

# Unprimed Plastic Parts Refinishing

## Area: Paint Prep

### STEP 1:

Perform a substrate test. Using P600, dry sand a small area on the inside of the plastic part. If the part powders, it must be sanded before proceeding to Step 2. If substrate gums up during sanding, proceed directly to Step 2.



### STEP 2:

Clean all surfaces (back and front) with W4K157 or SC159 Anti-Static Surface cleaner along with a white or gold nylon scuff pad. Thoroughly rinse with clean water and wipe dry. VOC Restricted areas must dilute W4K157 Surface Cleaner.



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

### STEP 3:

Scuff sand using a white or gold nylon scuff pad along with USP90 Liquid Scuffing Gel, paying close attention to small grooves and depressions.



### STEP 4:

Thoroughly rinse off the scuffing agent with clean water and completely dry the surface.



### STEP 5:

Thoroughly clean the plastic substrate with SC159 Plastic Anti-Static Cleaner and a gold scuff pad or for VOC Restricted areas, you must dilute W4K157 Surface Cleaner.



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

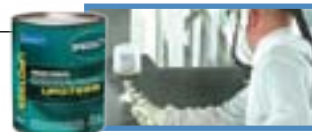
Dry excess material with a clean cloth and re-apply with appropriate cleaner, followed by wiping the part dry with a clean cloth.



## Area: Spraybooth

### STEP 6:

Apply 1 medium coat of the Clear Adhesion Promoter UPO7228 for low VOC or UPO7229 for National Rule to the bare plastic. Allow 10 minutes to flash.



### STEP 7:

Apply 1 full even wet coat of P30 or P27 Primer Sealer. Allow to flash handlick before topcoating. **NOTE: For VOC Restricted areas use P27.**



### STEP 8:

Apply AWX® basecoat until coverage is achieved. Refer to Product Data Sheet AS2667.



### STEP 9:

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

### STEP 10:

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®.



## Best Demonstrated Practices

**I-CAR** | INDUSTRY TRAINING ALLIANCE

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



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