

COLLISION REPAIR INFORMATION

FOR THE TOYOTA DEALER

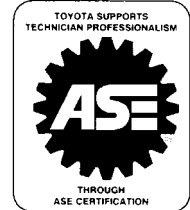
TITLE: PAINT GUIDE AND REPAIR PROCEDURES

PAGE 1 of 8

SECTION: REFINISH BULLETIN #53

MODELS: ALL

DATE: FEBRUARY 1994



The following information includes details of different types of paint film and recommended repair procedures. The actual number of refinish paint coat applications will vary depending upon the pigment, metallic and mica flakes or the use of a clear coat which can be determined by using the attached information and the paint code on the vehicle. In order to achieve an acceptable repair, the technician must:

Step 1.

Locate the paint code on the vehicle.

Step 2.

Reference the paint guide for paint code, model and paint type on page 2.

Step 3.

Verify paint type on page 4.

Step 4.

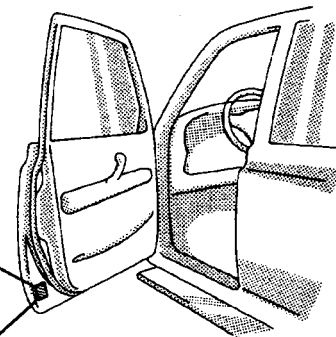
Reference the recommended repair procedure according to the type of paint on pages 5–8.

PAINT CODE	MODEL APPLICATION												PAINT TYPE
	TRC	PAS	COR	CAM	CEL	MR2	SUP	PRV	4RN	TAC	T100	L-C	
751								NEW	NEW	NEW			2A
752					NEW								2A
753					NEW								2B
8B6						NEW					NEW		2A
8E3													2A
8H4													2A
8H5													2A
8H8													2A
8J2													2A
8J6													2A
8J7													2A
8J8													2A
8K0													2B
8K2													2B
923													2A
924													2A

PAINT CODE	PAINT CODE	TWO-TONE COMBINATIONS												PAINT TYPE
		TRC	PAS	COR	CAM	CEL	MR2	SUP	PRV	4RN	TAC	T100	L-C	
25T	3J8 & 179													2A
26P	181 & 183													2A
26W	181 & 3H4													2A
27X	751 & 6M3													2A
28X	196 & 202													2A

Paint Code or Color Identifier is located on the certification label in the "B" pillar or on left front door shell.

Example:



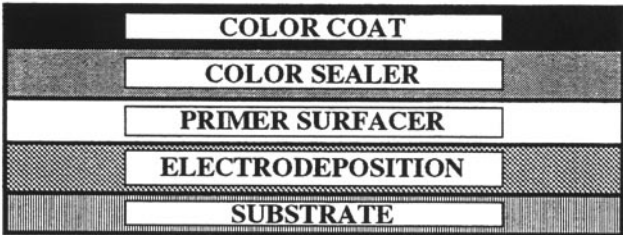
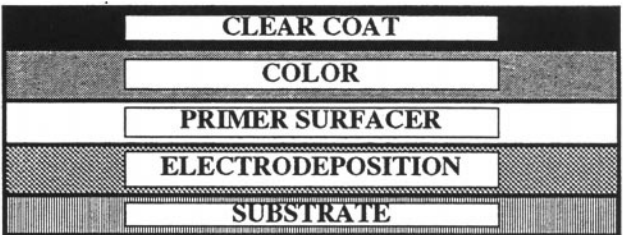
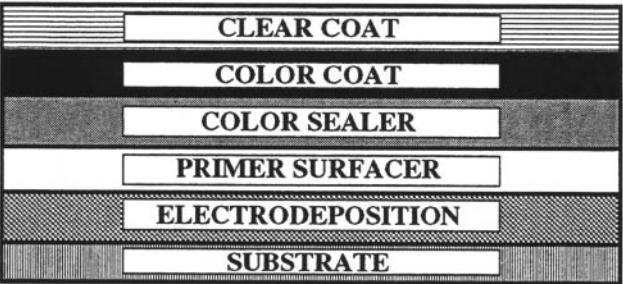
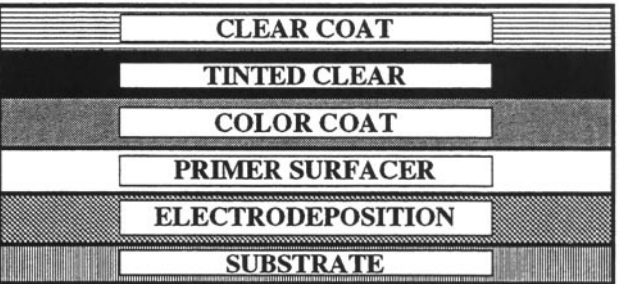
If the vehicle is painted completely in one color, the PAINT CODE is shown here.

