

# Standard Operating Procedure

## OEM Plastic Wet on Wet (PH254 BL/WH) S.O.P

1.		<ul style="list-style-type: none"><li>CLEAN SURFACE WITH WARM SOAPY WATER</li></ul>
2.		<ul style="list-style-type: none"><li>PREPARE PLASTIC PART WITH GREY SCOTCH BRITE</li></ul>
3.		<ul style="list-style-type: none"><li>CLEAN SURFACE WITH <b>TD25</b> ANTISTATIC DEGREASER</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% PA65 PLASTIC PRIMER</b></li><li>APPLY <b>1</b> FULL COAT OVER SURFACE @ <b>2 – 2.5 BAR</b></li><li>THIS CAN ALSO BE USED OVER OEM E-COAT PANELS</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><li>APPLY OCTORAL ECO+ WATERBASE AS PER S.O.P.</li></ul>
6.		<ul style="list-style-type: none"><li>ALLOW ECO+ TO FLASH OFF</li><li>TACK RAG IF NECESSARY</li><li>APPLY APPLICABLE OCTORAL TOPCOAT AS PER S.O.P.</li></ul>