

2017 COLLISION

Paint and Coatings - Bolt EV

INTRODUCTION

BASECOAT/CLEARCOAT PAINT SYSTEMS

WARNING: Exposure to isocyanates during paint preparation and application processes can cause severe breathing problems. Read and follow all of the instructions from the manufacturers of painting materials, equipment, and protective gear.

All paint finish repairs of rigid exterior surfaces must meet GM standards. Refer to the latest revision of the GM Approved Refinish Materials book to identify the paint systems you may use that have been engineered to meet GM standards. The GM Approved Refinish Materials book supplies all approved products, including volatile organic compound (VOC) compliant regulations recommended by the individual manufacturer, and detailed procedures for materials used in their paint system.

The latest revision of the GM Approved Refinish Materials booklet is located on the Genuine GM Parts website at www.genuinegmparts.com.

ANTI-CORROSION TREATMENT AND REPAIR

WARNING: When applying sound deadeners, or anti-corrosion materials due care and preventative measures must be exercised to prevent any material from being sprayed into door and quarter panel mechanisms such as door locks, window run channels, window regulators and seat belt retractors, as well as any moving or rotating mechanical or suspension parts on the underbody, particularly the parking brake cable. After material application, be sure that all body drain holes are open. Improper application may increase chance of corrosion damage or limit the operation of moving parts, resulting in personal injury.

Any procedure that disturbs these special treatments, such as panel replacement or collision damage repair operations, may leave the metal unprotected and result in corrosion. Proper recoating of these surfaces with service-type anti-corrosion material is essential.

After repair and/or replacement parts are installed, all accessible bare metal surfaces must be treated with metal conditioner and reprimed. Refer to the GM Approved Refinish Materials book which identifies the paint systems you may use.

The latest revision of the GM Approved Refinish Materials booklet is located on the Goodwrench website at www.gmgoodwrench.com.

Anti-corrosion compounds are light-bodied materials designed to penetrate between metal-to-metal surfaces, such as pinch-weld joints, hem flanges, and integral panel attaching points where metal surfaces are difficult to coat with conventional undercoating materials, and are inaccessible for painting. The materials that are suitable for interior and exterior are listed in the chart below. Conventional undercoating is recommended in order to coat large areas, such as replacement door and quarter outer panels, floor pan sections, lids, hoods, fenders, etc. During undercoating operations, care should be taken to prevent the material from being sprayed into door and quarter panel hardware mechanisms, such as door locks, window run channels, window regulators, and seat belt retractors. On the underbody, the material should not be applied to any moving or rotating part, energy absorbing bumper components, or shock absorbers. After undercoating, ensure that all body drain holes are open.

The following products are available from GM Dealer Equipment. For technical information, call 187-Permatex (1-877-376-2839):

Permatex Part Number	Description
310-JDI-UCA1	Permatex Canister and Wand Assembly
310-81881	Permatex Amber Rust Proofing (24 oz) (Qty of 12)
310-81882	Permatex Amber Rust Proofing (1 gal)

Exterior Protectants

The following product is available from *ECP, Inc. Contact them at 1-800-323-3521 or www.ecpinc.net.

Part Number	Description
178660	Nox Rust X-121B (12 cans per case)

The following products are available from your local *3M[®] distributor, or call 1-800-521-8180, ext. 779-5165.

3M [®] Part Number	Description
08804	Water-Based Undercoat
08801	No Clean-Up Applicator Gun
05917	Weld-Thru Coating
08891	Rust Fighter-I

The following product is available from *Transtar Autobody Technologies. Contact the company at 1-800-824-2843 or www.tat-co.com.

Part Number	Description
4353	Weld-Through Primer

*We believe these sources and their products to be reliable. There may be additional manufacturers of such material. General Motors does not endorse, indicate any preference for, or assume any responsibility for the products from these firms, or for any such items which may be available from other sources.

These sealers are intended to prevent water and dust from entering the vehicle and also are anti-corrosion barriers. Sealers are applied to such areas as rear compartment lid hem flanges, wheelhouse, quarter outer, floor, cowl, roof, and various other panel to panel attaching points. The originally sealed joints are obvious and any damage to these sealed locations should be corrected by resealing. Attaching points of new replacement panels should be resealed. Replacement lids and doors will also require sealing in the hem flange areas.

Flanged joints, overlap joints, and seams should be sealed using a quality sealer of medium-bodied consistency. The sealer used must retain its flexible characteristics after curing and be paintable.

Open joints which require bridging of the sealer in order to close a gap should be sealed using a heavy-bodied caulking material. Follow the label directions for the material selected.

Color application may be required in order to restore repaired areas such as hood, fenders, doors, quarters, lid, roof, engine compartment, underbody, and inner panels to original appearance. When this is necessary, conventional refinishing preparation, undercoat buildup, and color application techniques should be followed.

Deadener materials, spray-on type, are used on various metal panels in order to provide corrosion resistance and joint sealing. They control the general noise level inside the passenger area of the vehicle. When deadeners are disturbed because of damage, are removed during repair operations, or a new replacement panel is installed, the deadener material must be replaced by a service equivalent material. The application pattern and location of deadener materials can be determined by observing the original production installation.

Cleaning of the interior and underbody panel surfaces is necessary when original galvanized or other anti-corrosion materials have been burned off during welding or heating operations. Removal of the residue from burning will require additional care in such areas as interior surfaces of box-type construction and when configurations of the metal panels limit access to interior surfaces.

REPAIR INSTRUCTIONS

CLEARCOAT REPAIR WITHOUT REPAINTING

1. Thoroughly wash the repair area with Liquid Wash and Wax GM P/N 1052870 or the equivalent.
2. Environmental damage may be corrected. Refer to [Environmental Fallout \(Acid Rain\)](#), or [Rail Dust Damage Repair](#).

