



STANDARD OPERATING PROCEDURE

Cut-in Bolt-on Part

New Bolt-on Metal Part - Fender, Hood, Deck Lid, Door

Inspect - Test	1	Receive & inspect part for defects & alignment before Cut-In procedure. For small damage repair, see SOP 116.
	2	Ensure topcoat compatibility. Test e-coated panels with acetone or paint thinner. If coating fails, strip panel to bare metal. For Finishing Bare Metal, see SOP 111.
Clean	3	Clean with solvent-borne degreaser, SCAT #6311 or Speedi SCAT #6321.
	4	Clean with waterborne degreaser, Aqua SCAT 2 #1394.
Sand	5	Sand exterior surface with 400 grit on palm sander.
	6	Scuff entire panel with red scuff pad.
Clean	7	Blow off part. Clean with waterborne degreaser, Aqua SCAT 2 #1394.
Prime	8	On Exposed Bare Metal: Tack off. Apply Transtar corrosion protection primer where necessary.
Seal	9	Tack off part. Apply Transtar sealer. For improved hiding, select proper Star Shade value. Follow Transtar TDS for sealer. Allow proper flash time.
Edges/Jamb	10	Tack off. Apply topcoat to <i>edges, jambs & underside of part</i> according to Transtar TDS. Apply No Mix Basecoat 2-3 coats or until hiding is achieved.* Allow 5-10 minutes flash time. Tack off between coats.
	11	During part cut-in, create a sprayout card / letdown panel. See SOP 501.
Clear	12	Tack off. Apply Transtar clearcoat to edges, jambs & underside of part according to Transtar TDS. Apply 2 coats of clearcoat.
Install	13	After curing, install part onto vehicle.
Exterior	14	For prep & finishing exterior of part, see SOP 111 - Steel Finishing for e-coated panel.

● For Topcoat mixing & application to panel, see SOP 509. ● For plastic panels, see SOP 251/2.

SUGGESTED MATERIALS FOR JOB

- Acetone/Paint Thinner ● Transtar Solvent-borne degreaser, #6311 / #6321
- Transtar Waterborne degreaser, #1394 ● Sandpaper – various grits ● Sanding blocks
- Palm Sander ● Scuff pads ● Lint-free Towels ● Tack rags ● Transtar Corrosion Protection Primer
- Transtar Primer Sealer ● No Mix Basecoat ● Transtar Reducer ● Transtar Clearcoat

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