



TECHNICAL SERVICE BULLETIN

Classification:	Reference:	Date:
BT22-010A	NTB22-046A	August 1, 2023

REMOVING SWIRLS FROM NISSAN PAINT

This bulletin has been amended. See **AMENDMENT HISTORY** on the last page.
Please discard previous versions of this bulletin.

APPLIED VEHICLES: All Nissan vehicles

SERVICE INFORMATION

If it is necessary to remove fine scratches (swirl marks, buff/polish marks), use the referenced equipment and materials and follow the **SERVICE PROCEDURE** starting below.

SERVICE PROCEDURE

1. Prepare the vehicle for polishing.
 - a. Thoroughly rinse the vehicle, preferably in a shady area, to remove all surface dirt and/or dust.
 - If the vehicle is extremely dirty, wash the vehicle with soap and water consistent with Nissan car wash procedures.
 - b. Prior to polishing, ensure the painted surfaces are dry, cool to the touch, and completely free of dust and water spots, before moving to step 2 on page 2.

Bulletins are intended for use by qualified technicians, not 'do-it-yourselfers'. Qualified technicians are properly trained individuals who have the equipment, tools, safety instruction, and know-how to do a job properly and safely. **NOTE:** If you believe that a described condition may apply to a particular vehicle, DO NOT assume that it does. See your Nissan dealer to determine if this applies to your vehicle.

2. Polish the vehicle using only a **Dual Action Random Orbital Polisher** with a **soft foam polishing pad** (see **PARTS INFORMATION** for Foam Pads).
 - a. Spread the polishing compound around with the soft foam polishing pad on the surface to be polished.
 - Removing fine scratches requires a soft foam polishing pad and a Dual Action Random Orbital Polisher.

NOTICE

To avoid creating swirl marks on painted surfaces while polishing, do not use a rotary buffer. The uniform rotation of a rotary buffer can create swirl marks instead of removing them.

- b. While keeping the soft foam polishing pad flat on the vehicle surface, turn ON the Dual Action Random Orbital Polisher. Move it slowly, but continuously over the area while applying approximately 4lbs of downforce.

Recommended speeds:

- For 3" pad – 11,000 rpm (Max)
- For 5" pad – 10,000 rpm (Max)

NOTICE

To avoid overheating the painted surface while polishing, it is important to maintain a “wet” surface. Overheating the painted surface can damage the paint or underlying component.

- c. Use an overlapping pattern (Figure 1) to ensure an even polishing effort on all areas.

HINT: For isolated fine scratches, polish the affected area of each panel (for example: hood, deck lid, door panel). For cases of more extensive fine scratches, it may be necessary to polish the entire panel.

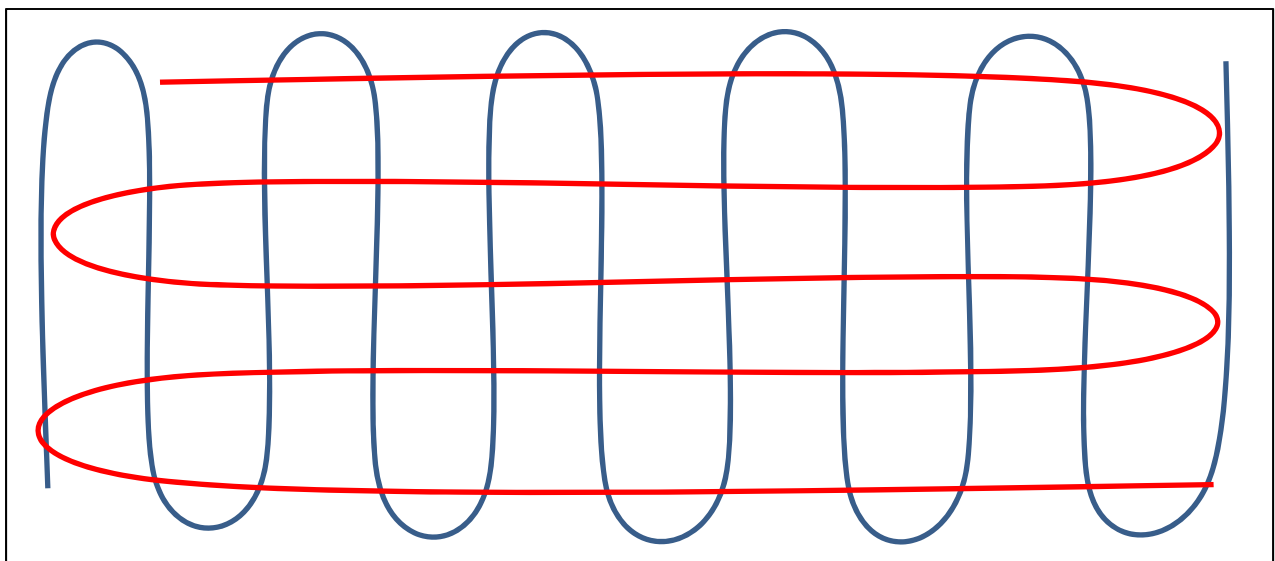


Figure 1

- d. Wipe off any excess polish material with a clean, seamless microfiber towel (Figure 2).

HINT: The thread used in microfiber towel seams can cause fine scratches.



Figure 2

- e. If necessary, repeat steps 2a-2d until the desired result is attained.

HINT: To confirm that the swirls have been removed, wipe away the polish residue with a mixture of water and alcohol (50/50 mixture), and then verify visually in either the direct sunlight, or with a light that replicates sunlight.

The following list of parts and materials are listed as a reference only. This list provides a minimum standard to properly perform this **SERVICE PROCEDURE**, and is not a recommendation or endorsement. Equivalent products may be used.

PARTS INFORMATION

	DESCRIPTION	3M PART NO
Polish	3M™ Perfect-It™ Ultrafine Machine Polish (1)	06068 (quart) (2)
Foam Pads	White – 3" 3M™ Perfect-It™ (1)	01963
	White – 5 ¼" 3M™ Perfect-It™ (1)	01912
Back Up Pad	3" – 3M™ Hookit™ (1)	20350
	5" – 3M™ Hookit™ (1)	84226

- (1) Can be ordered from the 3M website https://www.3m.com/3M/en_US/p/c/compounds-polishes/
- (2) Additional size containers available from 3M

CLAIMS INFORMATION

Reference the Nissan "Warranty Paint Flat Rate Manual" and use the Polish and Buff operation, or combination of operations, that best reflects the repair performed. Please note that the usual Paint Inspection requirements will apply.

AMENDMENT HISTORY

PUBLISHED DATE	REFERENCE	DESCRIPTION
June 1, 2022	NTB22-046	Original bulletin published
August 1, 2023	NTB22-046A	Publication date revised to include the latest models and model years, and CLAIMS INFORMATION revised