

## Paint and Decals

### Paint Repair

#### **! CAUTION**

Utilimaster recommends that a professional body shop do all paint repairs. The service technician should read this entire procedure before working on the vehicle.

Adequate ventilation is required when working in a confined area with paint and paint-related chemicals.

Always wear proper protective equipment when appropriate for the process.

Safety and application instructions provided with sealants, adhesives, and other products should always supersede information provided by Utilimaster.

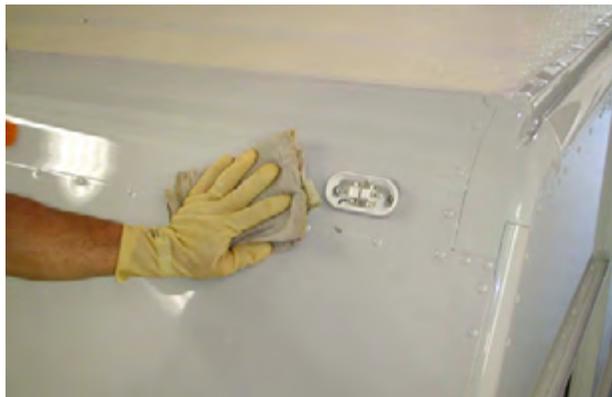
#### **NOTICE**

Make sure the area cleaned is bigger than the spray area. Mix paint thoroughly to ensure proper application and paint performance. Clear nozzle before spraying.

This procedure applies to aluminum surfaces, RIM hood material, and fiberglass hood material.

### Substrate Preparation

1. If necessary, follow the procedure in the Decals section to remove any decals from the affected area.
2. Use a clean rag soaked in isopropyl alcohol to clean the repair area and the area surrounding the repair. Use a second clean dry rag, wipe off the isopropyl alcohol before it evaporates. If the isopropyl alcohol dries before it is removed, re-wet and wipe dry.



*Use isopropyl alcohol as a cleaner*

3. Sand the defective area with 320-grit sand paper.

## **NOTICE**

If necessary, use a finer (400-grit) sandpaper to smooth the blend area surrounding the repair area.

4. Repeat cleaning with a clean rag soaked in isopropyl alcohol to remove sanding dust (see step 2).
5. Mask all fixtures (lights, grille, bumper, etc.) to protect from over spray.

## **NOTICE**

Use masking tape and a paper that cannot be penetrated by paint.

6. Wipe a wide area with the tack cloth to make sure all areas to be sprayed are clear of dust and debris.
7. If the base or substrate is exposed by sanding, apply epoxy sealer (Sherwin Williams E2A960P) and catalyst (Sherwin Williams V6V965).



*Sand area to be prepared*



*Protect with masking tape and oil paper*



*Use tack cloth for final wipe*

## RIM Fender Painting Preparation

### CAUTION

Always wear proper protective equipment when appropriate for the process.

Safety and application instructions provided with sealants, adhesives, and other products should always supersede information provided by Utilimaster.

Use the following painting preparation procedure before or after installation.

8. Use a pump sprayer to apply isopropyl alcohol over a 2-foot square area at a time.
9. Use a clean, dry cloth to wipe off isopropyl alcohol **before** it evaporates.

### NOTICE

If drying occurs, repeat application. If any residue is still present, **REWASH** using the same procedure.

10. Sand all areas to be primed and painted with 320 or 400 sandpaper using a dual action (DA) orbital sander or by hand.
11. Use a 3M Red Scotch-Brite Hand Pad 7447 (or equivalent) for hard-to-reach areas. Remove all gloss from the part during the sanding process.
12. Use compressed air to blow off dust from fender starting at the top of the part.
13. Repeat cleaning with pump sprayer and isopropyl alcohol.
14. Use a clean, dry cloth to wipe off isopropyl alcohol before it evaporates
15. Inspect fender for shiny areas and repeat process if necessary.

### NOTICE

Sanding to a dull finish is critical to paint adhesions. Failure to sand properly will result in adhesion loss.

Use masking tape and a paper that cannot be penetrated by paint.

Paint fender as soon as possible. A delay in painting allows the release agent on the fender to come to the surface.

16. Mask all fixtures (lights, grille, bumper, etc.) to protect from overspray.

## Paint Preparation

1. Use a graduated (9-ounce) measuring cup to pour 3 ounces paint (Sherwin Williams Genesis M) to 1 ounce catalyst (Sherwin Williams GH 1093).
2. Add 1/8 ounce of accelerator (Sherwin Williams GA 1098 gallon can) to the paint mixture.
3. Use a paint stick to stir paint mixture thoroughly.
4. Place the paint strainer in the touch-up gun cup and pour the paint through the strainer.



*Three ounces of paint*



*One ounce of catalyst*



*Add accelerator*



*Stir well*

5. Reassemble the touch-up gun.
6. Check the blender gun to make sure it has sufficient blended (Sherwin Williams ES20 and BS10 solvent).



*Use paint strainer*

## Paint Application

1. Use a touch-up gun containing Sherwin Williams Genesis M paint to do a test spray directed away from the vehicle to make sure the touch-up gun nozzle is clear.
2. Apply the first coat of paint.
3. Air dry for 1 to 2 minutes.
4. Using the blender gun with Sherwin Williams ES20 and BS10 blender, do a test spray directed away from the vehicle to make sure the blender nozzle is clear.
5. Apply a first coat of blender.
6. Air dry for 1 to 2 minutes.
7. Apply a second coat of paint, covering an area just beyond the first coat of color.
8. Air dry for 1 to 2 minutes.
9. Apply the final coat of blender, extending just beyond the previous spray patterns.
10. Air dry 1 hour before removing masking materials.
11. If the repair is not glossy enough after drying, use buffing compound and buff to achieve the desired appearance.



*Apply paint*



*Apply blender*



*Air dry 3 to 4 hours*

## **Decals**

### **Removal**

1. Use a heat gun to soften the adhesive under the decal.
2. With a razor knife, carefully peel the edge back.
3. Continue to heat evenly while manually pulling the decal off.

### **Installation**

1. Before reapplying decals over repaired paint, wait 24 hours for nonreflective decals or 72 hours for reflective decals.
2. Clean the surface with isopropyl alcohol.
3. Align the decal into position.
4. Smooth the decal from the center to the edges.
5. Squeegee the edges to ensure a proper seal.

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