



# 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:

Refer to product data sheet OC-35 (SU470LV / SUA470LV aerosol)  
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:

SU470LV / SUA470LV is packaged ready-to-spray.

Pot Life: Indefinite

- ❖ 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

Selection of Substrate Cleaner:	Code	Product	Purpose									
<b>ONECHOICE® Commercial CFX Cleaner</b> 	CFX435LV	Low VOC Cleaner	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 RTS:</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>		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>Air Pressure:</b>	10 PSI at the cap	29 - 40 PSI at the gun										
		<b>Note:</b> For best overall results, refer to spray gun manufacturer's recommendations for the inlet air pressures.										
<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> Sealing or priming 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 ONE™, DELFLEET® EVOLUTION OR DELFLEET ESSENTIAL® SEALER OR PRIMER PRODUCT:

- Delfleet One F8801 Thin Film Epoxy Primer** (product data sheet DFO-101)
- Delfleet One F8810 Urethane Primer** (product data sheet DFO-111)
- Delfleet One F8812 Fast Dry Sealer** (product data sheet DFO-113)
- 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 ONE™**, **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.**

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