



Refinishing Saturn Doors & Rocker Panels

Panel Composition

ABS/PC: (acrylonitrile butadiene styrene/polycarbonate)

This is a solvent sensitive substrate.

Use the recommendations that follow to avoid problems such as sand scratch swelling, dieback or lifting.

New OEM Replacement Panels

These panels are usually pre-primed. In some instances the OEM primer is sanded through to remove a surface imperfection (scratch or nick) or has been applied too thin from the factory.

- 1) Wash thoroughly with soap and water. Then rinse and dry.
- 2) Lightly scuff the OEM primer with a gray scuff pad.
- 3) Wipe down the entire panel with Aqua SCAT 2 #1391/1394.
- 4) Apply 1 - 2 coats of Hydroflex #1231 or Hydrobase DTM Primer #9491/9494 and allow to dry.
- 5) Sand with 500 or 600 grit (do **not** sand through Hydroflex or Hydrobase DTM Primer without re-coating or sealing. Note: Hydroflex should always be sealed before topcoating) and reclean with Aqua SCAT 2.
- 6) Apply any approved basecoat system and desired Transtar clearcoat.

Existing Panels

The following procedure should be used any time the OEM finish is sanded through to the OEM primer on existing panels.

- 1) Wash thoroughly with soap and water. Then rinse and dry.
- 2) Wipe down the entire panel with Aqua SCAT 2 #1391/1394.
- 3) Perform necessary repairs.
- 4) Feather the leading edge of the repair area with 320 – 400 grit or finer.
- 5) Sand the remainder of the panel with 1200 -1500 grit.
- 6) Wipe down the entire panel with Aqua SCAT 2.
- 7) Apply 2 - 3 coats of Hydroflex #1231 or Hydrobase DTM Primer #9491/9494 and allow to dry.
- 8) Sand with 500 or 600 grit (do **not** sand through Hydroflex or Hydrobase DTM Primer without re-coating or sealing. Note: Hydroflex should always be sealed before topcoating and reclean with Aqua SCAT 2.
- 9) Apply any approved basecoat system and desired Transtar clearcoat.