If the vehicle is two tone, the COLOR IDENTIFIER is shown here.

COLOR IDENTIFIERS are decoded using the chart above.

For Example: Identifier 26W = paint codes 181 & 3H4
 1st paint code (181) is upper body color
 2nd paint code (3H4) is accent body color

PAINT FILM CROSS SECTIONS

PAINT TYPE #1	PAINT TYPE #2A
<p><u>Solid Color – Non Clear Coat</u></p> <p>Codes: 040, 041, 045, 202, 3E5, 3H7, 3J6, 576, 8E2</p> 	<p><u>Metallic or Mica Color – Clear Coat</u></p> <p>Codes: 1A0, 1A1, 1A2, 176, 179, 181, 183, 187, 192, 193, 196, 199, 205, 3H4, 3H8, 3K3, 3K4, 3K9, 4K1, 4K9, 4M4, 4M9, 6L3, 6M1, 6M8, 6M9, 6N1, 746, 747, 751, 752, 753, 8B6, 8E3, 8H4, 8H5, 8H8, 8J2, 8J6, 8J7, 8J8, 8K0, 8K2, 923, 924, 25T, 26P, 26W, 27X, 28X</p> 
PAINT TYPE #2B	PAINT TYPE #3
<p><u>Metallic or Mica Color – Clear Coat</u></p> <p>Codes: 3J7</p> 	<p><u>Solid Color – Tinted Clear Coat</u></p> <p>Codes: 3L2</p> 

**APPLICATION PROCESS FOR PAINT TYPE #1
(Single Stage Paint)**

MATERIAL	PROCESS	SEQUENTIAL OPERATION PROCEDURE	IMPORTANT POINTS
PRIMER SURFACER	Application of UNDERCOAT	Apply primer–surfacers following manufacturer’s recommendations. Hand sand after recommended dry time, using 600 grit sandpaper (wet) or power sand using 500 grit sandpaper (dry).	Use a high quality 2 component primer–surfacers. Use of a tintable primer sealer may increase top coat hiding.
COLOR SEALER	Application of UNDERCOAT	Follow manufacturer’s recommendations.	Sanding not necessary. Follow manufacturers recommended dry time.
COLOR COAT	Application of COLOR TOP COAT	Use a spray–out panel to verify color match. Match texture to surrounding panels. Apply according to paint manufacturer’s recommendation.	Apply only urethane color coats. To reduce orange peel, use the four following steps: <ul style="list-style-type: none"> • Use slower evaporating solvent. • Use higher air pressure for better atomization. • Decrease spray gun travel speed. • Decrease spray gun distance to the panel.
	DRYING	Allow proper flash time before forced drying.	Allow panels to cool down naturally to room temperature before sanding or polishing.
	SANDING	Color sanding of the top coat can be performed, if necessary, with 1500/2000 grit sandpaper (wet).	Use clean water with a mild detergent for abrasion resistance. Periodically check sanding progress with a squeegee.
	POLISHING	If necessary, finish the paint film so the adjacent panels have matching texture and lustre.	Allow 24 hours dry time. Use a non–aggressive polishing system that eliminates any imperfections.
	EVALUATING	Evaluate your repair with the unrepaired portions of the vehicle.	Customer Satisfaction: If you see a difference, so will the customer.

**APPLICATION PROCESS FOR PAINT TYPE #2A
(Two Stage Paint Without Color Sealer)**

MATERIAL	PROCESS	SEQUENTIAL OPERATION PROCEDURE	IMPORTANT POINTS
PRIMER SURFACER	Application of UNDER COAT	Following paint manufacturer's recommendations. Hand sand after recommended dry time, using 600 grit sandpaper (wet) or power sand using 500 grit sandpaper (dry).	Use a high quality 2 component primer-surfacer. Use of a tintable primer sealer may increase top coat hiding.
COLOR COAT	Application of COLOR TOP COAT	Use a spray out panel to verify color match. Spray two full wet coats according to instructions. Use air pressure appropriate to conditions.	<i>Do not over reduce with solvent.</i> Use slowest dry solvent shop conditions will allow.
CLEAR COAT	Application of CLEAR TOP COAT	Match texture to surrounding panels using paint manufacturer's recommendations.	To reduce orange peel, use the four following steps: <ul style="list-style-type: none"> • Use slower evaporating solvent. • Use higher air pressure for better atomization. • Decrease spray gun travel speed. • Decrease spray gun distance to the panel.
	DRYING	Allow proper flash time <i>before</i> force drying.	Allow panels to cool down naturally to room temperature before polishing procedures are started (normally 24 hours).
	SANDING	Color sanding of the top coat can be performed, if necessary, with 1500/2000 grit sandpaper (wet).	Use clean water with a mild detergent for abrasion resistance. Periodically check sanding progress with a squeegee.
	POLISHING	If necessary, finish the paint film so the adjacent panels have matching texture and lustre.	Use a non-aggressive polishing system that eliminates any imperfections.
	EVALUATING	Evaluate your repair by comparing it to an unrepaired portion of the vehicle.	Customer Satisfaction: If you can see a difference, so will the customer.

