

# INTERIOR PLASTIC TRIM—PAINT-TO-MATCH AND REPAIR—INTERIOR SPRAY PAINT AND ADHESION PROMOTER USAGE INSTRUCTIONS

TSB 04-20-7

## FORD:

2004-2005 Crown Victoria, Focus, Mustang, Taurus, Thunderbird  
 2005 Five Hundred, Ford GT, Freestyle  
 2004-2005 Econoline, Escape, Excursion, Expedition, Explorer Sport Trac, Explorer, F-150, F-250, F-Super Duty, Freestar, Ranger  
 2005 Escape Hybrid

## LINCOLN:

2004-2005 LS, Town Car, Aviator, Navigator

## MERCURY:

2004-2005 Grand Marquis, Sable  
 2005 Montego  
 2004-2005 Monterey, Mountaineer  
 2005 Mariner

## ISSUE

Ford Motor Company has adopted a new premium interior paint formulation with significantly improved performance properties. When used as directed, the product preserves the original grain pattern of the plastic, is UV stable, color fast, and is completely flexible. It will not crack, flake, or peel. Motorcraft Interior Spray Paint, PM-19M547-XXXXH, (XXXX = Color Code), can be used for both paint-to-match and repair procedures.

## ACTION

It is important to follow the product application directions, especially when plastic adhesion promoter, such as Motorcraft Adhesion Promoter PM-19A316-AA (or equivalent adhesion promoter), is required. Adhesion promoter must be applied prior to color coating when the interior trim plastic is a hard plastic (e.g., ATC, Pure PP, PC-ABS). However, DO NOT use an adhesion promoter prior to color coating soft plastic (e.g., Cast PVC, PVC-ABS).

## SERVICE PROCEDURE

1. Refer to the TSB chart and determine if adhesion promoter is required prior to painting.

Plastic Trim Part	Vehicle	Plastic Type
Consoles	All 2004 -2005 Ford, Lincoln, and Mercury vehicles	Soft
Pillars	All 2004 -2005 Ford, Lincoln, and Mercury vehicles	Hard
Lower Door Panels	All 2004 -2005 Ford, Lincoln, and Mercury vehicles	Hard
Upper Door Panels	All 2004 -2005 Ford and Mercury vehicles	Hard
Upper Door Panels	All 2004 - 2005 Lincoln vehicles	Soft
Instrument Panels	2004 - 2005 Escape, Excursion, Expedition, F150, F250-750, Focus, Freestyle, Mariner, and Mustang	Hard
Instrument Panels	All other 2004 and 2005 vehicles	Soft

- a. If adhesion promoter is required, proceed to "USING ADHESION PROMOTER".
- b. If adhesion promoter is not required, proceed to "USING INTERIOR SPRAY PAINT".

**NOTE:** The information in Technical Service Bulletins is intended for use by trained, professional technicians with the knowledge, tools, and equipment to do the job properly and safely. It informs these technicians of conditions that may occur on some vehicles, or provides information that could assist in proper vehicle service. The procedures should not be performed by "do-it-yourselfers". Do not assume that a condition described affects your car or truck. Contact a Ford, Lincoln, or Mercury dealership to determine whether the Bulletin applies to your vehicle. Warranty Policy and Extended Service Plan documentation determine Warranty and/or Extended Service Plan coverage unless stated otherwise in the TSB article. The information in this Technical Service Bulletin (TSB) was current at the time of printing. Ford Motor Company reserves the right to supersede this information with updates. The most recent information is available through Ford Motor Company's on-line technical resources.

## TSB 04-20-7 (Continued)

### **NOTE**

PROPER SURFACE PREPARATION MUST BE PERFORMED BEFORE ANY ADHESION PROMOTER OR PAINT PRODUCT IS APPLIED. THOROUGHLY CLEAN SURFACE TO BE COATED. REMOVE ANY GREASE, DIRT, POLISH, MOISTURE, ETC. WITH A WAX AND GREASE REMOVER, BY WIPING IN ONE DIRECTION. TO ENSURE PROPER ADHESION, IT IS ESSENTIAL THAT ALL SILICONE, CONDITIONERS, AND EXISTING PAINT (OTHER THAN THIS SAME PRODUCT) BE REMOVED PRIOR TO APPLICATION. MASK OFF AREAS TO BE PROTECTED FROM OVERSPRAY.

### **USING ADHESION PROMOTER**

- For best results, use only when the product and surface temperatures are between 15-33° C (60-92° F). In cases of high humidity, apply the adhesion promoter in a spray booth or controlled climate. If not an option, use a hair dryer or fan to create air movement to speed the adhesion promoter curing process.
- Shake can vigorously for one full minute before use and repeat for ten seconds after each full minute of use.
- Test spray on a hidden area before proceeding.
- To spray, hold can 6-10 inches from the surface and spray a full wet coat with a steady back and forth motion. Be sure all areas of the surface are covered. Observe for uniform gloss across the surface while adhesion promoter is still wet.
- Allow adhesion promoter to dry 2-3 minutes and then apply a second wet coat. Allow adhesion promoter to dry 2-3 minutes.
- Apply the color coat as soon as possible after second coat of adhesion promoter dries, preferably within 10 minutes. Refer to "USING INTERIOR SPRAY PAINT".

### **NOTE**

AFTER USE, INVERT THE CAN AND SPRAY FOR 4 SECONDS TO CLEAN VALVE. IF SPRAY BUTTON BECOMES CLOGGED, WIPE OFF ORIFICE WITH LACQUER THINNER. DO NOT STICK PINS OR WIRE INTO CAN OPENING.

### **USING INTERIOR SPRAY PAINT**

- For best results, use only when the product and surface temperatures are between 15-33° C (60-92° F). In cases of high humidity, blushing may occur. To alleviate this problem, apply paint in a spray booth or controlled climate. If not an option, use a hair dryer or fan to create air movement to speed the paint curing process.
- Before use, shake can vigorously for two full minutes. Hold can vertically, and 12 inches from surface to be painted. Apply paint in light mist coats using even strokes from side to side (stop spraying at the end of strokes).
- Apply to a small area to verify color match before painting entire surface.
- Apply 2 to 3 mist coats, allowing approximately 10 minutes between coats. Heavy coats will result in patchiness and runs and may trap solvents, resulting in improper curing.
- Each 6 oz. can covers approximately 5-7 square feet of surface.

### **NOTE**

AFTER USE, INVERT THE CAN AND SPRAY UNTIL ONLY CLEAR GAS IS EMITTED. DO NOT STICK PINS OR WIRE INTO CAN OPENING.

PART NUMBER	PART NAME
PM-19A316-AA PM-19M547-XXXXH	Adhesion Promoter Interior Spray Paint (XXXX = Color Code)

**WARRANTY STATUS:** Information Only