

STANDARD OPERATING PROCEDURE

Prep & Sanding Metal Substrates

Sand to Prime

Sand to Paint

	Sand to Prime	Sand to Paint
Inspect	1 Inspect repair area for defects. Assure area is properly repaired & prepped. Return to body dept if necessary.	1 Inspect repair area for defects. Assure area is properly prepped & primed. Return to body/prep dept if necessary.
Clean	2 Clean repair area with solvent-borne degreaser, SCAT #6311 or Speedi SCAT #6321.	2 Clean repair area with solvent-borne degreaser, SCAT #6311 or Speedi SCAT #6321.
	3 Clean with waterborne degreaser, Aqua SCAT 2 #1394.	3 Clean with waterborne degreaser, Aqua SCAT 2 #1394.
Sand	4 Sand repair area with 180-240 grit on palm sander.	4 Apply Low Spot Finder Guide Coat #9183 to surface. Block sand primed area with 320 grit (wet or dry) to eliminate orange peel.
	5 Sand surrounding area with red scuff pad.	5 Apply Low Spot Finder Guide Coat #9183 again. Finish sanding repair area with 400-600 grit on palm sander.
		6 Dull shiny areas for blend with 800-1000 grit (wet or dry) or gray/green scuff pad & Scuff /Prep Paste #6338.
Clean	6 Blow off vehicle. Wipe repair area with Aqua SCAT 2 #1394.	7 Blow off vehicle/wash off paste. Wipe with Aqua SCAT 2 #1394.
Mask	7 Mask area to be primed.	8 Move vehicle into spray booth. Mask area to be painted.
Clean	8 Wipe repair area with Aqua SCAT 2 #1394.	9 Wipe with Aqua SCAT 2 #1394.
Prime	9 On Exposed Bare Metal: Tack off. Apply corrosion protection primer.	10 On Exposed Bare Metal: Tack off. Apply corrosion protection primer.
Prime	10 Tack off. Apply primer surfacer to repair area according to TDS using <i>Outside-in method</i> .	
	Go to column 2, Step 1.	
Topcoat		11 Apply sealer & topcoat per Transtar SOP 509. For blending, see SOP 513/4.

SUGGESTED MATERIAL FOR JOB

- Transtar Solvent-borne Degreaser, #6311 / #6321 ● Transtar Waterborne degreaser, #1394 ● Lint-free Towels
- Sandpaper – various grits ● Sanding blocks ● Palm Sander ● Scuff pads ● Transtar Scuff & Prep Paste, #6338
- Transtar Guide Coat, #9183 ● Tack rags ● Transtar Corrosion Protection Primer ● Transtar Primer Surfacer

* Always refer to Transtar Technical Data Sheet (TDS) for specific product application, suitable substrates & other product information.