tape or paper to keep primer from spreading.

### 4. Spraying chipping guard primer

- Stir the primer thoroughly.
- Put the primer in a beaker and weigh the needed amount of primer to be used.
- Mix the hardener into the primer, following the manufacturer's instructions.

NOTE: Measure the primer and hardener so they are in correct ratio.

Item	Primer	:	Hardener
* High Primer Surfacer 2C	10	:	1
* Auto Primer Surfacer Mighty	5	:	1

- Add the specified thinner to the mixture of hardener and primer to attain the proper viscosity for spraying.  
2C 68°F (20°C) 18 sec ± 1
- These substances are not available in the U.S.A. Honda recommends using DuPont's 123 Vinyl Coating, or Sherwin-Williams' Vinyl Gravel Guard. Follow the manufacturer's instructions for application.
- Once mixed with the hardener and thinner, the primer must be used within the times shown below.

Temp.		41°F (5°C)	50°F (10°C)	68°F (20°C)
Time	High Primer Surfacer 2C	30H	24H	8H
	Auto Primer Surfacer Mighty	4H	3.5H	3H

**⚠ 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.

- Fill the gun's paint cup with the primer. Use a strainer when pouring the primer into the cup.
- Primer should never be applied to a dirty or greasy surface. Before spraying, blow dust and dirt off the surface and clean with wax and grease remover.

(Method of spraying)

- Do not try to cover the surface with one heavy coat. Apply several thin coats.

NOTE:

- Spray coat 4-5 coats to get 20 microns of thickness, as one coat deposits 5-7 microns.
- Spray the primer at 250-300 kPa (2.5-3.0 kgf/cm<sup>2</sup>, 35.6-42.7 psi) pressure. Spraying with improper air pressure will cause imperfections.
- Open the gun 3-4 turns.
- Wipe up unwanted primer immediately with thinner.

#### 5. Cleaning spray gun

- After spraying, be sure to clean the spray gun thoroughly with thinner or solvent.
- The gun will be permanently clogged if the primer is allowed to dry.

#### 6. Drying

- After spraying the chipping guard primer, air-dry for 7-10 minutes to evaporate the thinner in the primer. Then dry it with infrared lamps at 176°F (80°C) for 30-40 minutes.

NOTE: Insufficient baking may cause pinholes if the primer coat is too thick.

- The temperature lamps and drying time recommendations should be followed closely.

#### 7. Intermediate and Top coating

- Sand the chipping guard primer film with #280-#400 sandpaper.
- Follow the intermediate/top coating procedures (see pages 8-9 and 8-11).

Temperature		41°F (5°C)	68°F (20°C)	86°F (30°C)	140°F (60°C)	176°F (80°C)
Time	Before sanding	8-13H 6-10H	3.5-5H 4-5H	2-3H 2-4H	30 Min. 15-20 Min.	20 Min. 10-15 Min.
	Minimum time	8H 10-18H	4H 6-8H	3H 4-8H	30 Min. 20-40 Min.	20 Min. 15-30 Min.

NOTE: The upper line of time shows specifications for High Primer Surfacer 2C, and the lower line Auto Primer Surfacer Mighty.