

COLLISION REPAIR INFORMATION

FOR THE TOYOTA DEALER

TITLE: REFINISH PROCEDURES FOR
POLYURETHANE BUMPER COVERS

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SECTION: REFINISH BULLETIN #69

MODELS: AVALON, CELICA & SUPRA

DATE: MARCH 1996



PAINT REPAIRS ON POLYURETHANE BUMPERS

Polyurethane bumper covers are formed by forcing liquid plastic material into a mold. Lubricant is added to the mold as a release agent to make it easier to separate the bumper from the mold.

MOLD LUBRICANT CHANGE

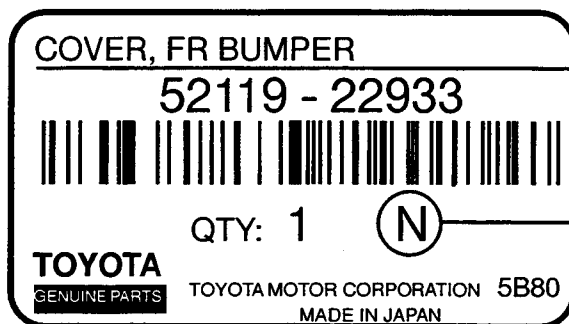
Recently, the mold lubrication (release agent) was changed from a **wax type** to a **soap type** on OEM supply parts. The wax lubricant was discontinued because wax removal from the bumper surface required the use of trichloroethylene.

The new mold lubricant (soap type) is easily removed by using a water based cleaner, such as mild soap and water, and a photochemically non-reactive cleaning agent.

NOTE: Remove wax from wax type lubricant supply parts according to the paint manufacturer's recommendations.

BUMPER IDENTIFICATION

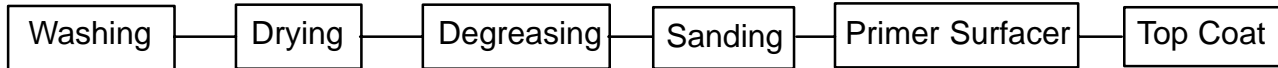
Supply part bumper covers using soap type lubricant were introduced in June 1995. An "N" on the part label identifies the new soap type bumpers (see diagram). The "N" identifier on the part number label will be discontinued after July 1996.



**"N" INDICATES SOAP TYPE
BLANK INDICATES WAX TYPE**

(For bumper covers manufactured between 6/96 & 8/96. After 7/96 a blank indicates soap type).

STANDARD PROCESS



REPAIR PROCESS

- Begin by washing the new part with soapy water; rinse with clean water and towel dry (clean, dry compressed air may be substituted for drying).
- Degrease the part with a wax and grease remover.
- Abrade the part with a grey scotchbrite and sanding paste.
- Degrease with anti-static plastic parts cleaner.
- Apply the appropriate plastic parts primer.
- Refinish with appropriate urethane top coat.

For additional information concerning the refinishing process please refer to your paint manufacturer's recommendations.

NOTE: PLEASE ROUTE THIS BULLETIN TO YOUR COLLISION REPAIR CENTER MANAGER