



DE LOREAN MOTOR CARS OF AMERICA
Division of DeLorean Motor Company

SERVICE BULLETIN

NUMBER ST-02-2/82

CATEGORY: TECHNICAL
ATTENTION: ALL DMC DEALERS/SERVICE MANAGERS
SUBJECT: PAINTING OF STAINLESS STEEL BODY PANELS

Much interest has been expressed recently in painting the stainless steel body panels of the De Lorean automobile. In an effort to assist our dealers, De Lorean Motor Company has obtained the paint procedures, including materials specifications, recommended by three major suppliers of automotive paints. These processes, according to the paint suppliers, have been tested and found acceptable by the companies involved. We will supply you with test data when available. Dealers are strongly advised to contact the local distributor or representative of the specific paint brand to be utilized before proceeding with any paint work. The local agents may be able to provide assistance, answer questions, and clarify what warranty, if any, may be available from each specific supplier.

While De Lorean Motor Company has test painted three vehicles which are very attractive, we have not yet completed adhesion or durability tests. De Lorean Motor Company therefore makes no specific recommendation with regard to the advisability of painting the stainless steel, or to the process and materials for such painting. In addition, De Lorean Motor Company does not offer a paint warranty, except as contained in the published new car warranty applying to those painted components which are standard on production vehicles. Consequential damage to dealer supplied paint resulting from the failure of a warranted component is not covered under the De Lorean warranty.

The attachments to this bulletin are the painting processes as described above.

Continued

Issued 2/1/82

Road Wheels

Since the road wheels have a color coating that is impregnated into the surface as part of the heat treatment used to temper the alloy, with an epoxy clear coat applied over that, the adhesion of another color coat will be difficult to achieve even with careful preparation. Again, it is suggested that you consult with your local paint distributor before proceeding.

Front and Rear Facias

Facias may be refinished to match body colors applied. See our Service Bulletin ST-13-9/81, or consult your local paint distributor.

William A. Charles
Director, Service/Parts

WAC:ak

Attachments

The Sherwin-Williams Company
1550 So. Anaheim Blvd.
Anaheim, Calif. 92805

January 19, 1982

Dear Mr. Charles:

Per your request you will find our recommendations for Delorean-Stainless.

1. Detergent wash with QUICK SLICK Detergent solution, W4 K 290.
2. Solvent wipe with SHER-WILL-CLEAN, R7 K 156.
3. Apply 2 wet coats of Wash Primer, E2 G 973, per instructions.
4. Apply 2 or more medium coats of Ultra Fill Primer Surfacer.
5. Topcoat with Acrylic Lacquer.

If you have any questions or would like any assistance regarding this matter, please do not hesitate to contact me.

Sincerely,

W. A. Patterson

PPG INDUSTRIES, INC./3800 WEST 143RD STREET/CLEVELAND, OHIO 44111/AREA 216/671-0050

Andrew R. Cooper, Technical Manager
Ditzler Automotive Finishes
Coatings and Resins Division

January 5, 1982

Doyle Potter
Technical Training Manager
2055 South East Main Street
Ervine, California 92714

In response to our phone conversation, I have outlined below the Ditzler painting system that will be presented to Mr. DeLorean. Panels representing the performance properties of this system are also being submitted.

1. Thoroughly clean surface to be painted with DX200 Wax and Grease Remover and Scotch-Brite pads.
2. Apply 2 full wet coats of DP40 Epoxy Chromate primer mixed with equal parts of DP401 Primer Catalyst. A flash time of 20-30 minutes between coats of primer is recommended.
3. After primer has air dried for 2 hours, apply 2 or 3 double coats of Deltron Acrylic Urethane color catalyzed and reduced per label instructions.
4. If desired the color coat can then be clear coated using DAU82 Deigio Acrylic Urethane clear. Follow label instructions and necessary dry times. The use of the clear will provide the ultimate in gloss and long term durability.

For further information on the individual products please contact our area representative Mr. Ramiro Fernandez or me.

A.R. Cooper
Technical Manager

ARC:sv

DuPont Refinish System
For DeLorean Motor Company

Following are the recommended procedures for refinishing with DuPont's Imron® polyurethane enamel. As certain components of the products represent a health hazard, included are safety precautions and procedures. Equipment chosen should meet OSHA, NIOSH and MESA standards.

5717-S Metal Conditioner (Safety)

WARNING! CAUSES IRRITATION. Contains phosphoric acid. Avoid contact with skin and eyes. Avoid prolonged or repeated breathing of vapor. Wash thoroughly after handling. In case of contact, immediately flush eyes with plenty of water for at least 15 minutes; call a physician. Flush skin with water. To avoid skin contact, the use of rubber gloves is suggested.

224-S Steel Conversion Coating (Safety)

DANGER! STRONG OXIDIZER. CONTACT WITH OTHER MATERIAL MAY CAUSE FIRE. HARMFUL IF SWALLOWED. CAUSES IRRITATION. Contains phosphoric acid and bromates. Keep from contact with clothing and other combustible materials. Do not store near combustible materials. Avoid breathing mist and contact with skin and eyes. Wash thoroughly after handling. Keep container closed. In case of contact, immediately flush eyes with plenty of water for at least 15 minutes; call a physician. Flush skin with water. If swallowed, dilute by giving several glasses of water or milk. If vomiting occurs spontaneously, repeat several times. Call a physician. USE WITH ADEQUATE VENTILATION. KEEP OUT OF REACH OF CHILDREN.

