

# Primed Plastic Refinishing

## Area: Paint Prep

### STEP 1:

Solvent test factory-primer. If insoluble please proceed to Step 2. If factory-primer is soluble, remove the primer and follow the "Unprimed Plastic Parts" procedure.



### STEP 2:

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:

Sand blend areas with P800 grit sandpaper. Thoroughly scuff unsanded area with gray nylon scuff pad.



### STEP 4:

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

### STEP 5:

Re-clean the part with G2T151 or W4K157 Surface Cleaner. VOC Restricted areas must dilute W4K157 Surface Cleaners. Make sure all residue is removed.

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



## Area: Spraybooth

### STEP 6:

Apply 1 wet coat of P30 SpectraSeal® Primer Sealer or P27 2.1 VOC Sealer to the exterior of panel. Allow Sealer to flash at least 5 minutes before topcoating. (Use P27 in Low VOC areas.)



### 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®.



## 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.



**SHERWIN-WILLIAMS**  
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