



STANDARD OPERATING PROCEDURE

Topcoat - Full Panel / Complete

Application with No Mix® HS & MS Basecoat – Solid & Metallic Colors

Inspect	1 Inspect vehicle/part for proper preparation (sanding, corrosion protection, cleanliness). For Prep & Sanding, see Transtar SOP 051. For Steel Finishing, see SOP 111. For plastic finishing, see SOP 251/2.
Mix	2 Mix basecoat color using No Mix PLUS software & scale. See Transtar SOP 501 for Color Selection & Matching. When topcoating panel(s), assure a blendable color match is achieved. Always mix with Basecoat Activator.
Mask	3 Move vehicle into spray booth. Mask off vehicle.
Clean	4 Blow off vehicle/part. Clean panel(s) with waterborne degreaser, Aqua SCAT 2 #1394.
Seal	5 Tack off vehicle/part. Apply Transtar sealer (if necessary) to entire part/vehicle. For improved hiding, select proper Star Shade value. Follow Transtar TDS for sealer. Allow proper flash time.
Basecoat	6 Tack off. Apply No Mix basecoat 2-3 coats or until hiding is achieved. Allow 5-10 minute flash time. Tack off between coats. When painting one panel, it may be necessary to blend color onto adjacent panel(s). For Blending, see SOP 513/4.
Inspect	7 Check application to assure proper coverage. Turn lights off in booth to check color with a single light source. If coverage is not acceptable, apply additional coat(s).
Dry	Allow basecoat to dry 15-20 minutes before application of clearcoat. Dry times may vary due to shop temperature & reducer selection. Recoat time of activated basecoat is 2 hours @ 77°F.
Mix	8 Mix clearcoat according to Transtar TDS. On plastic substrates, mix clearcoat with Flex Additive, #9194, per TDS.
Clear	9 Tack off vehicle/part. Apply 2-3 coats of clearcoat per TDS. Clearcoat the entire panel whenever possible. Assure a minimum dry film thickness of 2 mils after sanding & buffing.

- For Clearcoat Defect Removal, see SOP 817.
- For Blending Solids/Metallics, see SOP 513. • For Blending Tri-Coats, see SOP 514.
- Refer to OEM recommendations for repair & refinish as some manufacturers have specific procedures for warranty repairs.

SUGGESTED MATERIALS FOR JOB

- Transtar Waterborne degreaser, #1394 • Lint-free towels • Masking materials • Tack rags • Transtar Sealer
- Transtar No Mix Basecoat • Transtar Reducer • Transtar Basecoat Activator • Transtar Clearcoat

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