

# Port Rework



**Subject:**

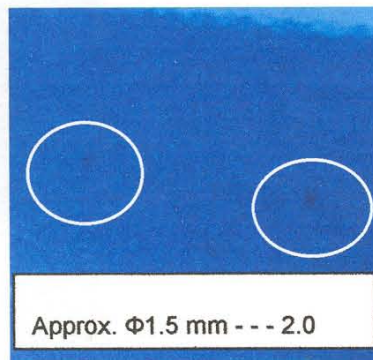
2002 Millenia & Protégé 5 exterior paint contamination.

**Description:**

Some type of environmental fall-out contaminated the vehicles surfaces that were not wrap guarded. These vehicles were parked in Japan's Hofu plant during the time of contamination.

Black colored spots may be imbedded into the vehicle's exterior surfaces that are not wrap guarded, wrap guarded surfaces were protected from the fall-out contamination. These spots are approx. 1. mm in diameter and are more visible on light colored vehicles. If the spots are not removed, a poor appearance of the vehicle's surfaces may result.

**Photos of the Black Colored Spots:**



**Inspection/Repair Procedure Overview:**

The vehicle(s) will first have to be washed, and then inspect the surfaces (that are not wrap guarded) for spot(s). If spot are noted, a three (3) step buffing and polishing procedure must be performed. The total chemical contents of the fall-out (spot) has not been determined, but no type of acid is present. Therefore, it is not necessary to neutralize the affected surfaces.

**Supplies for Repairs:**

All necessary supplies for the repairs will be shipped to the ports on August 1<sup>st</sup>.

<b>Product Name</b>	<b>Product Number (suppliers internal number)</b>	<b>Size</b>	<b>Repair Capacity</b>
Clear Coat Compound	VG-303-G	One Gallon	60 vehicles
Clear Coat Cutting Pad	VG-03-Y	One Pad	At least 10 vehicles
Machine Polish	VG-301-G	One Gallon	60 vehicles
Lamb's Wool Polishing Pad	VG-810-G	One Pad	At least 10 vehicles
Foam Polishing Pad	VG-528-G	One Pad	At least 10 vehicles
Micro Fiber Towels	VG-MFG	4 Per Pack	As needed

## Inspection/Repair Procedure:

1. Identify the affected vehicles from the VIN list.
2. Wash and dry the exterior of the vehicle. Do not remove the wrap guard.
3. Place the vehicle in a well-lit area and inspect the exterior surfaces.
  - a. If no spots are noted, perform steps #12 & #13.
  - b. If spots are noted, proceed to step #4.
4. Apply a small amount of Clear Coat Compound (VG-303-G) to the spot(s).

**Caution:** Make certain to wear safety goggles and any other protected gear necessary.

**Caution:** *The repair procedure requires buffing and polishing of the vehicle's painted surfaces. If the procedure is not performed correctly, damage (excessive removal of clear coat and/or damage to the paint) will result. It's recommended that the body shop personnel perform the repair procedure.*

5. Using a yellow colored Clear Coat Cutting Pad (VG-03Y), buff the affected area until the compound dissipates.

**Caution:** *One buff application removes 1/10 of a MIL of clear coat. Never remove more than 3/10 of a MIL of clear coat.*

**Caution:** *The buffer speed must be set between 1,440 to 1,750 RPM's. Never exceed 1,750 RPM's*

6. Re-inspect the spot(s).
  - a. If the spot(s) are still visible, repeat steps 3 & 4.

**Note:** *In some cases when the spot is removed, a yellow colored stain may be visible. If the stain is visible, repeat steps 3 & 4*

- b. If the spot(s) are not visible, proceed to step #6.

7. Apply a small amount of Machine Polish (VG-301G) to the previously buffed area(s).

8. Using an orange colored Lamb's Wool Polishing Pad (VG-810G), polish the area until the polish dissipates.

**Caution:** *The polisher speed must be set between 1,440 to 1,750 RPM's. Never exceed 1,750 RPM's*

9. Apply a small amount of Machine Polish (VG-301G) to the previously polished area(s).

10. Using a Foam Polishing Pad (VG-528G), polish the area until the polish dissipates.

**Caution:** *The polisher speed must be set between 1,440 to 1,750 RPM's. Never*

# Port Rework



11. Completely clean all compound/polish splatter with the supplied Micro Fiber Towels. These towels can be washed and reused several times.
12. Locate a "Port Campaign Label". Using a pin, write 01-08-01 next to the word "rework #", indicate your port's code, and the current date.
13. Open the hood and adhere the "Port Campaign Label" to the vehicle's firewall as illustrated.

