



# COMMERCIAL COATINGS

CCTB-01

## TPO Plastic Preparation Procedure and Paint Systems

This bulletin provides paint technicians with the proper preparation procedure when painting bare, unprimed TPO (thermoplastic olefin) plastic with a recommended PPG DELFLEET® system. These procedures must be followed to ensure the proper adhesion of primer and paint. Use the following steps, in conjunction with the correct PPG Product Information Bulletin.

Note: Plastic composition and consistency can vary. All plastic substrates should be tested, prior to painting.

**SURFACE PREPARATION:** Proper cleaning procedures are very important. Use the following steps:










- ❖ Thoroughly clean and scuff the area to be painted with the ONECHOICE® SU4901 Clean and Scuff Sponge or SX1002 Sanding Paste and a gray scuff pad, rinse with clean water. **Note: Water should sheet (run-off) from the surface. If water beads up, repeat the cleaning process before proceeding.**
- ❖ Blow or wipe dry with a clean cloth and ensure that the entire surface has been totally deglossed. Change clean cloths as often as needed.
- ❖ Final clean with *OneChoice* Commercial CFX435LV Low VOC Cleaner.
- ❖ Be sure the surface is thoroughly dry before proceeding and use a tack cloth to eliminate dirt prior to applying SU470LV / SUA470LV 1K Compliant Adhesion Promoter.
- ❖ To ensure maximum adhesion after cleaning, SU470LV / SUA470LV 1K Compliant Adhesion Promoter should be applied immediately following the cleaning process.

**APPLY PLASTIC PRIMER:** Refer to product data sheet OC-35 (SU470LV / SUA470LV aerosol)



- ❖ Hand shake SU470LV well before each use.
- ❖ SU470LV may be left in a spray gun for up to 8 hours.
- ❖ When using SUA470LV aerosol, vigorously hand shake spray can for one minute to ensure uniformity and to prevent clogging.

## APPLICATION DATA

<b>Selection of Substrate Cleaner:</b>  <b>ONECHOICE® Commercial CFX Cleaner</b>		<b>Code</b> CFX435LV	<b>Product</b> Low VOC Cleaner	<b>Purpose</b> Compliant cleaner suitable for removing dirt, grease or other contaminants before or during the painting process.									
<b>Application:</b>		<b>Apply:</b> 1 medium wet coat <b>Note:</b> The pigmentation in this product is intended to visually aid you in applying the product. If you have sprayed this product to hiding you have exceeded the maximum film build of the product, which will negatively affect cure.											
<b>Mixing Ratio:</b>		SU470LV / SUA470LV is packaged ready-to-spray.											
<b>Pot Life:</b>		Indefinite											
<b>Spray Gun Set-up:</b>		<table border="1"> <thead> <tr> <th></th> <th>HVLP</th> <th>Compliant</th> </tr> </thead> <tbody> <tr> <td><b>Fluid Tip:</b></td> <td>1.3 – 1.5 mm or equivalent</td> <td>1.3 – 1.5 mm or equivalent</td> </tr> <tr> <td><b>Air Pressure:</b></td> <td>10 PSI at the cap</td> <td>29 - 40 PSI at the gun</td> </tr> </tbody> </table> <p><b>Note:</b> For best overall results, refer to spray gun manufacturer's recommendations for the inlet air pressures.</p>				HVLP	Compliant	<b>Fluid Tip:</b>	1.3 – 1.5 mm or equivalent	1.3 – 1.5 mm or equivalent	<b>Air Pressure:</b>	10 PSI at the cap	29 - 40 PSI at the gun
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<b>Number of Coats:</b>	 	1 medium wet coat  <b>Note:</b> The pigmentation in this product is intended to visually aid you in applying the product. If you have sprayed this product to hiding you have exceeded the maximum film build of the product, which will negatively affect cure.											
<b>Dry Times:</b>		<b>Before topcoating:</b> 70°F (21°C) 10 minutes *If longer than 1 hour, lightly sand, re-clean and re-apply SU470LV / SUA470LV  <b>Note:</b> Priming or sealing prior to top coating will improve the systems overall performance and should be applied as soon as SU470LV / SUA470LV is dry to avoid contamination of the plastic part.											

### SELECT/APPLY RECOMMENDED DELFLEET® EVOLUTION OR DELFLEET ESSENTIAL® PRIMER OR SEALER PRODUCT:

- Delfleet Evolution F3970 Ultra High Solids Primer** (product data sheet DFT-052)
- Delfleet Evolution F3993 Conventional Epoxy Primer** (product data sheet DFT-057)
- Delfleet Evolution F4943 2.1 VOC Fast Dry Urethane Sealer** (product data sheet DFT-074)
- Delfleet Essential ESU460 4.6 VOC Epoxy Primer** (product data sheet DFE-06)
- Delfleet Essential ESU480 2.1 VOC Epoxy Primer** (product data sheet DFE-10)

Refer to specific product data sheet for primers/sealer mix ratio, spray gun settings, air pressure, application, potlife and flash time between coats and before topcoat information.

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## SELECT and APPLY TOPCOAT:

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Selection of **DELFLLEET® EVOLUTION** or **DELFLLEET ESSENTIAL®** topcoat should be based upon VOC and color requirements. Please refer to the specific product data sheet for details.

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### Health and Safety:



Safety Data Sheets (SDS) for the PPG products mentioned in this publication are available through [www.ppgcommercialcoatings.com](http://www.ppgcommercialcoatings.com) (Safety, SDS Search) or your PPG Distributor.

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**For additional information regarding this product, see the SDS and LABEL information.**

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### EMERGENCY MEDICAL OR SPILL CONTROL INFORMATION (412) 434-4515; IN CANADA (514) 645-1320 AND IN MEXICO 01-800-00-21-400.

Materials described are designed for application by professional, trained personnel using proper equipment and are not intended for sale to the public. Products mentioned may be hazardous and should only be used according to directions, while observing precautions and warning statements listed on label. Statements and methods described are based upon the best information and practices known to PPG Industries. Procedures for applications mentioned are suggestions only and are not to be construed as representations or warranties as to performance, results, or fitness for any intended use, nor does PPG Industries warrant freedom from patent infringement in the use of any formula or process set forth herein.

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