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

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 under knowledge base section.

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
Phone : 949-290-8391
5 TO 1 Mixing Ratio :
Mixing Formula :
5-Parts Primer
1- Part Hardener #1256
10% TIP TOP Reducer #1257

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