PORSCHE öffnet die Welt

PORSCHE

Black


NOTICE
AUTHORIZED
PERSONNEL ONLY
PORSCH
STUTTGART

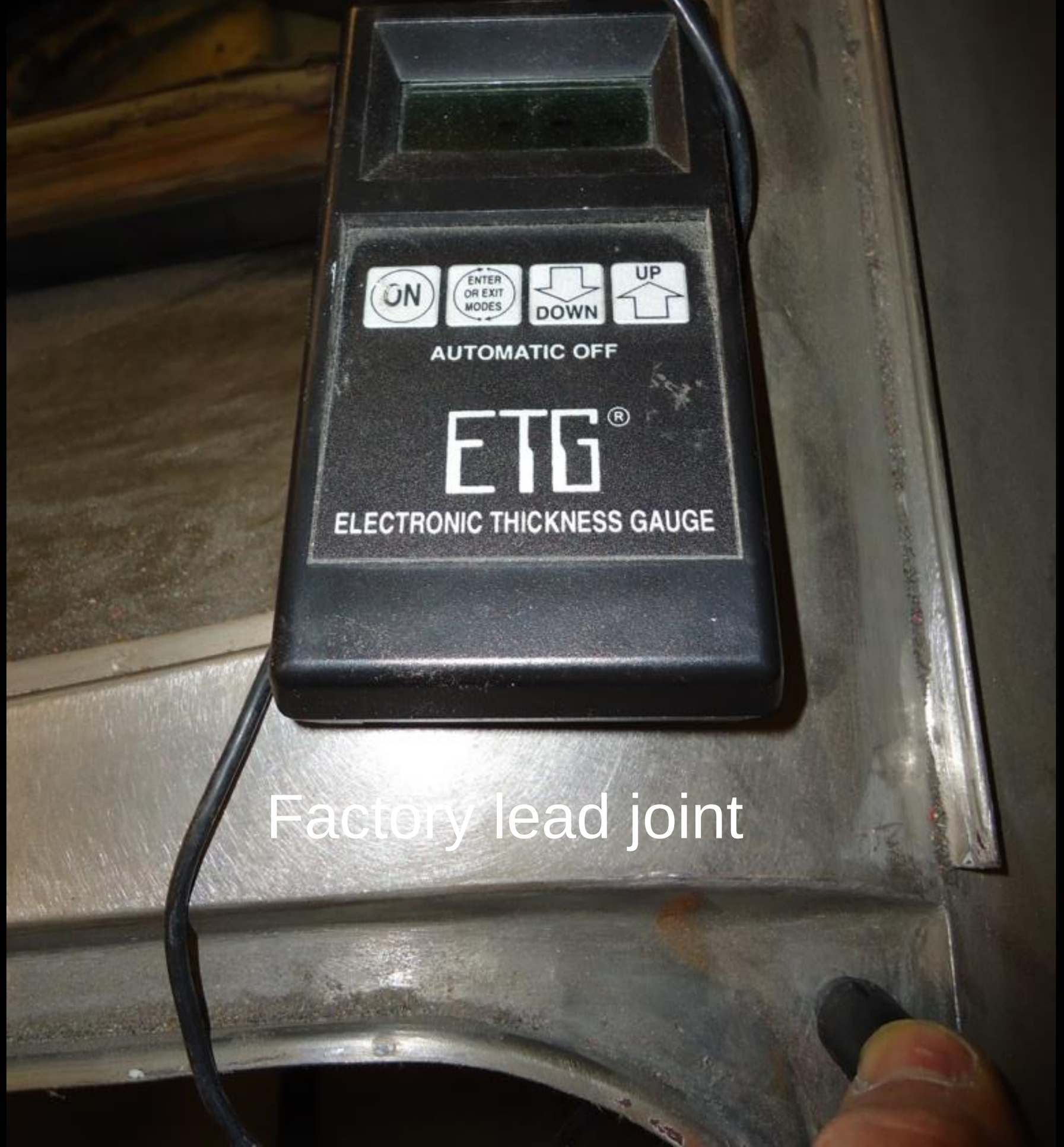
Paint gauge could save a “mil”

What’s a “mil”?

