



Important!

Please give copies to all
your VW Technicians

Technical Bulletin

Subject: "Klavierlack" Paint, Application Instructions

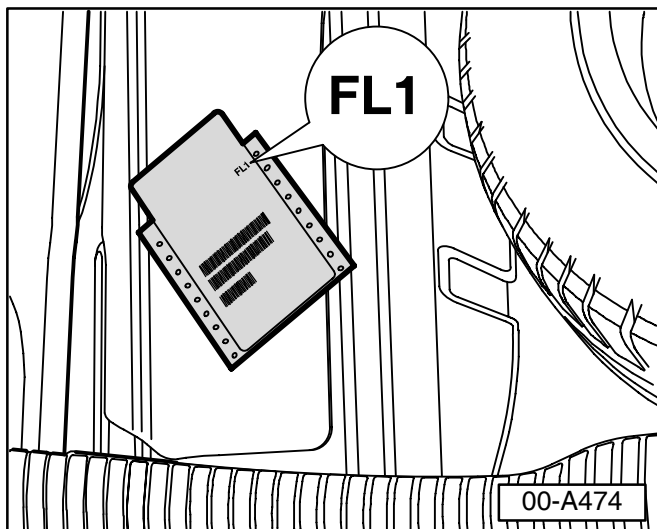
Group: 50

Number: 04-02

Model(s): Phaeton

2004

Date: Jan. 29, 2004



Service

When refinishing a vehicle with "Klavierlack" (Piano Finish) high gloss finish paint:

- ◆ "Klavierlak" paint finish is an additional option identified by "FL1" after the paint code on the vehicle data sticker (located in the trunk of the vehicle as shown).

- Use instructions provided by the manufacturer of the system you are using.

- ◆ Attached are three approved systems

For questions or technical support regarding these products or their instruction sets:

- Contact the Manufacturer at the following:

- Spies Hecker <http://www.spieshecker.com/>
Tel.: 1-888-371-3313
- Standex <http://www.standex.com/>
Tel.: 1-800-551-9296
- DuPont <http://www1.dupont.com/NASApp/dupontglobal/corp/index.jsp>
Tel.: 1-800-438-3876

For questions or technical support regarding other approved systems or their instruction sets:

- Contact the manufacturer of that system.

01/01/2004

Refinish System for the VW Phaeton

This system data sheet describes the refinish system for the body of the Phaeton, which is made of galvanized steel, aluminum, and PUR plastic. It explains the correct procedure to repair the standard finish and piano finish on the Phaeton.

- I. Primer*** Apply Priomat® Wash Primer 4075 transparent (only on areas which have been sanded through to bare metal). For notes on application, please refer to Technical Data Sheet No. 300.7. For plastic parts, see Plastic System Chart No. L3009
- II. Surfacer**** Then apply:
 Permacron® Vario Surfacer 8590 gray. Mix with Permasolid® HS Hardener. For notes on application, please refer to Technical Data Sheet No. 988.3.
OR
 Permasolid® HS Premium Surfacer 5310. Mix with Permasolid® HS Hardener. For notes on application please refer to Technical Data Sheet No. 341.3.
OR (California)
 Permasolid® 2.1 Surfacer 5155. Mix with Permacron® Hardener 3193, 3195, 3197, or 3199. For notes on application, please refer to Technical Data Sheet No. 341.4
- III. Permacron^o**
Base Coat Series 293/295 Apply Permacron® Base Coat Series 293/295. For notes on application, please refer to the respective Technical Data Sheet No. 970.10, 970.13.
OR
Permahyd® Base Coat Series 280/285 Apply Permahyd® Base Coat Series 280/285. For notes on application, please refer to the respective Technical Data Sheet No. 100.0, 100.1.
- IV. Clear Coat**** Apply 2 coats (approximately 45-50 microns) of Permasolid® HS Clear Coat 8030. Mix with Permasolid® HS Hardeners. For notes on the application, please refer to Technical Data Sheet No. 110.8
OR (California)
 Apply 2 coats (approximately 45-50 microns) of Permacron® 2.1 Clear Coat 8095. Mix with Mix with Permacron® Hardener 3193, 3195, 3197, or 3199.. For notes on application, please refer to Technical Data Sheet No. 111.8.
- V. Piano Finish** Sand with P1200 grade dry sand paper, or P1500 wet sand paper. Sand out all dirt nibs and imperfections. Apply 2 more coats (approximately 45-50 microns) of the same clear coat used in step IV.

*Substrate preparation procedures must be followed, see Technical Data Sheet No. 300.7.

**Permasolid® Elastic additive 9050 must be used in surfacer and clear coat for plastic parts. See Technical Data Sheet 640.0

VR Technical Data Sheet No. 902.2/04/2003-GB

STANDOX® Refinishing System for the VW Phaeton

This technical data supplement outlines the refinish procedures for the body of the Phaeton, which is made of galvanized steel, aluminum and PUR plastic. It explains the procedures to repair the standard finish and piano finish on the Phaeton.

