

Service-Information Motorcycle



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Service Department

Group: 99
Paint Work

March 1990
99 002 90
(2398)

For USA Only

Paint Application - Code 031 - Red Metallic

The Red Metallic color is one of the most difficult finishes to apply because the depth of the red color is determined by two factors:

1. The thickness/consistency of the Clear Coat application (more clear = deeper, darker red color)
2. The speed that the Clear Coat cures/dries (solvent penetration/faster drying = lighter color shade)

To aid you in achieving higher quality/consistency when spraying this color, please note the following recommendations:

1. Check the date code on the paint set. The hardener is the most sensitive component regarding shelf-life, so replace any shelf-expired hardener, which has turned amber/yellowish in color.
2. The other components in the paint set can often be used after the expiration recommendation, as long as they have been sealed tightly and the metallic products "rotated". (Flip the cans every few months to allow the metallic particles to drop to the other end of the can. This keeps the metallic particles from "seeding", producing blotches or "spit" from the spray gun).
3. BMW changed the formulation of the paint sets several years ago to reduce the vapor emissions of the paint when it dries. These new products are identified as MS products.

When using Acrylic Clear Coat Lacquer - MS, we suggest using Hardener-MS Slow. The slower curing time will allow the Clear Coat to achieve a deeper, darker red color.

For normal Acrylic Clear Coat Lacquer (2K Varnish), we recommend using normal speed hardener.

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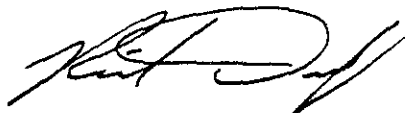
4. Use thinner of the speed appropriate to the ambient temperature and humidity.

Very truly yours,

BMW of North America, Inc.



Frank Stevens
National Service Manager
Motorcycle Group



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FS:je1/230.7