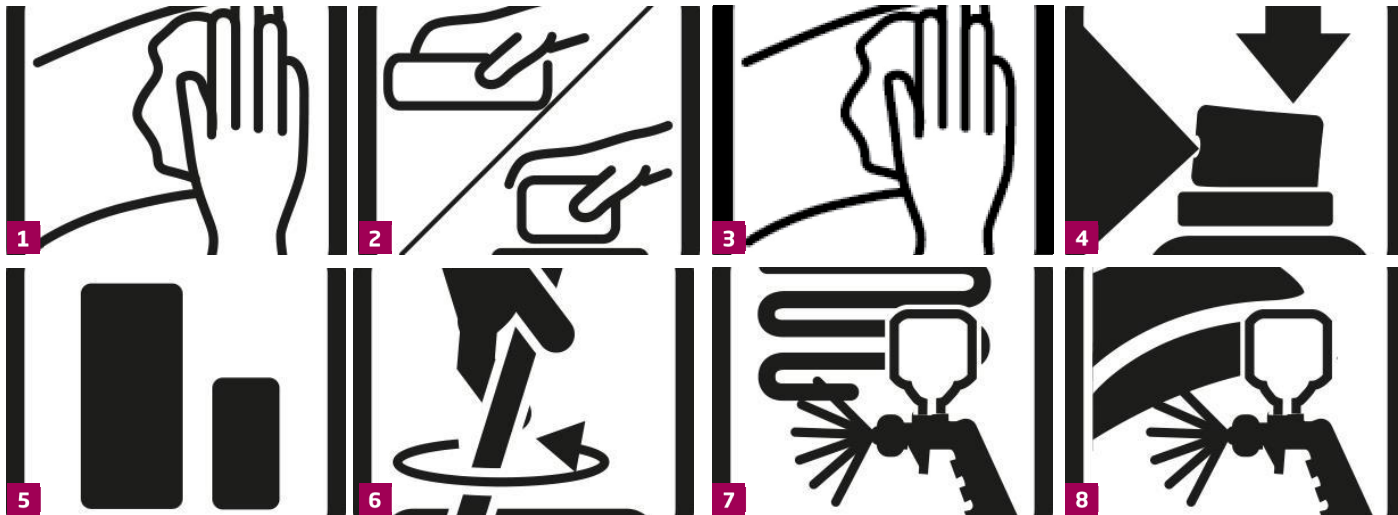


REPAIR PROCESS

RAPTOR TEXTURE COAT REPLACEMENT PROCESS



DRIVING SURFACE PERFECTION™



Step 1: Inspect / clean panel

Clean / Degrease with solvent or waterborne degreaser UP2002, UP2012, UP2022 or equivalent.

Step 2: Sand surface

Painted Surfaces: P180 - P320
Flexible Plastics (TPO, PP, EPDM)**: P180 - P320
Bare Steel: P80 - P180
Aluminum, Galvanized: P120 - P180
Fiberglass, SMC, Carbon Fiber: P120 - P180 grit
E-Coat: Coarse abrasive pad

Step 3: Re-Clean

Blow off with compressed air.
Re-clean / degrease with solvent or waterborne degreaser UP2002, UP2012, UP2022 or equivalent

Step 4: Prime

1) Prime any exposed bare metal, aluminum or galvanized areas with UP0741V ACID# or UP4842 RAPTOR 2K Aerosol Epoxy Primer.
2) Flexible plastics (TPO, PP, EPDM): prime with UP0799 GRIP #4 Adhesion Promoter.

Note: Polyethylene (PE/HDPE) cannot be coated.

Step 5: Mix Raptor

A) From bottle (fill level 24 fl. oz.): pour 8 fl.oz. (237ml) hardener into bottle and shake for 2 minutes.
B) From mixing bank: Mix ratio is 3:1 in graduated mix cup.
1 activated quart yields theoretical 2 coat coverage over 21.5 sq ft (2 square meters).

Note: RAPTOR may be reduced 10-20% with urethane reducer based on desired texture and application equipment used.

Step 6 Tinting

Mix 3 fl. oz. solvent basecoat toner* per activated quart of tintable RAPTOR. Mix / Shake thoroughly for 2 minutes until well mixed.

Note: Refer to RAPTOR Tintable TDS Guide for additional mixing and tinting guidelines.

- Raptor cannot be tinted with water-borne paint systems

Step 7: Equipment set-up

1) Application from Raptor bottle: Thread RAPTOR gun (UP0726 or UP4880.) onto bottle. Adjust air inlet pressure between 40-60 psi. Hold gun 18 - 24" from surface. Adjust distance, speed, and air pressure to achieve desired texture.
2) Application with 3M Performance Gun H/O set-up with 2.0 nozzle: Pour mixed / activated RAPTOR into spray gun cup. Starting point guidelines: Spray test panel and adjust inlet air pressure, H/O pressure adjustment knob, fluid adjustment and fan pattern knobs to achieve desired texture. Adjust inlet gun pressure between 5 psi and 15 psi (depending on desired texture). From closed position, open fan adjustment knob, fluid adjustment knob and H/O pressure adjustment knob 1 full turn.

Note: Refer to RAPTOR Wall Chart Texture Guide and Equipment Selector for additional texture recommendations.

Step 8: Apply RAPTOR

Apply 2 coats to ensure full uniform coverage. Flash time: Allow 15 minute flash time @70F (20C) between coats. Allow final coat to dry 30 minutes or longer @ 70F (20C) before applying topcoat per manufactures guidelines. RAPTOR can be directly top coated with solvent borne paint systems. Follow paint manufacturer guidelines for base coat / clear coat flash and dry times. When applying water-borne base coats, follow paint manufactures guidelines for sealing prior to applying water-borne base coat and appropriate clear coat guidelines.

Note: To accelerate flash time RAPTOR can be short baked @ 140F (60C) for 15 minutes prior to topcoat application.

For additional prep and application guidelines refer to RAPTOR TDS Guide

Step 9: Dry times

Bake booth: After application of base and clear Raptor can be baked @ 140F (60C) for 30 minutes. Follow paint manufacturers guidelines.
Air Dry @ 70F (20C):
Dry to touch: 1 hour



BE SMART:
CLEAN AND TIDY UP



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