.001 in.
.03 mm

Epoxy primer on bare steel

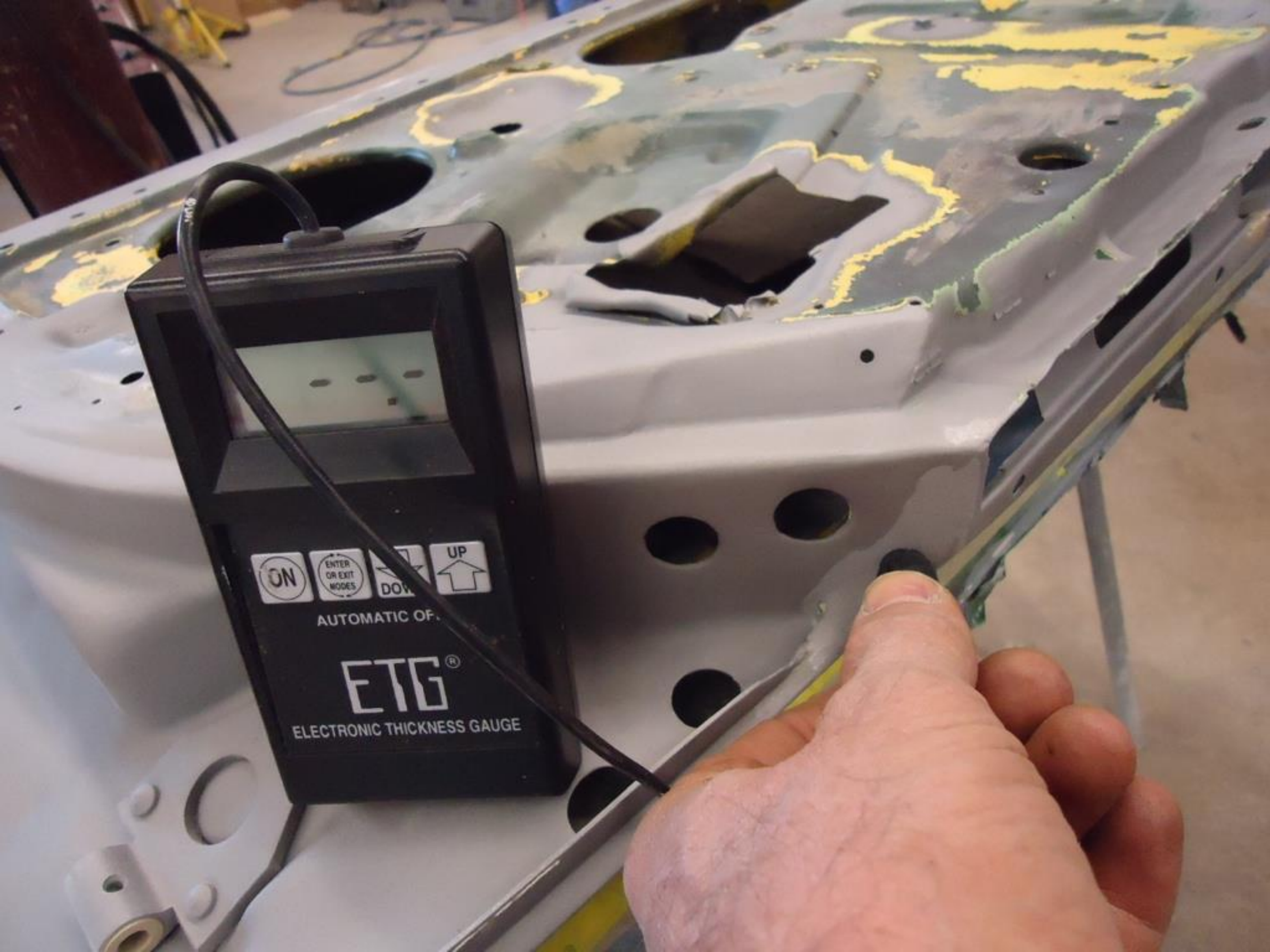
Epoxy primer and high build epoxy primer



Factory lead joint


ON
ENTER OR EXIT MODES
DOWN
UP
AUTOMATIC OFF
ETG®

356 door edge lead


ON
ENTER OR EXIT MODES
UP
ETG®
ELECTRONIC THICKNESS GAUGE

ON

ENTER OR EXIT MODES

DOWN

UP

AUTOMATIC OFF

ETG®

ELECTRONIC THICKNESS GAUGE


ON
ENTER
OR EXIT
MODES
DOWN
UP
AUTOMATIC OFF

Spraygun Set-up:

Apply:	1 wet coat as non-sanding primer 2 – 4 wet coats as surfacer
Fluid Tip:	1.4 – 1.6 mm or equivalent
Air Pressure:	10 PSI at the cap for HVLP 45 – 50 PSI at the gun for conventional gun

Dry Times:

Between Coats:	Allow 5 – 10 minutes dry between coats
Recommended Dry Film Build: Surfacer (After sanding) Non-sanding Primer	 2.0 – 6.0 mils 1.5 – 1.8 mils
Dry to Topcoat:	30 minutes at 70°F (21°C) for 1 coat non-sanding primer application
Dry to Sand:	1 – 2 hours at 70°F (21°C)
Purge Time:	10 minutes at 70°F (21°C)
Force Dry:	20 – 30 minutes at 140°F (60°C)
IR (Infrared):	20 minutes for Medium Wave 10 minutes for Short Wave
Dust Free Time:	20 minutes

Note: *NCP270/271 must be sanded prior to topcoat application if allowed to dry more than 8 hours.*

Directions for Use

Number of Coats:

Apply:	2 wet coats or until hiding is achieved.
Film build per wet coat	3.0 – 3.7 mils
Dry film build per coat	1.3 – 1.3 mils

Drying Times:

