

# CRIB COLLISION REPAIR INFORMATION

## BULLETIN FOR THE COLLISION REPAIR PROFESSIONAL

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<b>TITLE:</b>	<b>Carbon Fiber Panel Repairs</b>	<b>2016-189</b>
<b>SECTION:</b>	<b>Exterior</b>	<b>Page 1 of 3</b>
<b>APPLICABLE VEHICLES:</b>	<b>2015 – Lexus Models</b>	
<b>DATE:</b>	<b>February 2016</b>	

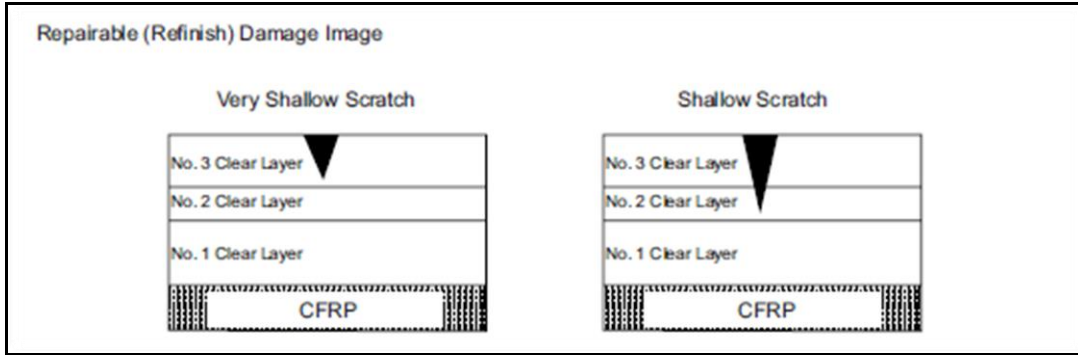
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### OPTIONAL CARBON FIBER PANELS

Carbon fiber panel 'scuff-and-buff' repairs are limited to those that can be removed with cosmetic sanding and polishing, not removing more than 13 microns (0.5 mil) of clear coat during this process. Refer to Collision Repair and Refinish course PLB101 for guidance on this type of repair. If excessive clear-coat is removed Ultra Violet (UV) exposure may degrade the finish causing a change in appearance.

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MANAGER AND COLLISION REPAIR TECHNICIANS**



Clear coat should be applied to level the finish and to provide UV protection if scratch repair requires removing more than 13 microns (0.5 mil) of clear coat during sanding operations. Clear coat sanding is limited to layers #3 and #2. Boundaries between layers may be difficult to determine visually so measuring the clear coat layers is an important step. No more than 50% of total clear coat thickness should be removed for carbon fiber clear coat refinish repairs.

NOTE: A specialized film thickness gauge is required to measure clear coat thickness on carbon fiber.

- The following is a description of the Carbon Fiber Clear Coat OE Finish Layers:

#3 Clear Layer	Weather and UV Resistance
#2 Clear Layer	Improvement of Coating Adhesion
#1 Clear Layer	Carbon Fiber sealing
Carbon Fiber Panel Base	

The first application of clear coat should be only to the scratch repair area that has been featheredged properly. Once dry the first clear coat should be sanded to level the finish, and for adhesion of final clear coat. Final clear coat should be applied to the entire carbon fiber panel to provide an even finish and undetectable repair.

The following 2K clear coats are recommended for carbon fiber clear coat refinish:

Sikkens	Autoclear Plus HS	Autoclear PC (National Rule)	Autoclear Superior 250 (Low VOC)
Cromax	3800S Chromaclear VOC	74500S DLC740 Productive Clear (National Rule)	Cromax Pro LE8300S Productive Clear (Low VOC)

Spies Hecker	Permasolid HS Optimum Plus Clear Coat 8650	Permacron MS Express Clear Coat 8046 (National Rule)	Permasolid Low VOC Clear Coat 8096 (Low VOC)
Stadox	Standocryl VOC Express Clear	Standocryl 2K Clear 15-60 Plus (National Rule)	Standocryl Clear PFC 20 (Low VOC)
Glasurit	923-447 HS Clear Scratch Resistant VOC	923-109 HS UV Karlack (National Rule)	923-209 Low VOC HS Karlack Clear (Low VOC)
RM	Crystalclear CP	DC5335 Glamour Clear (National Rule)	DC5995 Low VOC Glamour Clear (Low VOC)
PPG	D8122 Ceramiclear	D8126 Ceramiclear (National Rule)	D8126 Ceramiclear (Low VOC)
Nexa	P190-6512 2K SR Ceramiclear	P190-6490 Scratch Resistant Clear Coat (National Rule)	P190-6490 Scratch Resistant Clear Coat (Low VOC)
Sherwin Williams	1100755 / Elegance Clear Coat	1100755 / Elegance Clear Coat (National Rule)	1100755 / Elegance Clear Coat (Low VOC)