

## TSB-90-15-3

### FORD:

1985-90 CROWN VICTORIA, ESCORT, MUSTANG, TEMPO, THUNDERBIRD  
1986-90 TAURUS  
1988-90 FESTIVA, PROBE

### LINCOLN-MERCURY:

1985-90 CONTINENTAL, COUGAR, GRAND MARQUIS, MARK VII, TOPAZ, TOWN CAR  
1986-90 SABLE  
1987-90 TRACER

### LIGHT TRUCK:

1985-90 BRONCO II, BRONCO, ECONOLINE, F-150, F-250, F-350, RANGER  
1988-90 F SUPER DUTY

### ISSUE:

A service repair procedure has been developed to restore damaged factory-applied lower body stone protection vinyl material.

### ACTION:

If service is required, use the following procedure to restore damaged lower body stone protected areas.

This abrasion resistant coating material (D9AZ-19515-A) is primarily for repair of factory-applied protective coatings. However, this material may also be installed on previously unprotected vehicles.

If the vehicle has body damage in the area of the factory-applied coating, body damage must be repaired before repairing the protective coating.

### WARNING:

WHENEVER USING PAINT, SOLVENT, REFINISHING OR RECONDITIONING MATERIALS, WEAR A NOSE OR FACE MASK, PLUS HAVE ADEQUATE VENTILATION IN THE WORK AREA.

### LARGE REPAIR AREAS

A large repair area, resulting from peeling or damage, will require removal of the factory-applied vinyl coating.

### NOTE:

WHERE SHEET METAL IS DAMAGED TO THE EXTENT THAT A FENDER, DOOR OR QUARTER PANEL REPLACEMENT IS REQUIRED, (OR IN AN INITIAL INSTALLATION), SKIP STEPS #1 - 3.

1. Use a heat gun or lamp to soften the vinyl coating until it is pliable.
2. Scrape off the softened vinyl with a putty knife or similar tool. If necessary, sand off any hard-to-remove vinyl coating using an orbital disc sander (#80 Disc).

### NOTE:

THE REPAIR MATERIAL, ABRASION RESISTANT COATING (D9AZ-19515-Z), IS NOT SUITABLE FOR "SPOT" REPAIRS. THE OLD COATING MUST BE REMOVED COMPLETELY FROM EACH DAMAGED PANEL.

3. Make the necessary repairs to the sheet metal.

#### COATING PREPARATION AND APPLICATIONS:

The abrasion resistant coating is available in quart cans. About two quarts will be required for an initial installation on a passenger car similar to a factory-applied system. Slightly more will be required for a larger vehicle such as an Econoline.

The specified dry film thickness of 15 to 20 mils (.015 to .020" ) will require at least three or possibly four applications of coating material, with flash off time allowed between coats. As with painting, spray coat the complete lower panel.

The adherence of this coating to properly prepared sheet metal is excellent and it is not necessary to prime the repaired sheet metal. However, adhesion will be adversely affected unless the sheet metal (either repaired or new) is prepared in accordance with the following procedure.

#### COATING PREPARATION - MASKING CAR

1. Install covers over the wheels.
2. Determine the area to be coated.
  - If the vehicle has lower body side mouldings (12-14" above the "turn under" of the rocker Panel), the moulding can serve as the upper margin of the area to be coated.
  - If the vehicle does not have suitable mouldings, a sculpture or break line in the sheet metal can be used.
  - The method used in masking off the upper coating margin line will depend on the presence or absence of mouldings in this area.

#### VEHICLES WITH SIDE MOULDINGS

3. Position the masking tape so that the moulding lower side is covered down to, but not on the sheet metal.

#### VEHICLES WITHOUT SIDE MOULDINGS

4. If the contour of the body side has a break line, or if an arbitrary line is chosen, mask off the upper coating margin using Scotch "Fine Line" tape. This is available nationally from 3M Company Distributors.
  - a. Apply the normal masking tape and paper protection for the vehicle body side first. Position them about a 1/4" above the margin line.
  - b. Apply the "Fine Line" tape over the regular masking tape with the lower edge at the upper coating margin line.
  - c. Extend this "Fine Line" tape into the wheel opening, in absence of wheel opening mouldings, to allow the flange to be coated.
  - d. Since the protective coating does not adhere well to flexible plastic stone shields, mask off the front of the plastic rear stone shield, if exposed.

**NOTE:**

IT IS NOT NECESSARY TO MASK OFF THE BODY DOOR OPENINGS IN THE COATING AREA BECAUSE THEY WILL BE UNIFORMLY COATED WHERE THE DOOR MARGINS ALLOW THE COATING TO ENTER. HOWEVER, THESE DOOR OPENING AREAS SHOULD BE CLEANED TO ASSURE COATING ADHERENCE.