	DCX9 or DCX61	DU5 or DU6	DFX11
Between Coats:	10 – 15 minutes	10 – 15 minutes	5 – 10 minutes
Dust Free	30 – 50 minute	30 – 40 minutes	10 – 15 minutes
Tack Free	2 – 3½ hours	2 – 3½ hours	2 – 3½ hours
Tape Free	8 – 10 hours	8 – 10 hours	8 – 10 hours
Air Dry:	6 – 8 hours @ 70°	6 – 8 hours @ 70°	6 – 8 hours @ 70°
Purge Time	0 – 10 minutes	0 – 10 minutes	0 – 10 minutes
Force Dry	40 minutes @ 140°	15 – 25 minutes	15 – 30 minutes
IR (Infrared) Medium Wave	10 – 15 min depending on color		
Short Wave	8 minutes depending on color		

Blending:

DCC Color may also be blended by taking the DCC Color that you have in your gun cup and reduce the mixture with an equal amount of **DX840 Blend-Ease Universal Blending Solvent** (See P-235 for instructions). Apply this "over" reduced material to the dry edges. If additional blending is necessary, reduce the blend mixture with another equal part of DX840. Straight DX840 may also be misted onto the blend edge.

Note: Spot repairs cannot be done on OE or Refinish lacquers due to adhesion problems. Lacquer panel repairs must be sanded and sealed prior to applying DCC Color.

Polishing:

Metallics can be compounded but do not sand.

After 24 hours @ 70°F (21°C) solid colors can be sanded with 1200 – 2000 grit sandpaper and compounded. In all cases, use a fine compound and polishing pad.

Note: If sanding and/or polishing is required, an extra coat of DCC Color is recommended.

Repair and Recoat:

DCC color can be recoated immediately after the force dry/cooling cycle or 8 hours air dry at 70°F (21°C). DCC color must be sanded before recoating with primer, color or clear.

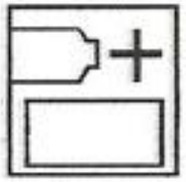
Compatible Clearcoats:

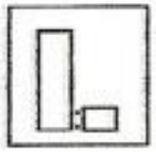
DC3000 *DELTRON*® High Veolcity Clearcoat

Body Filler or Putty

- Finish sanding body filler or putty with 180-220 grit sandpaper
- Featheredge with 320 grit sandpaper
- Blow off the surface with an air blow gun

MIXING:





4 parts 730 Super Build 4:1 Primer
to
1 part 733 or 734 Fast 4:1 Polyester Primer Catalyst

- Shake and stir the primer and catalyst thoroughly before mixing
- **733 – Pot Life is 60 minutes @ 75°F (24°C); pot life decreases at higher temperatures**
- **734 – Pot Life is 45 minutes @ @ 75°F (24°C); pot life decreases at higher temperatures**
- ***Do not leave product in the spray gun for longer than 35 minutes***

APPLICATION:

- Use a primer gun with a 1.6 to 2.2 fluid nozzle/air cap (Spray at paint gun manufacturer's recommended air pressure)
- Apply **2-3** medium wet coats allowing **5-10** minutes flash time between coats

FINISH:

- At 72°F (22°C) Super Build 4:1 is ready to sand in 80 – 120 minutes, depending on film build
- Applying over self-etch primer could add 4-6 hours to the dry time
- Once dry, sand Super Build 4:1 with *180-400 grit* sandpaper prior to next step

TECHNICAL SPECIFICATIONS:

Appearance	Gray liquid
VOC	Packaged: 2.02 lbs/gal (243g/L) Applied: 1.51 lbs/gal (180.9g/L)
Dry-Film-Thickness (DFT)	6.0 – 8.0 mils per coat
Solids by Volume	65 – 70%
Solids by Weight	70 – 75%
Viscosity (Ready to Spray)	30 – 35 seconds in Zahn #3
Coverage at 1 mil 100% Transfer	1200 sq. ft. per US gallon

	with P210-854 Hardener.	
VISCOSITY & POT LIFE 	**Viscosity:** 14-16 seconds DIN 4 @ 70°F (21°C) **Pot Life:** 2 hrs. @ 70°F (21°C)	**Viscosity:** 16-17 seconds DIN 4 @ 70°F (21°C) **Pot Life:** 4 hrs. @ 70°F (21°C)
SPRAY GUN & AIR PRESSURE 	**Siphon:** 1.4-1.8mm (.055" - .070") 50-55 psi at the gun. **Gravity:** 1.3-1.6mm (.050" - .063") 50-55 psi at the gun. **HLVP:** 0.8-1.5mm (.031" - .059") Max 10 psi cap press. 3-8 psi fluid press. (pressurised cup)	**Siphon:** 1.4-1.6mm (.055"-.063") 50-55 psi at the gun **Gravity:** 1.3-1.6mm (.050" - .063") 50-55 psi at the gun **HVLP:** 0.8-1.5mm (.031" - .059") Max 10 psi cap pressure 3-8 psi fluid pressure (pressurized cup).
	(HVLP: Refer to gun manufacturer's recommendations for required inlet pressure.)	
APPLICATION 	**2 single coats** (approx. 2.5 mils)	**2 single coats** (approx. 2.5 mils)
FLASH TIME 	**5-10 minutes** between coats **Note:** No flash-off is necessary before force drying.	**5-10 minutes** between coats. **Note:** No flash-off is necessary before force drying.
DRYING TIME 	**Air Dry @ 70°F (21°C)** Dust Free 10 min. Handle 2 hrs. Polishing 4 hrs **Force Dry @ 140° (60°C)** **(metal temperature)** 10 minutes	**Air Dry @ 70°F (21°C)** Dust Free 10-15 min. Handle 4-6 hrs Polishing 12-16 hrs **Force Dry @ 140° (60°C)** **(metal temperature)** P210-854 20 min. P210-856 30 min. P210-857 40 min.

