

STANDARD OPERATING PROCEDURE

Finishing Repaired/Pre-Primed Plastic

	Repaired Plastic	Pre-Primed Plastic
Clean	1 Wash with warm water & soap (silicone & oil free).	1 Wash with warm water & soap (silicone & oil free).
	2 Clean with water-borne degreaser, Aqua SCAT 2, #1391/4.	2 Clean with water-borne degreaser, Aqua SCAT 2, #1391/4.
Test		3 Test pre-primed panels with acetone or paint thinner. If coating fails, strip panel to bare plastic & follow SOP 251 for Raw Plastic.
Repair	3 Perform plastic repair. See Transtar SOP 219.	
Sand	4 Featheredge existing paint around repair area with 240-320 grit on palm sander.	4 Sand with 400-600 grit to remove surface texture.
		5 Scuff with red scuff pad and Scuff & Prep Paste #6338 until surface is uniformly dull.
Clean	5 Blow off vehicle/part.	6 Rinse off scuff paste with warm water.
	6 Clean with water-borne degreaser, Aqua SCAT 2, #1391/4.	7 Clean with water-borne degreaser, Aqua SCAT 2, #1391/4.
Mask	7 Mask off vehicle/part if necessary.	8 Mask off vehicle/part if necessary.
Prep	8 Tack off. On bare plastic only, apply 1 medium wet coat Mul-Tie Adhesion Promoter #1031/3. Allow to flash off 10-15 minutes.	
Prime	9 Tack off. Apply high-build primer surfacer to repair area using <i>Outside-In method</i> .	
Sand	10 After Primer has Cured: Apply Low Spot Finder Guide Coat #9183 to surface. Sand with 400-600 grit. If primer is sanded through, repeat step 9 & re-prime.	
Clean	11 Blow off vehicle/part. Clean with water-borne degreaser, Aqua SCAT 2 #1391/4	
Topcoat	12 Tack off. Apply sealer & topcoat per Transtar SOP 509. For blending, see SOP 513/4.	9 Tack off. Apply sealer & topcoat per Transtar SOP 509. For blending, see SOP 513/4.

● For Finishing Raw Plastic, see Transtar SOP 251.

● For improved resistance to cracking & chipping, add Transtar Flex Additive #9194 to primer, sealer & clearcoat; Do Not mix #9194 with specified coatings. See Transtar TDS for detail.

SUGGESTED MATERIALS FOR JOB

- Soap & water ● Lint-free Towels ● Transtar Waterborne degreaser, #1394 ● Acetone / Paint Thinner ● Sandpaper – various grits
- Sanding blocks ● Palm Sander ● Scuff pads ● Transtar Scuff/Prep Paste, #6338 ● Transtar Guide Coat, #9183 ● Masking material
- Tack rags ● Transtar Mul-Tie Adhesion Promoter #1031 ● Transtar Primer Surfacer ● Transtar Flex Additive #9194

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