**COATING PREPARATION - SHEET METAL**

**REPAIRED SHEET METAL**

1. Using a clean lint-free cloth, solvent wipe the area to be coated with a silicone and wax remover and allow to flash off.
2. Scuff sand (#180 Grit Paper) the glossy surface of the painted areas to be coated.
3. Remove sanding dust using a lint-free tack cloth and compressed air.

**NEW SHEET METAL**

1. Using a clean lint-free cloth, solvent wipe the area to be coated with a silicone and wax remover and allow to flash off.
2. Scuff sand (#180 Grit Paper) the prime paint in the area to be coated.
3. Remove sanding dust using a lint-free tack cloth and compressed air.

**INITIAL INSTALLATION**

1. Using a clean lint-free cloth, solvent wipe the area to be coated with a silicone and wax remover.
2. Sand the glossy surface of the paint in the coating area. (A D/A sander, 220/240 Grit Disc does a good fast job.)

**CAUTION:**

DO NOT SAND THROUGH THE COLOR COAT INTO THE PRIMER.

3. Remove sanding dust using a lint-free tack cloth and compressed air.

**COATING APPLICATION**

Coating applications must be applied with care.

- I The coating must be applied with commercial equipment by an experienced automotive painter.
- I The coating must be thoroughly agitated and used without thinning.
- I Since the material is reasonably heavy-bodied, a pressure cup equipped spray gun is recommended.

Satisfactory coating appearance (orange peel) will result with gun pressure of approximately 30 P.S.I. and cup pressures of approximately 15 P.S.I.

#### SPRAY PROCEDURE

Since the lower exposed painted fender, rocker and quarter panel down flanges are to be coated, the vehicle should be elevated high enough so that the painter can spray this area effectively. When an initial installation is to be made, a remote, two-quart capacity pressure cup makes a much more efficient tool because the spray gun can be used closer to the floor.

The spray gun, fluid hose and cup must be cleaned immediately after use. While lacquer thinner may be used when the suggested clean up material is unavailable, the Ford Vinyl Paint Pre-cleaner (VC-542-A) is quicker and much more efficient.

With the spray gun at 30 P.S.I. and pressure feed cup at 15 P.S.I. proceed as follows:

1. Apply a wet, sag-free coat. Allow 3 to 5 minutes flash off.
  2. Apply a second wet, sag-free coat. Allow 3 to 5 minutes flash off.
  3. Apply a third wet, sag-free coat. Allow 3 to 5 minutes flash off.
  4. Apply a final wet, sag-free coat. Allow 3 to 5 minutes flash off. Pull off the "Fine Line" tape, exposing the raw upper edge of the coating.
  5. Immediately clean the spray equipment using Ford Vinyl Paint Pre-cleaner (VC-542-A) or equivalent.
  6. Air drying time depends on the refinishing materials that are used.
- If you refinish with acrylic lacquer, allow one hour for drying (at 70°F).
  - If you refinish with acrylic enamel, allow two hours for drying (at 70°F).

#### COLOR COAT

In order to paint the entire coated area as well as the upper raw edge, mask off the upper margin line using the "Fine Line" tape. Position the tape 1/16" above the coating edge. The protective coating area can now be finish painted.

#### NOTE:

IF DAMAGED SHEET METAL EXTENDS ABOVE THE PROTECTIVE COATING AREA, NORMAL PRIME/COLOR PAINT PROCEDURES SHOULD BE FOLLOWED.

#### SUGGESTED EQUIPMENT

- DeVilbiss - Spray Gun - Model JGA-502-704-FX or equivalent
- DeVilbiss - Remote Pressure Cup - Model KB-520 (2 Quarts), Model KB-521 (1 Quart) or equivalent

- Binks - Spray Gun - Model 62 (#63 Air Cap, #SS Fluid Tip, #363 AN Needle)
- Binks - Attached Pressure Cup - Model 80 (1 Quart, with Air Adjusting Gage) or equivalent.

3	PART NUMBER	3	PART NAME	3	CLASS	3
3	D9AZ-19515-A	3	Abrasion Resistant Coating	3	C	3
3	VC-542-A	3	Vinyl Paint PreCleaner	3	C	3
3	Obtain Locally	3	Scotch "Fine Line" Tape (3M Part #06303-1/2" x 60 yards)	3	-	3
3	Obtain Locally	3	Silicone & Wax Remover	3	-	3

OTHER APPLICABLE ARTICLES: NONE

WARRANTY STATUS: INFORMATION ONLY