The new metallic paint finish differs from the formerly used single coat finish in that it is applied in two coats, that is, a metallic basic coat, and a clear top coat. This application is accomplished by the wet-on-wet method and produces an especially smooth and long lasting gloss.

Application of this wet-on-wet method still requires the usual attention and care required by the single coat method. Although dust particles or minor scratches in the top coat can be removed with wet sanding paper of 600-grain coarseness, followed up with polishing compounds.

When several adjacent areas are to be painted, it is necessary to spray the entire side, front or rear section, or the entire body. If the paint job does not turn out as good as required, it will be necessary to sand the entire surface again and respray with both coats.

In the past it was possible to apply this double coat method only in paint shops which could utilize $80^{o}C$ materials. This material, when handled in professional manner, produces results which are almost comparable with original finishes. Consequently, shops which have a drying facility at their disposal should continue to apply this painting method.

For an alternate method, the double coat metallic paint now is available in an air drying version. This process is more difficult to accomplish and does not provide results obtainable through the $80^{o}C$ baking process. The following disadvantages are inherent in this type of painting:

a. The paint finish is initially very easily scratched and does not reach a fair degree of hardness until after about 8 to 10 days, although application of regular heating lamps or devices does speed up the drying process.

b. A filler coat must be used to ensure proper bonding between the old and new coats.

c. The clear top coat yellows after about two years time.

A. Preparation

Smaller damages where the old paint can be oversprayed should be sanded with 400 or 500-grain wet sanding paper and then smoothened with 500 or 600-grain wet sand paper.

NOTE

If coarser sand paper is used, sanding scratches may become visible in the new finish.

B. Priming and Painting

Painting of new parts or the entire body is accomplished in the same manner as applicable to 80°C baked synthetic enamel. In the same way, filler can be the 80°C synthetic resin filler or the combination filler. If a toning metallic paint is to be applied, select primer of proper color. Also, the application of the double coat metallic enamel continues to present the otherwise known problems inherent in metallic paint applications. Therefore, only whole surfaces or body parts can be painted.

The metallic enamel is to be sprayed into a faultless surface, at first with fine spray nozzle setting and 1/2 cross-sweep, followed up with a second cross-sweep utilizing same material.

To avoid shading, the spray should be neither too dry (results in light tones), not too wet (results in dark tones). It is necessary to spray paint each body section individually.

Viscosity of basic metallic paint	14 - 17 sec. DIN 4 mm at 20° C
Spray pressure	4 - 5 atmospheres
Spray gun nozzle	1 - 1.2 mm

Filler

Synthetic resin or combination filler may be used.
Spray the entire area with filler. To ensure good bonding, it is also necessary to coat those surfaces with filler which are to be repainted.

Spray viscosity	18 - 20 sec. DIN 4 mm
Spray pressure	5 atmospheres
Application	1 1/2 to 2 cross-sweeps
Drying time (combination filler)	ca. 2 hours at 20° C

Basic Paint Coat

Basic metallic paint is same as 80°C enamel. Spray basic metallic paint wet, avoiding dusting (similar as Uni-Enamel).

Spray viscosity	13 - 14 sec. DIN 4 mm
Thinner	HERBOL V 161-1125, or other good quality synthetic enamel thinner
Spray pressure	5 atmospheres
Spray gun nozzle	1,0 - 1,2 mm
Application	1 1/2 cross-sweeps

Final Coat

Mix the clear enamel with HERBOL at a 9 1 ratio; this represents the proper spray concentration. It is recommended, however, to check the consistency of the mix and thinning it with good synthetic enamel thinner if necessary.

