

## Standard Operating Procedure

### New OEM E-coat Panel Wet on Wet



# OCTORAL

1.		<ul style="list-style-type: none"><li>• CLEAN PANEL THOROUGHLY</li><li>• USING OCTORAL CLEANERS <b>TD20</b> AND <b>TD80</b></li></ul>
2.		<ul style="list-style-type: none"><li>• INSPECT OEM PANEL FOR ANY IMPERFECTIONS</li><li>• REMOVE IF NECESSARY, USING <b>P320-P400</b></li></ul>
3.		<ul style="list-style-type: none"><li>• CLEAN PANEL WITH CLEANERS <b>TD20</b> AND <b>TD80</b></li><li>• TACK RAG OEM PANEL</li></ul>
4.		<ul style="list-style-type: none"><li>• USING A <b>T2 / TE20</b> AIR CAP</li><li>• <b>PH254 @ 5:1 WITH H25 HS420 HARDENER + 25% TA910 THINNER</b></li><li>• APPLY <b>1</b> FULL COAT OVER SURFACE <b>@ 2 – 2.5 BAR</b></li></ul>
5.		<ul style="list-style-type: none"><li>• ALLOW APPROPRIATE FLASH OFF TIME</li><li>• <b>PH254 = 12 – 15 MINUTES MIN.</b> @ 20-25 DEGREES</li><li>• <b>PH254 = 48 HOURS MAX.</b> @ 20-25 DEGREES</li></ul>
6.		<ul style="list-style-type: none"><li>• APPLY <b>OCTORAL ECO+</b> AS PER S.O.P.</li><li>• APPLY APPLICABLE <b>OCTORAL TOPCOAT</b> AS PER S.O.P.</li></ul>