*Note: Prior to adhering the label, clean the area with Isopropyl Alcohol.*



## Allowed Inspection/Repair Times:

1. Vehicle wash (standard time)
2. Vehicle inspection (.2)
3. Vehicle repair (maximum time per vehicle is .6).

If you have any questions with this inspection/rework, please contact Richard Salceda at (949) 442-6513

# Port Activity Overview



ORIGINATED FROM	REPORTED BY	ACTIVITY TYPE	MODEL INVOLVED	CONTROL NUMBER
McGaw Office	Richard Salceda	Port Rework	2002 Protege 5 & Millenia	04/01

**Concern:**

Black colored spots are imbedded into the vehicle's painted metal surfaces, bumpers, and mirrors. These spots range from 1.mm to several mm's in size. If these spots are not removed, a poor appearance of the vehicle's surfaces will result.

**Root Cause:**

Some type of environmental fall-out contaminated the vehicle surfaces. These vehicles were at the Hofu plant during the time of contamination.

**Number of Affected Vehicles:**

- 1. Port Tacoma = 876 (vehicles are now at the port)
  - 2. Port Hueneme = 555 (vehicles are scheduled to arrive on 07/20/01)
  - 3. Port Jacksonville = 1,274 (vehicles are scheduled to arrive on 07/29/01)
  - 4. Port Jersey = 1,180 (vehicles are scheduled to arrive on 08/01/01)
- Total -----  
3,885 (1,988 Protégé 5 & 1,897 Millenia)

**Inspection and Repair Procedure:**

On Tuesday, July, 24, 2001, I will visit port Hueneme to:

- 1. Determine the severity of the vehicles contamination.
- 2. Recommend if the vehicles need to be placed on hold at the port.
- 3. Validate the inspection and repair procedure(s).
- 4. Try to identify the type of fall-out.

**Estimated Failure Ratio:**

Pending port Hueneme's inspection results.

**Allowed Repair Time:**

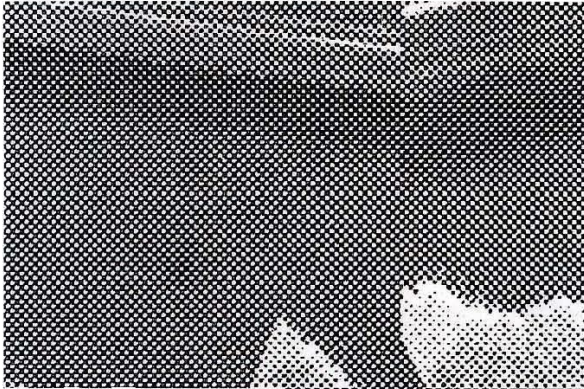
Pending port Hueneme's inspection results.

**Repair Team:**

Pending port Hueneme's inspection results.

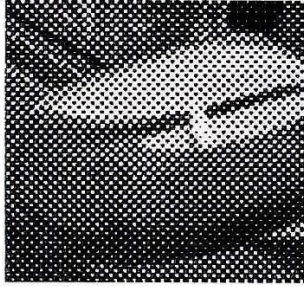
**Repair Parts and Material:**

Pending port Hueneme's inspection results.



A spot appears on the right door mirror. But this is less than 1.0 mm in diameter and judged OK.

Another spot is found on the rear spoiler. This is also less than 1.0 mm in diameter and judged OK.



A lot of spots appear on the front and rear bumpers.

A spot in the enlarged view 6 is a big one that is 7 mm x 3 mm. Others are 1.5 mm - 2.0 mm in diameter.

The spots appear on the plastic resin parts, but no spots are found on the vehicle body panel (metal area) or unpainted molding areas.

They appear in the locations where rain water easily collects. From this fact, we believe that impurities included in the water rain cause the spots.

The front and rear bumpers were repaired by repainting.

The door mirror and rear spoiler are not seriously affected (less than 1.0 mm in