

# New Parts (Factory-Primer) Refinishing



## Best Demonstrated Practices

### Area: Paint Prep

#### STEP 1:

Solvent test E-Coat. If insoluble proceed to Step 2. If E-Coat is soluble, remove E-Coat and follow "Repaired Part Refinishing" procedure.

#### STEP 2:

Thoroughly clean part with G2T151 or W4K157 Surface Cleaners. VOC Restricted areas must dilute W4K157 Surface Cleaner.

**MIX:**  $\frac{1}{\text{W4K157}} + \frac{5}{\text{Water}}$

#### STEP 3:

Remove Factory E-Coat imperfections using a DA with P600 grit sandpaper on an interface pad. Minimize break throughs to E-Coat. **NOTE: If P30/P27 Sealer was applied to the exterior of the new part in the "Jamming Parts Refinishing" procedure, sand the P30/P27 Sealer with P600 grit before topcoating.**

#### STEP 4:

Re-clean the new part with G2T151 or W4K157 Surface Cleaners. VOC Restricted areas must dilute W4K157 Surface Cleaner.

**MIX:**  $\frac{1}{\text{W4K157}} + \frac{5}{\text{Water}}$

#### STEP 5:

Small cut-throughs in the factory coating may be treated with P30 or P27 Primer Sealer. Large areas must be treated with PE995 or E2G970 Corrosion Shield® Primer.

### Area: Spraybooth

#### STEP 6:

Apply 1 full even wet coat of P30 or P27 Primer Sealer. Allow to flash handslick before topcoating. **NOTE: If the exterior of the new part has been prepared using the "NOTE" under Step 3, no additional P30/P27 Sealer is required and can be directly topcoated.**

#### STEP 7:

Apply AWX® basecoat until coverage is achieved. Refer to Product Data Sheet AS2667. If blending is necessary, refer to 4550500 AWX® Blender Product Data Sheet AS2926.

#### STEP 8:

Allow the AWX® Basecoat to flash 15–30 minutes or until fully dehydrated before clearcoating.

#### STEP 9:

For low VOC areas apply 1100755, HPC21, CC920, CC921, CC923, CC927 or SRC2. See clearcoat Product Data Sheet. For National Rule Areas, 1100755, CC939, CC947 and HPC15 can also be used over AWX®.



I-CAR recommends following the paint manufacturer's recommendations for paint preparation, mixing and application of automotive refinishing products.



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Automotive Finishes

The Sherwin-Williams Company  
4440 Warrensville Center Road  
Warrensville Heights, OH 44128  
1-800-798-5872

[www.sherwin-automotive.com](http://www.sherwin-automotive.com)