

Plastic Preparation Using The OneChoice System

Process for Pre-Primed Plastic Substrates

Step 1:



Using the SU4901 Clean and Scuff Pad...

Tear open SU4901 and clean the substrate thoroughly using the scuff pad side of the pre-saturated sponge, then rinse with water. Blow dry or wipe with a clean cloth. The entire surface must be totally de-glossed. Make sure surface is thoroughly dry before proceeding.

Step 2:



Thoroughly sand with 400-grit sandpaper or gray scuff pad.

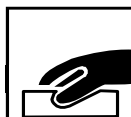
Step 3:



Mix **SX1005** Wax and Grease Remover 2:1 with water. Saturate a clean cloth and wipe the surface thoroughly. Using another clean cloth, wipe the surface dry. Do not allow the cleaner to dry on the surface. Be sure the part is completely dry before going to the next step. **Note:** To insure maximum adhesion and systems performance, **Do Not** apply Envirobase High Performance waterborne basecoat directly over pre-primed parts, a sealer or primer must be first be applied. See data sheet EU-143, page 3 for compatibility.

Process for Un-primed Plastic Substrates

Step 1:



Using the SU4901 Clean and Scuff Pad...

Tear open SU4901 and clean the substrate thoroughly using the scuff pad side of the pre-saturated sponge, then rinse with water. Blow dry or wipe with a clean cloth. The entire surface must be totally de-glossed. Make sure surface is thoroughly dry before going to the next step.

Step 2:



Using the SU4902 Plastic Adhesion Prep...

Tear open SU4902. (This is an advanced film former that promotes excellent adhesion and removes static charge from unprimed plastic substrates). Apply a light even coat over the entire area, wiping in one direction to minimize product overlap. Allow a 3 - 5 minute flash time.

Step 3:



Using the SU4903 or SUA4903 (Aerosol) Advance Plastic Bond...**

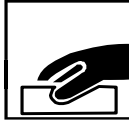
Apply a light coat of either SUA4903 (Aerosol) or SU4903 and allow 5 minutes dry time or until completely flashed to a matt finish, prior to sealing. **Note:** To insure maximum adhesion and systems performance, **Do Not** apply Envirobase High Performance waterborne basecoat directly over SU4903 or SUA4903 Advance Plastic Bond, a primer or sealer must be first be applied. See data sheet EU-143, page 3 for compatibility.

****Note:** Local air quality regulations may limit use of specific products. Verify acceptability before use.

Plastic Preparation Using GLOBAL Products

Process for Pre-Primed Plastic Substrates

Step 1:



Wash all surfaces to be painted with soap and water.

Step 2:



Thoroughly sand with 400-grit sandpaper or gray scuff pad. Mix **SX1005** Wax and Grease Remover 2:1 with water. Saturate a clean cloth and wipe the surface thoroughly. Using another clean cloth, wipe the surface dry. Do not allow the cleaner to dry on the surface. Be sure the part completely dry before going to the next step..

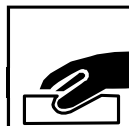
Step 3:



Apply a sealer or primer. **Note:** To insure maximum adhesion and systems performance, **Do Not** apply Envirobase High Performance waterborne basecoat directly over pre-primed parts. A sealer or primer must be first be applied. See data sheet EU-143, page 3 for compatibility.

Process for Un-primed Plastic Substrates

Step 1:



Wash all surfaces to be painted with soap and water. Clean the surface to remove any silicone mold release or contaminates using **SXA103****.

Step 2:



Thoroughly sand with 400-grit sandpaper or gray scuff pad and re-clean all surfaces with **SX1005** mixed 2:1 with water. Saturate a clean cloth and wipe the surface thoroughly. Using another clean cloth, wipe the surface dry. Be sure part is completely dry before going to the next step.

Step 3:



Apply 1 wet coat of **D820**. Allow a 30 minute flash before applying a primer or a sealer. **Note:** To insure maximum adhesion and systems performance, **Do Not** apply Envirobase High Performance waterborne basecoat directly over D820 Plastic Adhesion Promoter. A primer or sealer must be first be applied. See data sheet EU-143, page 3 for compatibility.

****Note:** Local air quality regulations may limit use of specific products. Verify acceptability before use.