



STANDARD OPERATING PROCEDURE

Steel Finishing

		Bare Metal	E-Coated Panel	Repaired / Used Panel
Inspect			1 Inspect part for defects. Return to body dept/supplier if necessary.	1 Inspect panel/repair area for defects. Return to body dept if necessary.
Test			2 Test e-coated panels with acetone or paint thinner. If coating fails, strip panel to bare metal & follow SOP 111 for Bare Metal.	2 Test coated panels with acetone or paint thinner. If coating fails, strip panel to bare metal & follow SOP 111 for Bare Metal.
Clean			3 Wash with warm water & soap (silicone & oil free).	3 Wash with warm water & soap (silicone & oil free).
	1	Clean with solvent-borne degreaser SCAT #6311 or Speedi SCAT #6321.	4 Clean with solvent-borne degreaser SCAT #6311 or Speedi SCAT #6321.	4 Clean with solvent-borne degreaser SCAT #6311 or Speedi SCAT #6321.
	2	Clean with waterborne degreaser Aqua SCAT 2 #1394	5 Clean with waterborne degreaser Aqua SCAT 2 #1394	5 Clean with waterborne degreaser Aqua SCAT 2 #1394
Sand	3	Sand bare metal with 80 grit on palm sander.	6 Scuff panel with red scuff pad or 400 grit paper on palm sander.	6 Sand repair area with 180-240 grit on palm sander.
	4	Sand with 180 grit on palm sander.		7 Scuff around repair area with red scuff pad.
Clean	5	Blow off vehicle/panel. Clean with waterborne degreaser, Aqua SCAT 2 #1394	7 Blow off vehicle/panel. Clean with waterborne degreaser, Aqua SCAT 2 #1394	8 Blow off vehicle/panel. Clean with water-borne degreaser, Aqua SCAT 2 #1394
Prime	6	Tack off. Apply corrosion protection primer.	8 On Exposed Bare Metal: Tack off. Apply corrosion protection primer.	9 On Exposed Bare Metal: Tack off. Apply corrosion protection primer.
Prime	7	If necessary, tack off & apply high-build primer surfacer.	9 If necessary, tack off & apply high-build primer surfacer.	10 If necessary, tack off & apply high-build primer surfacer.

- For Selection of Transtar Primer by Substrate, see SOP 021. • For Prep & Sanding to Paint, see SOP 051.
- For small damage repair, see SOP 116.

SUGGESTED MATERIALS FOR JOB

- Acetone / Paint Thinner • Soap & Water • Transtar Solvent-borne degreaser, #6311/6321
- Transtar Waterborne degreaser, #1394 • Lint-free Towels • Sandpaper – various grits • Sanding blocks • Palm Sander
- Scuff pads • Transtar Guide Coat, #9183 • Tack rags • Transtar Corrosion Protection Primer • Transtar Primer Surfacer

* Always refer to Transtar Technical Data Sheet (TDS) for specific product application, suitable substrates & other product information.