NOTE: Follow all of the instructions from the manufacturer of the polishing material.

3. Use a paint gauge before, during, and after sanding and/or polishing, to avoid removing too much clearcoat. Refer to [Paint Gauges](#).

ENVIRONMENTAL FALLOUT (ACID RAIN)

CAUTION: Refer to [Clearcoat/Ultraviolet Screeners Caution](#).

NOTE: Always refer to the manufacturer's packaged instructions for the detailed procedures of materials used for compounding and/or polishing.

Since the severity of the condition varies from area to area, proper diagnosis of the contamination extent is critical to the success of the repairs. Perform the diagnosis under high intensity fluorescent lighting on the horizontal surfaces (hood, roof panel, rear compartment lid), after the surfaces have been properly cleaned by washing the vehicle with GM Wash and Wax GM P/N 1237841 (Canadian P/N 10953203), or equivalent.

There are 3 basic types of acid rain damage:

Surface Level Contamination

May be repaired by simply washing the vehicle, cleaning the surface with a silicone wax and grease remover, neutralizing acidic residue, and finesse polishing. Refer to Surface Level Contamination Repair.

Clearcoat Etching

Slight etching is still noticeable after the above washing and finesse polishing procedure. Refer to Slight Clearcoat Damage - Wet Sanding, Finesse Polishing.

Basecoat Etching

Severe etching beyond the clearcoat into the basecoat in the affected areas will require refinishing. Refer to [Basecoat/Clearcoat Paint Systems](#).

Surface Level Contamination Repair

1. Thoroughly wash and dry the contaminated area with GM Wash and Wax GM P/N 1237841 (Canadian P/N 10953203), or equivalent.
2. Clean the affected area with silicone, wax and grease remover.
3. Remove and neutralize acidic residue by cleaning the contaminated areas with a mixture of baking soda and water (1 tablespoon of baking soda per 1 liter or 1 quart of water). Rinse thoroughly and dry the panel completely.
4. Apply finesse-type polish with a foam panel. If damage has been repaired, remove any swirl marks with a dual action orbital polisher and foam pad. cardiagn.com
5. If some damage remains, refer to Slight Clearcoat Damage - Wet Sanding, Finesse Polishing.

1. Select a small contaminated test area.
2. Film thickness should be taken prior to the sanding and polishing. Refer to [Paint Gauges](#).
3. Wet sand and finesse polish the contaminated test area. If during the polishing you suspect or observe that etching has penetrated into the basecoat, too much clearcoat has been removed during sanding, or base color is transferred to the polishing pad during polishing, then the affected areas will require refinishing. Refer to [Basecoat/Clearcoat Paint Systems](#).

PAINT GAUGES

Paint thickness gauges measure the total thickness of the vehicle finish. It is important to accurately measure the thickness of the finish on each vehicle as the thickness of the finish will vary on each vehicle. Use a paint gauge before the sanding process in order to accurately measure how much finish there is to remove before, during, and after the sanding process. Paint gauges range from magnetic pull type to sophisticated electronic types, and are available from a variety of sources. The older magnetic type gauges, at best have a 5 percent accuracy range and are not sensitive enough to detect removal of 0.02 mm 0.5 mil (0.0005 in) clearcoat. The newer type magnetic gauges have improved accuracy ranges. Most gauges are confined to checking either ferrous metal, steel, non-ferrous metal, or aluminum panel. At this time, there are no viable gauges for reading film thickness on composite (SCM doors, RIM fenders) panels. The more sophisticated electronic paint thickness gauges (ETG) digital type gauges are able to read film thickness on both ferrous and non-ferrous metal panel. Digital ETG gauges may have an accuracy range of 1 percent and include thickness standards for recalibration. The following paint thickness gauges are available. Call 1-800-GM-TOOLS for information:

Paint Thickness Gauges

- 147-5437-ETG Standard model
- 147-5437-ETG-P Standard model with print option
- 147-5437-N-ETG-N Non-ferrous model for aluminum panels
- 147-5437-NP-ETG-NP Non-ferrous model with print option
- 147-54437-SD-ETG Steel and aluminum gauge

CLEARCOAT THICKNESS

The clearcoat on the vehicle is typically 0.059 - 0.078 mm (1.5 - 2 mils [0.0015 - 0.0020 in]) thick. The clearcoat contains ultraviolet screeners. Removing more than 0.5 mils (0.019 in) of the clearcoat may result in early paint failure.

RAIL DUST DAMAGE REPAIR

WARNING: Refer to [Eye Protection Warning](#) .

NOTE: If rail dust has penetrated into the basecoat, the panel requires refinishing. Ensure all the rail dust has been removed prior to refinishing or the rust spots will return.

Rail dust damage comes from the tiny iron particles produced from the friction between the train wheels and the track. It can also be deposited on vehicles if stored near any operation producing iron dust (i.e., steel ore yards). This dust can either lay on top of, or embed into the paint surface. It is usually diagnosed as bumps in the paint surface or rust colored spots in the paint.

1. Move the vehicle to a cool shaded area and ensure the vehicle surfaces are cool during the removal process.
2. Thoroughly wash the repair area with Liquid Wash and Wax GM P/N 1052870, or equivalent.
3. Wipe the area dry.
4. Clean the affected area with silicone, wax and grease remover.
5. Perform the removal process according to the manufacturer's directions of the type of repair material used (Gel Type Oxalic Acid or Clay Type Non-Acid Based). If, upon inspection, some

particles are still present, the process may be repeated. If the damage has been repaired, complete the repair to the entire panel.

6. Polish the entire panel after the removal process. If small pits remain in the clearcoat after all of the damage has been repaired, refer to [**Clearcoat Repair without Repainting**](#).
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