



# URETHANE PARTS PAINT PREPARATION STEP BY STEP

Meets California Air Quality Requirements

Note: The following procedures were developed for meeting California's (SCAMD) South Coast Air Quality Management District requirements.

## MATERIALS REQUIRED

Spies Hecker Silicone Remover #7090  
Spies Hecker Fine Putty #7715  
Spies Hecker #3304 Plastic Adhesion Primer  
500 Grit Wet Sand Paper  
3M #2604 Fine (Soft Back) Sanding Sponge  
Scotchbrite Pad # 7447  
Clean Rags

## TIP TOP PRIMER # 1255

Contact Info @ [www.tiptoptech.com](http://www.tiptoptech.com)  
Phone : 949-290-8391

## 5 TO 1 Mixing Ratio :

Mixing Formula : 5-Parts Primer  
1- Part Hardener #1256  
10% TIP TOP Reducer #1257

## Cleaning the Part :

***If a bake booth is available, the first step is to bake all urethane parts for 2 hours at 80 degrees.***

If you do not have a bake booth, placing the parts in the sun, or use of a hair dryer will work fine. This will allow the part to sweat out oils in the urethane and any trapped gases. Then thoroughly clean the part inside and out with a silicone remover or comparable wax and grease remover. We recommend using 7090 Spies Hecker Brand silicone remover. Using a spray bottle, spray the outside of the part with silicone remover and at the same time scuff the surface to a dull finish with a 3M 7447 Scotchbrite Pad. After scuffing the part again clean the surface with the 7090 using a clean rag.

## Surface Inspection and minor defect repair

Inspect the surface for defects ie: scratches, nicks, etc. and spot repair with Spies Hecker Fine Putty #7715. After the putty dries, sand the putty smooth with 3M Soft Back Fine Grit Sanding Sponge. Again clean the surface again with 7090 cleaner.

## Plastic Adhesion Primer Application

Apply the 3304 plastic adhesion primer to the part surface. Allow to dry for 5 minutes.

## Primer Application

Apply the first coat of Tip Top #1255 Brand Primer to the part surface, the first coat should be a light coat. Allow to dry 5-10 Minutes. Apply a second wet coat of Tip TOP primer #1255, Allow to dry for 10-15 minutes. If heat is available put the parts in the oven for 1 -1/2 hours at 90 degrees to fully cure the primer. Remove from oven, allow to cool down and thoroughly wet sand with 3M 500 grit wet sand paper along with a solution of Simple Green and water. Final clean the part surface with Spies Hecker #7090 Silicone Remover. The part is now ready for base coat paint. Apply base coat & clear coat per manufacturers' specifications.

**A step by step video on prepping, priming & base coat / clear coat application can be viewed on our web site at [www.autobarber.com](http://www.autobarber.com) under knowledge base section.**