Spray viscosity	20 - 22 sec. DIN 4 mm
Spray pressure	5 atmospheres
Spray nozzle	1,0 - 1,2 mm
Application	1 1/2 to 2 cross-sweeps

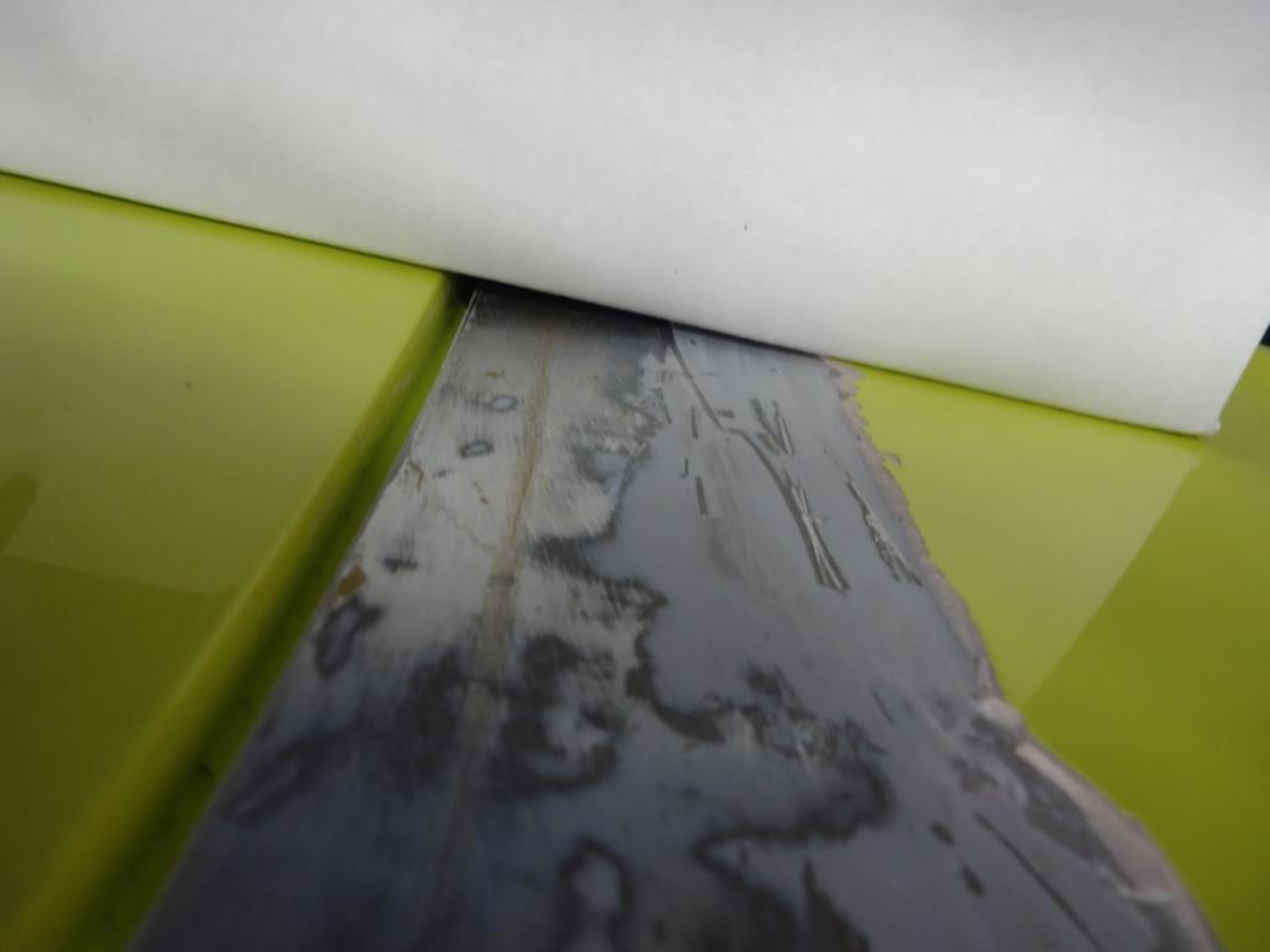
NOTE

Clear enamels mixed to spraying consistency must be used up within 6 to 8 hours, thus only the proper amounts should be prepared.
Mixtures which have thickened must not be thinned out. Air drying, double-coat metallic enamels can be stored only up to 10 months. The storing temperature should be maintained at a uniform 20°C if possible.
Greater temperature variations shorten the usability of the paint.

