



STANDARD OPERATING PROCEDURE

Finishing Raw Plastic

Raw Plastic with Transtar Adhesion Promoter		Raw Plastic with Transtar Adhesion Primer, #1074/84/94	
Clean	1 Wash with warm water & soap (silicone & oil free).	1 Wash with warm water & soap (silicone & oil free).	
	2 Rinse with water. If water does not sheet off, wash again. Assure all silicones are removed.	2 Rinse with water. If water does not sheet off, wash again. Assure all silicones are removed.	
	3 Clean thoroughly with waterborne degreaser Aqua Scat2, #1394. Do not allow degreaser to dry on surface. Clean again to remove residue & static. Wipe dry thoroughly.	3 Clean thoroughly with waterborne degreaser Aqua Scat2, #1394. Do not allow degreaser to dry on surface. Clean again to remove residue & static. Wipe dry thoroughly. <i>Ensure proper cleaning as Transtar 1074/84/94 is designed to save time by not abrading or scuffing plastic parts.</i>	
Note: Some plastic parts may need to be sweat-baked to properly remove mold release agent.			
Test		4 On Unknown Plastic Resin: Conduct adhesion test. Consult TDS sheet for suitable substrates/resins.	
	To determine if a primer may be used on plastic substrate & identify resin type, see SOP 021/2.		
Sand	4 Scuff thoroughly with gray scuff pad and Scuff & Prep Paste #6338.		
Clean	5 Rinse off scuff paste with warm water.		
	6 Clean with water-borne degreaser, Aqua SCAT 2, #1394.		
Prep	7 Tack off. Apply 1 medium wet coat Mul-Tie Adhesion Promoter #1031/3. Allow to flash off 10-15 minutes.		
Seal	8 Select Transtar sealer & Star Shade value. Tack off. Apply primer sealer per TDS.	5 Select Transtar Adhesion Primer #1074/84/94 for Star Shade value. Tack off. Apply 1 coat primer per TDS. Allow 30 minutes to cure before applying topcoat/sealer.	
Topcoat	9 Apply topcoat per Transtar SOP 509. For blending, see SOP 513/4.	6 Apply topcoat per Transtar SOP 509. For blending, see SOP 513/4. For Solvent Basecoat, sealer not required. See TDS for details.	

● For Finishing Repaired & Pre-Primed Plastic, see Transtar SOP 252.

● For improved resistance to cracking & chipping, add Transtar Flex Additive #9194 to primer, sealer & clearcoat; Do Not mix #9194 with Transtar Adhesion Primer 1074/84/94 and other specified coatings. See Transtar TDS for detail.

<p><u>SUGGESTED MATERIALS FOR JOB</u></p> <ul style="list-style-type: none"> ● Soap & water ● Lint-free Towels ● Transtar Waterborne degreaser, #1394 ● Tack rags ● Scuff pads ● Transtar Scuff/Prep Paste, #6338 ● Transtar Mul-Tie Adhesion Promoter #1031/3 ● Transtar Sealer ● Transtar Flex Additive #9194 	<p><u>SUGGESTED MATERIALS FOR JOB</u></p> <ul style="list-style-type: none"> ● Soap & water ● Lint-free Towels ● Transtar Waterborne degreaser, #1394 ● Tack rags ● Transtar Adhesion Primer, #1074/84/94 ● Transtar Sealer (if waterborne topcoat is applied)
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* Always refer to Transtar Technical Data Sheet (TDS) for specific product application, suitable substrates & other product information.