Primed Bumper Preparation Procedure:

Applies to OEM and aftermarket plastics

1. Solvent Test:

Test the stability of the primer by using 902 (AM902). Test by applying 902 to the primed part and wipe dry. If primer is apparent on the rag, all primer must be removed before any R-M coatings can be applied. If primer is removed, proceed to the RAW Plastic Preparation Procedure.

If primer is insoluble (not chemically removed) proceed below:

2. Clean:

Wash with soap approved for body shop use and water or apply 909 and wipe dry

3. Scuff:

Scuff with Gray to Gold scuff pad and 851/ 855 SharkBite or P600-P800 equivalent scuff pad.
BE SURE TO KEEP 851 WET, DO NOT ALLOW 851/855 TO DRY ON THE PANEL.

4. Re-Clean:

Triple rinse with clean water noting sheeting or beading of water.

5. Final Wipe:

Apply 909 and wipe completely dry

6. Tack:

Using a Tack-Rag (BASF B120) to remove any dust and lint

Optional:

Apply 903 Anti-Static Treatment and allow to dry completely

7. Apply appropriate R-M undercoat and/or topcoat

* Refer to product recommendation table

Raw Plastics Preparation Procedure:

1. Clean:

Wash with soap and water or apply 909 and wipe dry

2. Clean:

Apply 902 or AM902 thoroughly and wipe dry with **PPW300** Wipes. Both must be allowed to flash for 15 minutes under ventilation.

3. Scuff:

Scuff with 3M Gray to Gold scuff pad and 851/ 855 SharkBite or P600-P800 equivalent scuff pad.
BE SURE TO KEEP 851/855 WET, DO NOT ALLOW 851/855 TO DRY ON THE PANEL.

4. Re-Clean:

Triple rinse with clean water noting sheeting or beading of water.

5. Final Wipe:

Apply 909 and wipe completely dry and allow to flash completely.

6. Tack:

Use a Tack-Rag (BASF B120) to remove any dust and lint

Optional:

Apply 903 Anti-Static Treatment and allow to flash completely.

7. Apply appropriate R-M Plastic Adhesion Promoter

* Refer to product recommendation table

8. Apply appropriate R-M undercoat and/or topcoat

Plastic Success Tips

Cleaning and Testing:

- Proper cleaning will ensure a warrantable repair
- 851 and 855 will assist with cleaning of water based mold release compounds
    - Rinse both completely; do not allow either to dry on the surface
- 902 provides an aggressive cleaner targeted toward solvent based contaminants and mold release agents, intended to be used in well ventilated areas

Plastic Success Tips

(continued)

Cleaning and Testing (continued):

- If 902 is used it must flash for 15 minutes under well ventilated conditions
- Solvent testing with 902 is critical to ensure a warrantable repair
- If solvent testing fails; strip part and proceed as raw

Flex Agent

- Flex agents are designed to help the topcoat flex at the same rate as the substrate
- Flex is not required for rigid plastics
- Primers, sealer and most clearcoats require flex agent to ensure a lasting repair
- 868 and 869 **do not** require additional components
- 870, 875, 876 and R-M basecoats do not require flex agent added for flexible plastics

903 Options as an Antistat Coating

- 903 can be used to help reduce static electricity and ensure a cleaner substrate
- 903 can also be applied as a non wiping antistatic coating
    - Spray an even coat over the entire area, allow to fully dry and proceed with proper adhesion promoters and or topcoats
- 903 is used as a final step before the application of adhesion promoter or basecoat. It should be used only after all sanding, cleaning, and tacking is complete.

Critical Recommendation:

900, 901 and AM900 are not to be used on plastics due to static discharge and flammability hazards

Follow these recommendations for successful plastic refinish and repair

Safety

Materials described are for application by professional trained personnel only using proper equipment. Products may be hazardous and should be used according to label directions and technical data information. Appropriate respiratory protection should be worn at all times while products are in use - read product label and Material Safety Data Sheet (MSDS) for specific details. Statements and methods described are based upon the latest standard of technology known to the manufacturer Application procedures cited are suggestions only and are not to be interpreted as warranty for events resulting from their use. Dilution ratios are intended to provide maximum performance within the typical Volatile Organic Compound (VOC) restriction for product use. Specific VOC limits need to be referenced to verify local compliance. Altering the solvent or dilution ratio may impact VOC compliance. User is solely responsible to ensure product use and application is in accordance with all applicable regulatory, legislative, and municipal requirements.

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