824-S Light Gray
Corlar® Epoxy Primer (Safety)

WARNING! FLAMMABLE. BREATHING OF VAPOR MAY CAUSE IRRITATION. Contains glycol ether solvents. Keep away from heat, sparks and open flame. Avoid prolonged or repeated breathing of vapor or spray mist. Avoid contact with eyes and skin. Keep container closed when not in use.

USE ONLY WITH ADEQUATE VENTILATION. KEEP OUT OF THE REACH OF CHILDREN

FIRST AID: In case of skin contact, flush with plenty of water; for eyes, immediately flush with plenty of water for 15 minutes and get medical attention. If affected by inhalation of vapor, remove to fresh air. If swallowed, CALL A PHYSICIAN IMMEDIATELY. DO NOT induce vomiting.

Imron® Polyurethane Enamel (Safety)

WARNING! FLAMMABLE. Keep away from heat, sparks, and open flame. Avoid breathing vapor of spray mist and prolonged contact with skin. Wash thoroughly after handling. Keep container closed. Use with adequate ventilation. IMPORTANT: When mixing with 192-S mixture will have hazards of both components. Observe all applicable label precautions.

WARNING! CONTAINS LEAD. Dried films of this paint may be harmful if eaten or chewed.

Imron® Polyurethane Enamel System - Procedures

3812-S Enamel Reducer

Clean the metal to remove oil, grease and other contaminants. Using a clean cloth apply 3812-S Reducer to the surface. While the surface is still wet, fold a second clean cloth and wipe dry. Work small areas two to three square feet, wetting the surface liberally.

5717-S Metal Conditioner

Metal treatment dissolves rust & corrosion and etches the metal for better adhesion of finishing materials. Mix the cleaner with two parts of water in a plastic bucket. Wearing rubber gloves apply with a cloth or sponge. Work the area with a "Scotch-Brite" or similar abrasive pad. While the surface is still wet wipe it dry with a clean cloth.

224-S Conversion Coating

Steel Conversion Coating produces a high degree of corrosion resistance & optimum adhesion of paint system. Pour the material in a plastic bucket. Wearing rubber gloves use a "Scotch-Brite" or similar adhesive pad to apply the undiluted material to the treated metal surface.

Leave the conditioner on the surface two to five minutes. Work only as much area as can be coated and rinsed before the solution dries. Reapply if the surface dries before the rinsing. Flush the coating from the surface with cold water or mop with a damp sponge or cloth rinsed occasionally in clean water. Wipe dry with a clean cloth & allow to air dry. 224-S will impart a gray color to the steel.

824-S Light Gray Corlar® Epoxy Primer (Two-package product)

Offers excellent adhesion and flexibility over various substrates. Mix two parts of Corlar® with one part of 826-S activator. Allow to stand for an induction period of one hour if temperature is between 70°F and 90°F or two hours if temperature is between 55°F and 70°F. Do not use Corlar® if shop temperature is below 55°F. Reduce activated material up to 15% with 3602-S thinner. Spray one full wet coat to give a dry film thickness of 0.7 to 1 mil. Allow to dry 2-6 hours or overnight before topcoat application.

Imron® Polyurethane Enamel

A high-gloss, extremely durable, chemical & solvent resistant, air-dry material both in solid and metallic colors.

Mix three parts Imron® Polyurethane Enamel with 1 part 192-S Activator, 189-S Accelerator can be added (4 oz/gal) to increase drying rate. For spraying large areas material may be reduced further with 8485-S Imron® Reducer or 3979-S Retarder. 259-S Imron® Additive may be added (1 to 2 oz/gal) only if fish-eyes occur. Do not mix more material than will be used in a eight-hour period. Pot life of mixture is eight hours at 70°F.

Application of Solid Colors

With siphon equipment, use 50 pounds pressure at the gun. Spray a medium first coat. Allow to tack up and follow with a second coat.

With pressure pot, use 60-75 pounds of pressure at the gun and a fluid delivery rate of 12-20 ounces per minute.

Application of Metallics

With siphon equipment, use 65 pounds pressure and apply a light medium coat as a tack coat. Allow to set up 20 minutes, then apply a second light medium coat. Reduce remaining material 15% with 8485-S (17-18 seconds DuPont Viscosity Cup or #2 Zahn Cup) and apply a third light medium coat. If desired, another light medium coat of a reduced material may be used. Metallics can be clear coated with 500-S Clear following label directions.

With pressure pot equipment, use 65-75 pounds at the gun and a fluid delivery rate of 8-14 ounces per minute.

Both solid and metallic colors can be clear coated with Imron® 500-S Clear.

500-S Imron® Clear (Optional)

Offers high gloss, chemical resistance and durability of Imron®

Mix 3 parts of clear with one part of 192-S activator. Mix thoroughly and, if faster tape-free time is desired, add 189-S Accelerator at rate of four oz. per gallon. Mix no more material than will be used in an eight-hour period. Pot life of mixture is eight hours at 70°F. Following mixing, strain material. No further reduction is necessary for application. If desired, material may be further reduced with DuPont 3979-S Retarder. Check viscosity every four hours and reduce if necessary. Spray viscosity should be 18-22 seconds (#2 Zahn cup).

Allow Imron® color to dry overnight. Spray one medium coat. Allow to tack up and follow with a full second coat. A third coat may be applied if desired.

All information and recommendations are based on data which DuPont believes to be reliable. However, such information and recommendations are implemented and used by persons at their own discretion and risk.