

PORSCHE

Two Coat Metallic Paint Repair Procedures

Instructions for North America

Dr.Ing.h.c.F.Porsche KG Stuttgart Germany

TWO-COAT METALLIC PAINTING PROCEDURES

Please read all instructions to become acquainted with this very special procedure before you actually begin.

The material preparation and painting description outlined here is probably not the way you are accustomed to preparing standard materials. It might also not be the way you have been accustomed to applying the final coats. Be aware, however, that metallic paint has a very different visual effect because of the way light is reflected from the particles of metal in the paint. It has been our experience that to match these colors is more difficult than the non-metallic paint colors.

Because of the special composition of the material, it is absolutely necessary that instructions are followed closely. The materials used for painting the Porsche 911 models differ from those used for the 914 models. Therefore, make sure that you are using the proper materials as we have listed them. To restore the highest only entire sections should be repainted. Spot painting is not to be performed.

Use the 175° F oven drying process only if your shop has the necessary equipment.

Two-coat Metallic Painting -- Air Drying

The following is a list of the material required for this procedure:

Materials	914
Metallic Paint	LKL***
Reducer	LKL 162
Synthetic Clear Resin	L 100
Hardener	L 101
Combination Filler	L 145
Thinner	L 160
Primer Surfacer	Local purchase item



Materials	911
Metallic Paint	000 040 903 80---
Reducer	LKL 162
Synthetic Clear Resin	000 045 115 00
Hardener	000 045 118 00
Combination Filler	L 145
Thinner	L 160
Primer Surfacer	Local purchase item



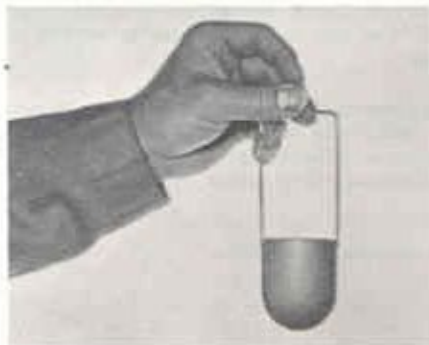
The following is a list of the special equipment you will need for this procedure:

Viscosity Cup (Viscosimeter or Ford Cup) Local purchase item

The cup capacity should be about 100 cc. or 3.5 cu. in.

Stop Watch:

Local purchase item.



Drying Time and Temperature Requirements

Depending on the drying temperature used, the painted areas can be handled (reinstall moldings, attach parts, etc.) as follows:

- a. If heat lamps are not used, then allow the painted area to dry overnight.
- b. If heat lamps are available (approx. temperature of about 100 F) then two (2) hours are needed.
- c. At 175° F., the time will be about forty (40) minutes.
- d. Be sure that the paint, the car or panels, and the shop temperature are the same, and as close to 70° F as possible.

Two-coat Metallic Painting --- 175^o F Oven Drying Process

The following is a list of the materials required for this procedure:

Materials	914
Metallic Paint	LK1
Reducer	LK1 102
Synthetic Clear Resin	LK 100
Hardener	LK 101
Combination Filler	L 145
Thinner	L 160
Primer Surfaces	Local purchase item



Materials	911
Metallic Paint	600 640 900 80
Reducer	LK1 102
Synthetic Clear Resin	600 645 107 00
Hardener	None
Combination Filler	Combination 140
Thinner	L 160
Primer Surfaces	Local purchase item



Caution

To ensure proper drying and to prevent damage to vehicle components do not exceed temperatures of 185^o F.

General If facilities are available for using the 175^o F drying process, the painting procedure differs slightly from the air drying procedure. Note the following:

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Priming Same as air-drying procedure.

Filling " " " "

Sanding " " " "

Painting " " " "

Clear coat application

Mix clear resin VW LK 100 with hardener VW LK 101 in the proportion of 3 : 1. Check the viscosity with a viscosity cup; it should be 15 - 17 seconds. Reduce with LK1 102 if necessary.

Note

The prepared clear coat mixture has to be used within a 4 hour period to prevent hardening.

Apply the clear coat with a gun pressure of 75 - 85 psi, using 3 - 4 wet coats (1 1/2 - 2 cross coats).

6. Clear coat application:

914

Mix VW clear resin L 100 with VW hardener L 101 in the proportion of 8 : 1. The small can of L 101 is the right proportion for the can of L 100. The mixture is then reduced with reducer LKL 102 to a viscosity of 15 - 17 seconds with the viscosity cup.

The prepared clear coat mixture has to be used within a 6 hour period to prevent hardening.

Apply three (3) heavy coats with a pressure of 75 - 85 psi at the gun. Keep a distance of about twelve (12) inches away from the surface with the gun.

911

Mix Porche Clear Resin with Porche Hardener in the proportion of 9 : 1. The mixture should then be checked. The viscosity should be 20 - 22 seconds with the viscosity cup. Reduce with LKL 102 if necessary.

The prepared clear coat mixture has to be used within a 6 hour period to prevent hardening.

Apply three (3) heavy coats with a gun pressure of 70 psi. Keep distance of about twelve (12) inches away from the surface with the gun.

7. Drying:

Caution

Remove masking tape immediately after spraying the clear coat to prevent marks appearing at the paint edges.

The clear coat should now dry for about 40 min. at room temperature after which it will be touch-free. If heat lamps are available, they can be used after the clear has "flashed off".

Note

Depending on weather conditions, it may take the paint up to two weeks to cure when air-dried. This time can be shortened by force-drying at temperatures up to 175^o F. If dried at 175^o F, the clear coat will be cured within forty (40) minutes, but should not be polished for at least one week. Use of heat lamps will provide a hard top coat, which will prevent dust inclusions etc.

8. After spray gun has been used clean gun immediately with acrylic lacquer thinner to prevent the clear from clogging the gun.

9. Remove dust inclusions:

Caution

Do not sand or polish until the paint is completely cured.

When the paint is fully cured, dust inclusions in the clear coat can be removed with No. 600 wet sanding paper, followed by polishing compound and polishing fluid.