

PAINTWORK OPERATIONS

General information

78.00.00



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Body panels

1. Land Rover body panels are manufactured from a special aluminium-alloy known as 'Birmabright' and the following paintwork procedure should be followed on these panels.

Painting 'Birmabright'

2. The area to be painted must be flatted to remove the hard oxide skin which forms on the surface of the alloy when exposed to the atmosphere. Degrease and dry the area, then apply a suitable etch-primer. Unless an etch-primer is used, paint is liable to come away as it cannot 'Key' into the hard oxide of an untreated alloy surface and the use of I.C.I. Etching Primer P565-5002 is recommended. It is quick and easy to apply, and it prolongs the life of the paint film by ensuring excellent adhesion.

Application

3. The activated Etching Primer has a limited pot-life of about 8 hours at normal temperatures and should not be used after this time, as it may have inferior adhesion and corrosion resistance. Any Etching Primer which has been mixed for more than 8 hours must be thrown away, and not returned to the can.
4. Apply Etching Primer as soon as possible after cleaning, and paint as soon as the pre-treatment is completed. Undue delay may cause the surface to be contaminated again and thus nullify the treatment. Do not leave pre-treated work overnight before it is painted.
5. Etching Primer, when followed by a suitable paint system, gives a film which is very resistant to moisture, but the Etching Primer itself is water sensitive. It should therefore be coated with paint as soon as possible when it is dry.
6. Activate the Etching Primer by mixing it with an equal volume of Activator P273-5021 and allow to stand for 10 minutes.
7. Adjust the spraying viscosity of the mixture if necessary to 22-25 sec. BSB4 Cup by adding small quantities of Thinner 851-565; never add more Activator.
8. Apply by spray to a clean, dry surface in a thin uniform coat, rather than a thick heavy one which may impair adhesion.
9. Air dry for at least 15 minutes before applying undercoat by spray or for 2 hours before brush application. If required, these times can be shortened by force drying, this also gives increased hardness to the film.
10. Subsequent painting follows normal paintshop practice.
11. When wet flattening the subsequent paint layers take care not to rub through to the Etching Primer. If this does occur allow to dry out thoroughly, dry flat the area and spot in with Etching Primer.