**APPLICATION PROCESS FOR PAINT TYPE #2B
(Two Stage Paint With Color Sealer)**

MATERIAL	PROCESS	SEQUENTIAL OPERATION PROCEDURE	IMPORTANT POINTS
PRIMER SURFACER	Application of UNDER COAT	Follow paint manufacturer's recommendations. Hand sand after recommended dry time, using 600 grit sandpaper (wet) or power sand using 500 grit sandpaper (dry).	Use a high quality 2 component primer-surfacer. Use of a tintable primer sealer may increase top coat hiding.
COLOR SEALER	Application of UNDER COAT	Follow manufacturer's recommendations.	Sanding is not necessary after recommended dry time.
COLOR COAT	Application of COLOR TOP COAT	Use a spray-out panel to verify color match. Spray two full wet coats according to instructions. Use air pressure appropriate to conditions.	Do not over reduce with solvent. Use the slowest solvent shop conditions will allow.
CLEAR COAT	Application of CLEAR TOP COAT	Match texture to surrounding panels using paint manufacturer's recommendations.	To reduce orange peel, use the four following steps: <ul style="list-style-type: none"> • Use slower evaporating solvent. • Use higher air pressure for better atomization. • Decrease spray gun travel speed. • Decrease spray gun distance to the panel.
	DRYING	Allow proper flash time before forced drying.	Allow panels to cool down naturally to room temperature before polishing procedures are stated (normally 24 hours).
	SANDING	Color sanding of the top coat can be performed, if necessary, with 1500/2000 grit sandpaper (wet).	Use clean water with a mild detergent for abrasion resistance. Periodically check sanding progress with a squeegee.
	POLISHING	If necessary, finish the paint film so the adjacent panels have matching texture and lustre.	Use a non-aggressive polishing system that eliminates any imperfections.
	EVALUATING	Evaluate your repair by comparing it to an unrepaired portion of the vehicle.	Customer Satisfaction: If you can see a difference, so will the customer.

**APPLICATION PROCESS FOR PAINT TYPE #3
(Two Stage Paint With Tinted Clear Coat)**

MATERIAL	PROCESS	SEQUENTIAL OPERATION PROCEDURE	IMPORTANT POINTS
PRIMER SURFACER	Application of UNDERCOAT	Follow paint manufacturer's recommendation. Hand sand after recommended dry time, using 600 grit sandpaper (wet) or power sand using 500 grit sandpaper (dry).	Use a high quality 2 component primer-surfacer. Use of a tintable primer sealer may increase top coat hiding.
COLOR COAT	Application of COLOR TOP COAT	Apply urethane top coats only. Follow paint manufacturer's recommendation. Manually sand with 600 grit sandpaper (wet).	Do not over reduce with solvent.
TINTED CLEAR COAT	Application of TINTED CLEAR COAT	Follow paint manufacturer's recommendation.	Use a spray-out panel before applying paint to vehicle.
CLEAR COAT	Application of CLEAR TOP COAT	Apply ONLY urethane clear coats. Apply according to paint manufacturer recommendations.	Paint viscosity should follow paint supplier recommendations. To reduce orange peel, use the four following steps: <ul style="list-style-type: none"> • Use slower evaporating solvent. • Use higher air pressure for better atomization. • Decrease spray gun travel speed. • Decrease spray gun distance to the panel.
	DRYING	Allow proper flash time before force drying.	Allow panels to cool down naturally to room temperature before polishing procedures are started (normally 24 hours).
	SANDING	If necessary, use 1500 grit Wet Sand to smooth out orange peel.	Sand with extreme caution so as not to expose base color coat on the body character lines.
	POLISHING	If necessary, finish the paint film so the adjacent panels have matching texture and lustre.	Use a non-aggressive polishing system that eliminates any imperfections.
	EVALUATING	Evaluate your repair by comparing it to an unrepaired portion of the vehicle.	Customer Satisfaction: If you can see a difference, so will the customer.