Step 1. Etch Primer

Apply Standex Etching Adhesion Primer (020 11158) (only to areas which have been sanded through to bare metal). For mixing and application, please refer to Technical Data Sheet 312.

Step 2.* Primer Surfacer

Apply Standex 2K Nonstop Primer Filler (020 15331). For mixing and application, please refer to Technical Data Sheet 535.

OR

Standex 2K HS System Filler (020 15161). For mixing and application please refer to Technical Data Sheet 548.

OR

Standex 2.1 Filler (020 11999). For mixing and application, please refer to Technical Data Sheet 545.

Step 3. Basecoat

Apply Standex Basecoat. For mixing and application, please refer to Technical Data Sheet 610.

OR

Apply Standohyd® Basecoat. For mixing and application, please refer to Technical Data Sheet 801.

Step 4. Clearcoat

Apply Standocryl® 2K HS Clear (020 12766 or 020 14580) - 2 coats (approximately 1.8-2.0 mil / 45-50 microns). For mixing and application, please refer to Technical Data Sheet 564.

OR (for California)

Apply Standocryl 2.1 Clear (020 10020) - 2 coats (approximately 1.8-2.0 mil / 45-50 microns). For mixing and application, please refer to Technical Data Sheet 577.

Step 5. Piano Finish

Sand with P1200 dry sand paper or P1500 wet sand paper. Sand out all dirt nibs and imperfections. Apply 2 more coats of the same Clearcoat used in Step 4 (approximately 1.8-2.0 mil / 45-50 microns).

*Standex 2K Plasticiser (020 15260) must be used in Primer Surfacer and Clearcoat for plastic parts. See important remarks on the appropriate Technical Data Sheet.

The logo consists of the word "STANDOX" in white, bold, sans-serif capital letters, centered within a blue rectangular background that has a slight wave or curve at the top and bottom edges.



Refinish System for the Volkswagen Phaeton

This system data sheet outlines the repair process for the Volkswagen Phaeton, which is comprised of galvanized steel, aluminum, and PUR plastic. Where appropriate options are given that direct the repair system to:

- a. VOC National Rule
- b. Low VOC for California
- c. Flexible Plastic Repairs

Use the DuPont ChromaSystem™ Technical Manual for detailed application data.

1) Primer

- a. Use DuPont™ ChromaPremier® 22860S™ Premier Etch Primer for use on areas sanded through to bare metal.
- b. Use DuPont™ ChromaPremier® CF-22860S™ Premier Etch Primer (Chrome Free) for use on areas sanded through to bare metal where regulations require.
- c. Use DuPont™ Plas-Stick® 2330S™ Plastic Adhesion Promoter direct to exposed plastic substrate.

2) Surfacers

- a. Use DuPont™ ChromaPremier® 32430S™ 2K Premier Primer.
- b. Use DuPont 3250S™ Primer.
- c. Use ChromaPremier® 32430S™ 2K Premier Primer with DuPont™ Plas-Stick® 2350S™ Flexible Additive or DuPont 3250S™ Primer with Plas-Stick® 2350S™ Flexible Additive.

3) Base Color

Use DuPont™ ChromaPremier® Basecoat activated with ChromaPremier® 12305S™.

4) Clear

- a. Use DuPont™ ChromaPremier® 72500S™ Premium Appearance Clear.
- b. Use DuPont™ ChromaClear® 2400S™ 2.1 VOC Clearcoat.
- c. Use ChromaPremier® 72500S™ Premium Appearance Clear with DuPont™ Plas-Stick® 2350S™ Flexible Additive or use ChromaClear® 2400S™ 2.1 VOC Clearcoat with DuPont™ Plas-Stick® 2350S™ Flexible Additive.

Note: For optimal appearance, use the clearcoats in a normal two-coat process and through cure. Sand with P1200 dry or P1500 wet to remove all dirt nibs, imperfections and texture. Apply two more coats and detail as required.

DuPont ChromaSystem™ Technical Manual Product List

DuPont™ ChromaPremier® 22860S™ Premier Etch Primer	H-19149	07/02
DuPont™ ChromaPremier® CF- 22860S™ Premier Etch Primer	H-1914x	02/04
DuPont™ ChromaPremier® 32430S™ 2K Premier Primer	H-19368	07/02
DuPont 3250S™ Primer	H-1903x	02/04
DuPont™ ChromaPremier® Basecoat	H-19315	06/02
DuPont™ ChromaPremier® 72500S™ Premium Appearance Clear	H-19366	10/02
DuPont ChromaClear® 2400S™ 2.1 VOC Clearcoat	H-19466	10/03
DuPont™ Plas-Stick® 2320S™ Plastic Cleaner	H-19352	05/02
DuPont™ Plas-Stick® 2330S™ Plastic Adhesion Promoter	H-19353	06/02
DuPont™ Plas-Stick® 2350S™ Flexible Additive	H-19287	04/03