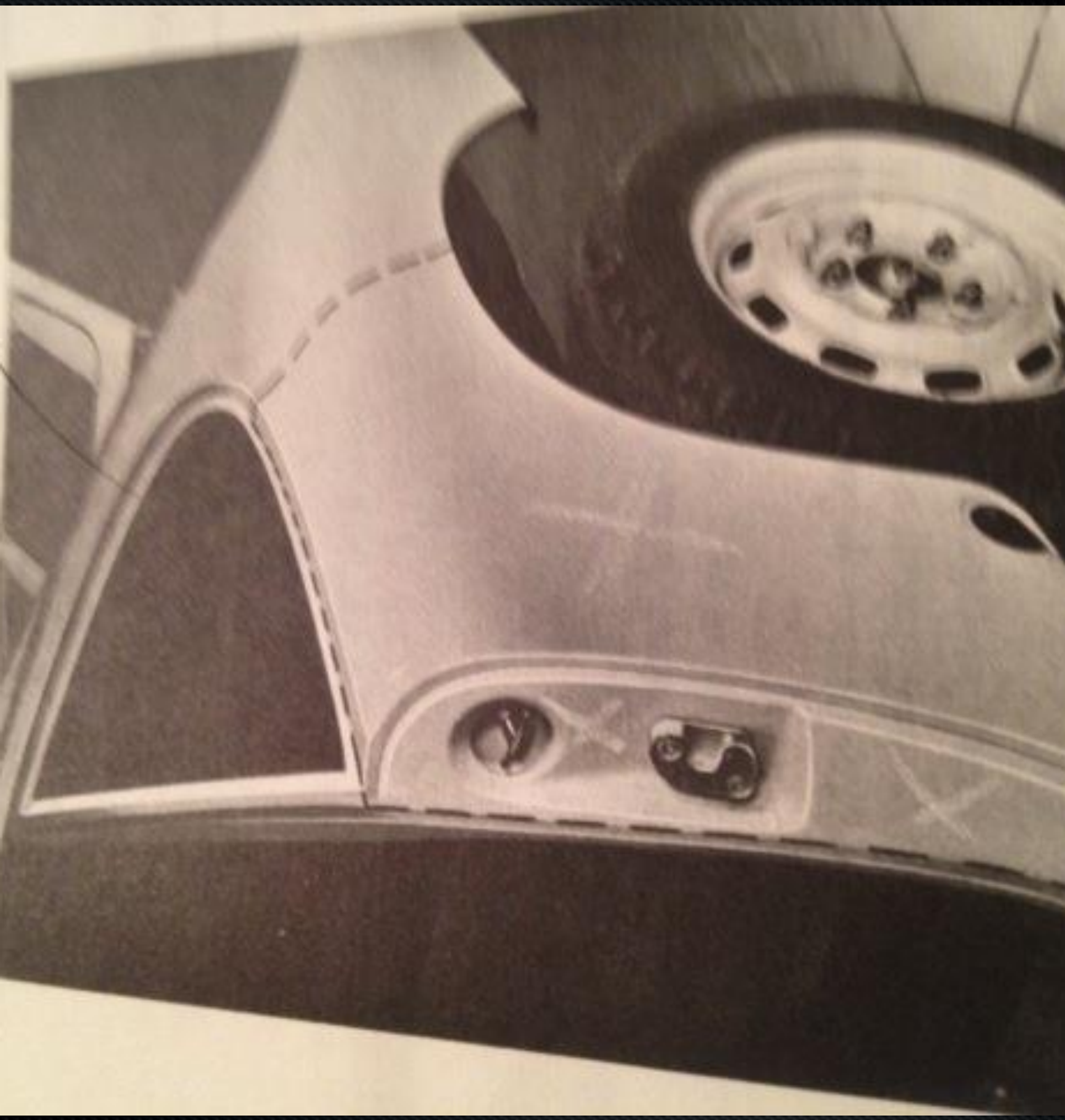
Drying

The paint is touch-dry within 40 minutes, and completely dry after about 2 weeks. A careful application of heating devices can shorten this time.


MAX 164°C



Collectable?



