



STANDARD OPERATING PROCEDURE

Clearcoat Defect Removal

Removal of Dirt, Orange Peel & Surface Imperfections

Inspect	1	Inspect surface area for dirt nibs, runs, orange peel & other surface defects. For extreme defects, sanding & re-application of clearcoat may be necessary.	
	2	Blow off vehicle. Clean surface with waterborne degreaser, Aqua SCAT 2 #1394. Ensure surface is dust free.	
	3	To prevent excessive clean up & burn through of edges, carefully tape gaps, adjacent panels, moldings, plastic parts, etc.	
Sand	Important: Always allow proper curing before starting to cut/buff. See Transtar Clearcoat TDS for detail.		
	4	Select the appropriate grit of sandpaper to start. Then move to the next finer grit. <ul style="list-style-type: none"> • Severe/moderate defects: 1000-1200 • Moderate/mild defects: 1200-1500 • Mild/light defects: 1500-3000 	
	5	If wet sanding, wet the paper or surface using clean water in a bucket & squirt bottle. Continually rewet surface to remove sanding dust. Pre-soak the sandpaper.	
	6	Using appropriate size & shape block/pad & light pressure, sand areas where defects are present. Avoid sanding along edges of panels.	
Clean	7	After sanding an area, clean surface with clean water. Wipe with a microfiber towel or squeegee. Dry with towel. Use an air nozzle to help dry if necessary. Inspect surface for high spots or remaining surface defects. Repeat Step 5-7 if necessary. Then move to the next area.	
Sand	8	Repeat step 4-7 on remaining panels, moving to a finer grit until surface defects are removed.	
Compound / Buff	After removing orange peel, runs & dirt nibs, apply compound / machine polish. Do NOT polish in direct sunlight or if vehicle is excessively hot.		
	Transtar 1-Product System		Transtar 3-Product System
	9	Buff with Tri-Cut II Compound system #5331. Start with Orange Cutting Compound Foam Pad #5272. Buff until major scratches are removed. For faster cutting, use wool pad #5200 or #5260.	9 Buff with Cutting Compound #5361 & Orange Cutting Compound Foam Pad #5272. Buff until major scratches are removed. For faster cutting, use wool pad #5200 or #5260.
	10	Buff with #5331 compound & White Machine Polish Foam Pad #5282. Buff until moderate scratches are removed.	10 Buff with Machine Polish #5374 & White Machine Polish Foam Pad #5282. Buff until moderate scratches are removed.
	11	Finish rubbing with #5331 compound on Gold Swirl Remover Foam Pad #5292. Buff until minor scratches are removed.	11 Finish polishing with Swirl Remover #5384 & Gold Swirl Remove Foam Pad #5292. Buff until minor scratches are removed.
	Move buffer in linear motion. Work in 2 ft. areas. Important: Do not remove excess clearcoat. Maintain minimum 2.0 mils of dry film thickness after cut & buff.		
Clean	12	Clean with Aqua SCAT 2 #1394. Wipe cleaner off with microfiber towel. Inspect surface. Repeat step 9-11 until scratches disappear.	

SUGGESTED MATERIALS FOR JOB

- Bucket of clean water • Squirt bottle with water • Dishwashing soap (to lubricate sanding surface) • Transtar degreaser #1394
- Lint-free Towels • Sandpaper – various grits • Sanding blocks / pads • Buffer/ Polisher
- Transtar Compound / Polish • Transtar Polishing pads

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