

## STANDARD OPERATING PROCEDURE

### Undercoat Corrosion Protection & Sound Deadening

Use on under carriages, quarter panels, wheel wells, interior side of fenders, door skins, under side of hood and trunk lid, floor pans, etc.

Aerosol Undercoat #60-4363-F, #4373		Undercoat & Spray Gun # 4361-F, 4364-F	
Inspect	1	Inspect repair area for defects. Assure area is properly repaired & prepped. Return to body dept if necessary.	
Repair	2	Repair all rust or damage as necessary. Refer to SOP 051 for prep & sanding metal substrates.	
Clean	3	Wash vehicle with soap and water. Power wash undercarriage area to be undercoated	
	4	Clean repair area with solvent-borne degreaser, SCAT #6311 or Speedi SCAT #6321.	
	5	Clean with waterborne degreaser, Aqua SCAT 2 #1394.	
Sand	6	If surface contains loose coatings, sand with 80-180 grit paper.	
Clean	7	Blow off vehicle/panels. Wipe repair area with Aqua SCAT 2 #1394.	
Prime	8	On bare metal, prime with corrosion protection primer #6183/4, #6111/4 or other Transtar metal treatment primer. Refer to Transtar SOP 111 for bare metal or SOP for corrosion protection with self etch primer.	
Mix	9	Before use of aerosol can, shake can vigorously for 1-2 minutes after ball breaks free. Shake can frequently during application.	9 Shake undercoat on a paint shaker thoroughly before use. Adjust shutz gun per manufacturer directions (pressure, fan).
	Undercoat	10	<u>External Panels / Surfaces:</u> Immediately after cleaning, tack off panel. Hold can 8-10" from surface. Apply 2-3 light even coats using short, even strokes. Overlap spray pattern by 50% for an even coat. Allow 10 minute flash time between coats.
11		<u>Interior Cavities:</u> Using Corrosions Kit #4471, select the best accessory (tubing, tip, etc.) and desired tubing. Insert 360° brass fitting into tube end. Insert aerosol tip onto undercoat can. Insert tubing into access hole in body panel. Push tubing the full length into deepest section of panel. Begin spraying. Slowly remove tubing from the cavity while spraying. When the mark on the tubing is exposed, stop spraying. Remove the tube/tip from the cavity. To ensure adequate coverage in the cavity, repeat spraying steps 2-3 times.	11 To spray interior cavities with shutz gun, check with gun manufacturer and available accessories.
Important: Avoid application of undercoating within 12" of exhaust system.			
Clean	12	To prevent clogging when finished spraying, invert can and spray until valve is free of material. When using corrosion kit #4471, remove corrosion kit tubing and spray tips from undercoat can. Wipe excess material. Insert tubing onto Acry Solvent can #9783. Spray solvent onto paper through tubing until clear and clean.	12 Clean gun with acetone as specified by manufacturer.
	13	Remove overspray from panels with Acry Solvent #60-9783.	

Note: Always wear gloves and appropriate personal protection equipment.

#### SUGGESTED MATERIALS FOR JOB

- Soap & water • Lint-free Towels • Sandpaper
- Solvent-borne degreaser, SCAT #6311 or Speedi SCAT #6321 • Transtar Waterborne degreaser, #1394 • Tack rags
- Transtar Corrosion Protection Primer: #6183, 6194, 6184, 6111
- Transtar Undercoat: 4361-F, 60-4363-F, 4364-F; #4373 • Corrosion Protection Kit, #4471
- Transtar Acry Solvent #60-9783 / 9784 • Acetone • Transtar Primer Surfacer / Sealer • Transtar Topcoat

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