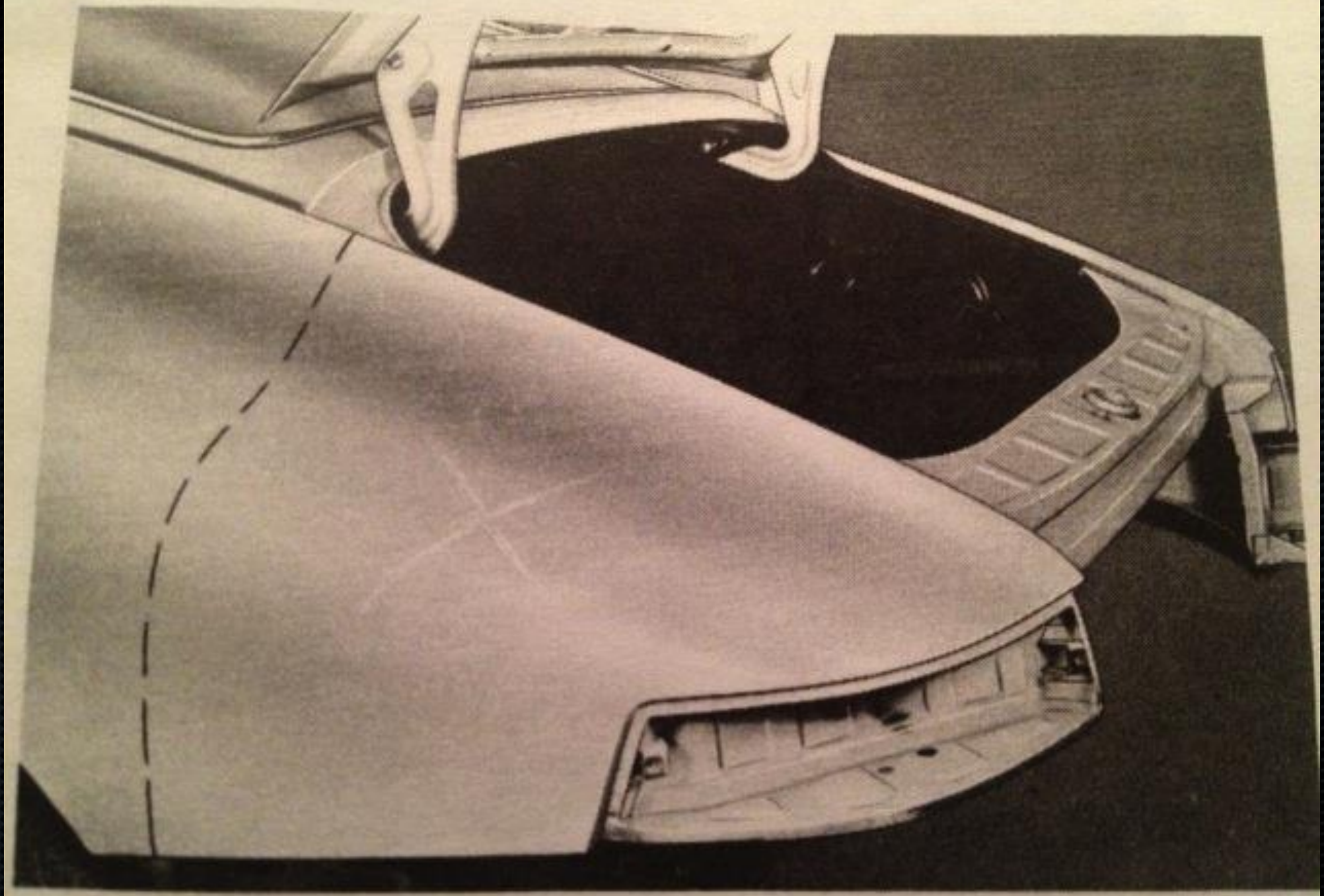
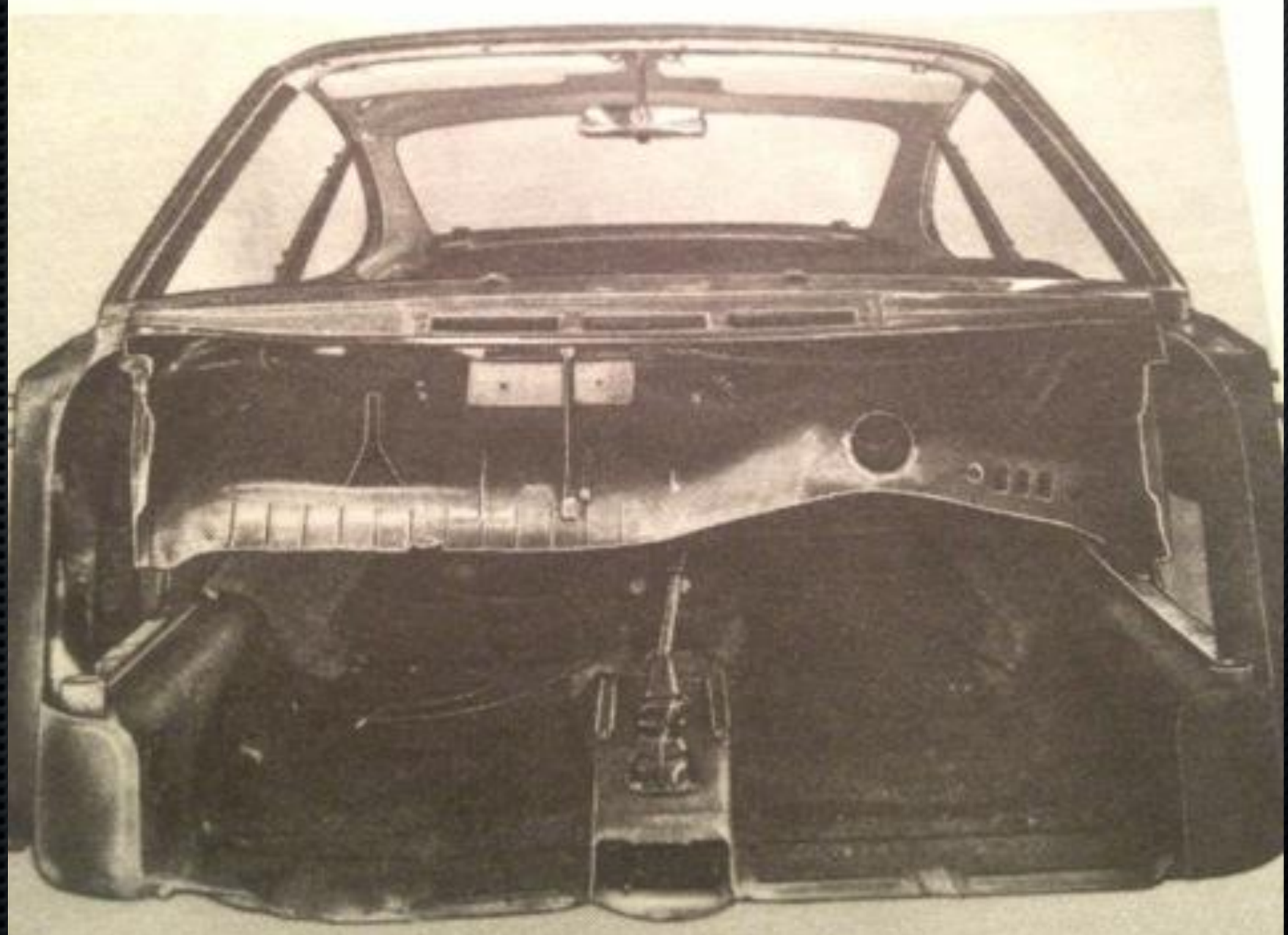


