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## 2. Color matching / Preparation / Paint Booth Use Time

Type of Topcoat	Number of Layers	Number of outer panels					Extra specification Poor Hiding color
		1 panel	2 panels	3 panels	4 panels	5 panels or more	
Solid	1-coat	2.2	2.2	2.2	2.2	2.2	+0.3
	2-coat	2.3	2.3	2.3	2.3	2.3	
Metallic		2.7	2.8	2.9	3.1	3.2	
2-coat Pearl		2.7	2.8	2.9	3.1	3.2	
3-coat Pearl	3-coat	3.7	4.0	4.3	4.5	4.8	

The number of panels refer to the number of outer panel which the color base coat is applied to.

Note : Painting only the bumper cover, don't use this table.

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## 3. Bumper Cover Painting Time

Item			Replacement	Deformation Repair	Scratch Repair		Color matching
	Type of Topcoat	number of Layers			Large (21-35cm)	Small (10-20cm)	
Front	Solid	1-coat	2.1	3.9	3.2	3.0	+0.4
		2-coat	2.2	4.0	3.3	3.1	+0.4
	Metallic		2.3	4.1	3.4	3.2	+0.5
	2-coat Pearl		2.3	4.1	3.4	3.2	+0.5
	3-coat Pearl	3-coat	2.5	4.4	3.7	3.4	+0.7
Rear	Solid	1-coat	2.1	3.9	3.2	3.0	+0.4
		2-coat	2.2	4.0	3.3	3.1	+0.4
	Metallic		2.3	4.1	3.4	3.2	+0.5
	2-coat Pearl		2.3	4.1	3.4	3.2	+0.5
	3-coat Pearl	3-coat	2.5	4.4	3.7	3.4	+0.7

Deformation repair includes putty repair for a damaged length of approx. 21cm.

Scratch repair includes putty repair. **Large** : 21-35cm in length **Small** : 10-20cm in length

Color matching : When painting only bumper cover, add color matching time only once.

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## 1. External Panel Painting Time

## 1) Application Time

No.	Panel Name	area (dm <sup>2</sup> )	Repair method														
			Replacement						Repair								
			New part		Extra specification		Extra work Rustproof Sealant	1/1 paint		1/2 paint		1/3 paint		Extra specification		Extra work	
Multiple	Single	Poor hiding color	2-coat Solid	0.1 / part	Multiple	Single	Multiple	Single	Multiple	Single	Poor Hiding color	2-coat Solid	0.1 / 1m	0.1 / part			
1	Hood Sub Assy	174	2.6	3.4	+0.4	+0.1	+0.1	4.4	4.8	3.2	3.6	2.6	3.0	+0.3	+0.1	+0.1	—
2	Fender Sub Assy Front	43	1.5	2.0	+0.4	+0.1	—	2.3	2.7	1.7	2.1	1.6	2.0	+0.3	+0.1	—	—
3	Front Door Panel Sub Assy	91	2.2	2.9	+0.4	+0.1	+0.1	3.3	3.7	2.3	2.7	2.0	2.4	+0.3	+0.1	+0.1	+0.1
4	Rear Door Panel Sub Assy	88	2.1	2.8	+0.4	+0.1	+0.1	3.3	3.7	2.3	2.7	1.9	2.3	+0.3	+0.1	+0.1	+0.1
5	Quarter Panel *1	104	3.1	3.8	+0.4	+0.1	—	3.5	3.9	2.5	2.9	2.0	2.4	+0.3	+0.1	+0.1	—
6	Back Door Panel Sub-Assy	123	2.6	3.5	+0.4	+0.1	+0.1	3.8	4.2	2.7	3.1	2.2	2.6	+0.3	+0.1	+0.1	+0.1
7	Body Lower Back Panel Sub Assy	20	1.5	1.9	+0.4	+0.1	—	1.7	2.1	1.4	1.8	1.4	1.8	+0.3	+0.1	+0.1	—
8	Roof Panel *2	304	4.9	6.4	+0.7	+0.3	—	5.8	6.2	4.4	4.8	3.6	4.0	+0.6	+0.3	+0.1	—
9	Rocker Panel Outer	25	1.6	1.8	+0.4	+0.1	—	1.5	1.9	1.5	1.9	1.5	1.9	+0.3	+0.1	—	—

Replacement Panel : includes surface preparation and applying body sealant.

Repair Panel : includes surface preparation.

\*1:(incl.) Back Door Opening Side Frame Sub-Assy

\*1:(incl.) Roof Side Rail Outer

1/1, 1/2, 1/3 are the proportions of the panel surface that the base coat is applied to.

Note: For spot panels, the replacement includes refinishing of the related areas.

## 2) Blending Time

## ③ Blending time

Type of Topcoat	Time
Metallic 2-coat paint	1.0
3-coat paint	1.1

This work time can be added only once, when blending is required during repair.

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