

COLLISION REPAIR INFORMATION

FOR THE TOYOTA DEALER

TITLE: ANTI-CHIP PRIMER APPLICATION

PAGE 1 of 3

SECTION: REFINISH BULLETIN #52

MODELS: ALL

DATE: FEBRUARY 1994



Illustration A shows the area in which anti-chip primer is used. This material improves stone chip resistance in critical areas such as the leading edge of the engine hood and front fenders. Illustration B identifies the layer in which the anti-chip primer is applied.

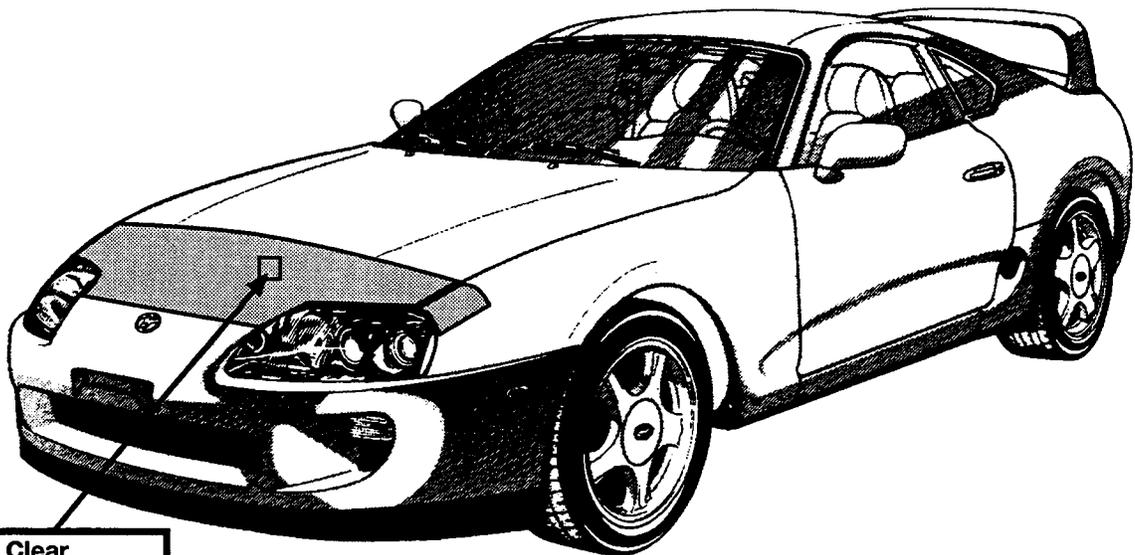


Illustration A.

Clear
Base Color
Primer Surfacer
Anti-chip Primer
Electro Deposition
Substrate

Illustration B.

The following matrix identifies the model and projected implementation date of anti-chip primer used on Toyota vehicles. This protection is the best available as of December 1993.

Model	1991	1992	1993	1994	1995
CAMRY TMC MANUF.			12/93		
CAMRY TMM			5/93		
CELICA	11/91				
COROLLA TMMC MANUF.		9/92			
COROLLA TMC MANUF.#1				5/94	
COROLLA TMC MANUF.#3			12/93		
MR2		8/92			
TERCEL					5/95
SUPRA			4/93		
PREVIA		10/92			
4 RUNNER NUMMI					1/95
4 RUNNER TAHARA			12/93		
T100				1/94	
LAND CRUISER					1/95

TMC = vehicles produced in Japan

TMM = vehicles produced in Georgetown, KY U.S.A.

NUMMI = vehicles produced in Fremont, CA U.S.A.

TMMC = vehicles produced in Canada

Tahara = vehicles produced in Japan at Tahara plant

TMC Manuf#1 = vehicles produced in Japan at Takaoka plant

TMC Manuf#3 = vehicles produced in Japan at other plants

NOTE: THE ANTI-CHIP PRIMER FOR SUPRA WAS DISCONTINUED MAY '93

All other models continue with anti-chip primer

The following information will help the refinish technician identify, repair or replace anti-chip primer on the hood/front fender.

REPAIR PROCEDURE

1. Remove the anti-chip primer from the repair
2. Repair the panel as necessary
3. Featheredge the paint as necessary
4. Clean the panel using a wax and grease remover *
5. Apply wash primer to bare metal areas **ONLY** **
6. Apply primer surfacer with flex agent to primer area only
7. Let panel dry (forced dry for 20 minutes at 140° F.)
8. Sand with 600 grit or equivalent wet or dry ***
9. Refinish remaining coats as necessary using only urethane paint systems

REPLACEMENT PROCEDURE

- A. Prepare the underside of the panel for refinishing
 1. Abrade the factory primer with 400 grit dry or equivalent ***
 2. Apply seam and joint sealer to the perimeter of the hood
 3. Apply tinted epoxy primer sealer
 4. Apply base color
 5. Let the panel dry (force dry for 20 minutes at 140° F.)
- B. Prepare exterior side of panel for refinishing
 1. Sand the exterior side of panel with 400 or equivalent ***
 2. Apply wash primer to bare metal areas **ONLY**
 3. Apply primer surfacer using a two method (1 gun with flex agent & 1 gun without flex agent). Spray flexiblized primer surfacer on approximately 300 mm of hood panel leading edge or approximately 100 mm of front of fender. See page 1 for example. Spray remainder of hood without flexibilized primer surfacer.
 4. Let panel dry (force dry for 30 minutes at 140° F.)
 5. Install panel and align
 6. Final sand the panel with 600 grit or equivalent ***
 7. Refinish as necessary

NOTE:

* Refer to local regulations for the various compliance issues.

** Epoxy primer may be substituted for wash primer, however follow local regulations concerning VOC compliance.

*** Always refer to local regulations regarding disposal of sanding residue or hazardous waste material.