Fig. 145

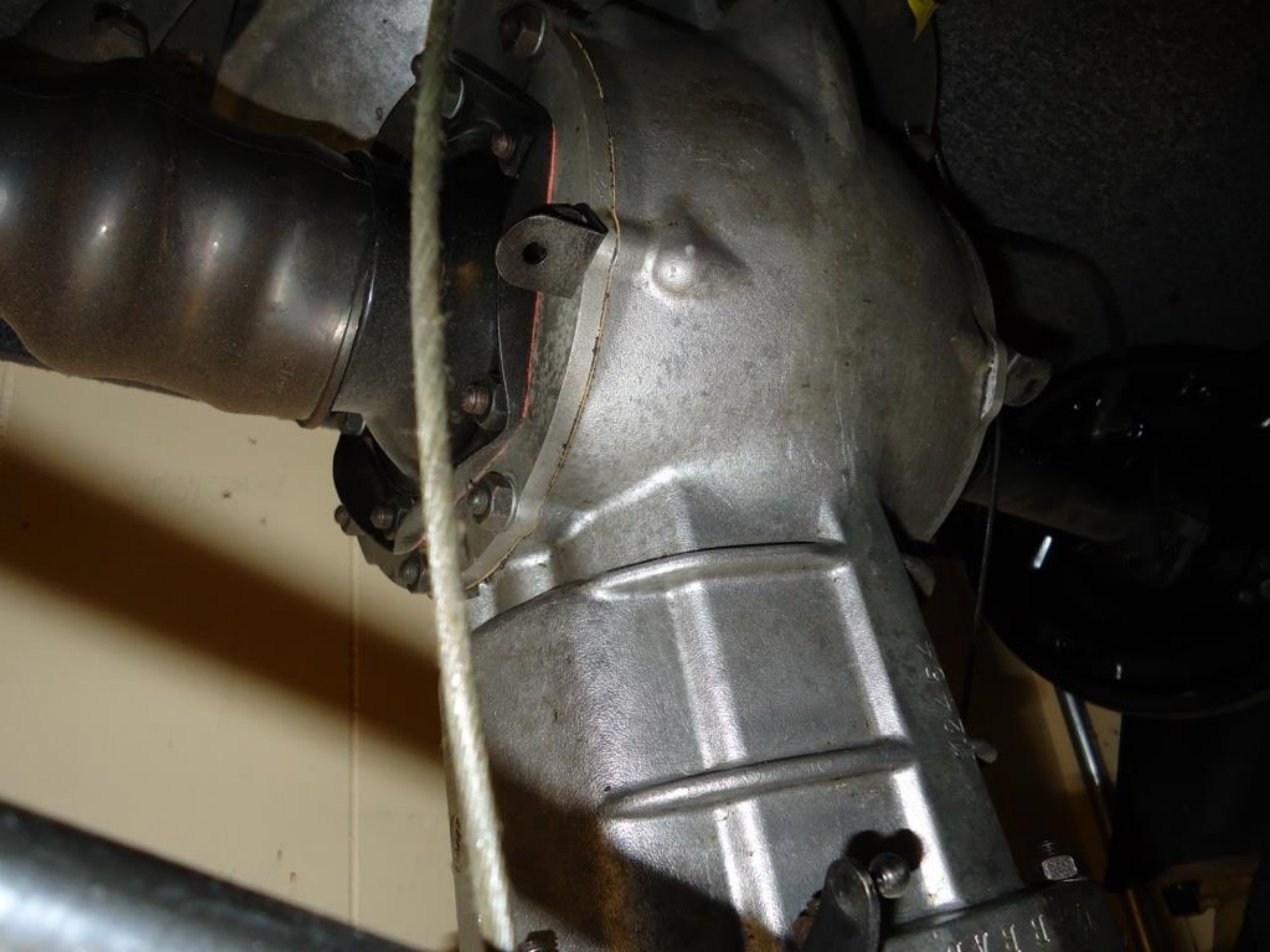
5. Clean sound-proofing compound from weld seams. This is best done by heating the sound-proofing compound with a welding torch and then brushing off with a steel brush.




BOSCH
SUPER PLUS


BOSCH


L




GOLD CUP
PORSCHES
LLENGE
Region
UB OF AMERICA
s not just the cars, it's the people.


TARGA
FLORIO
WINNER
SIEG FÜR DEN
INDY-PORSCHE
DAYTONA
PORSCHE
CUP
USA
NOTICE


Factory

Why rocker moulding ?

If you don’t know
...then just wing
it !

QUESTIONS ?