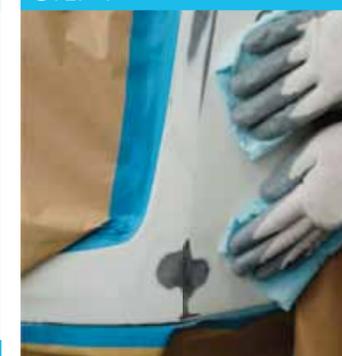




# OCTORAL

# PLASTIC REPAIR

<p><b>STEP 1</b></p> 	<p><b>PREPARATION</b></p> <ul style="list-style-type: none"> <li>Inspect small plastic repair damage.</li> <li>Degrease and clean repair area &amp; adjacent area.</li> <li>Cleaning:             <ul style="list-style-type: none"> <li>Air blow.</li> </ul> </li> </ul>	<p><b>STEP 2</b></p> 	<p><b>COLOUR CHECK</b></p> <ul style="list-style-type: none"> <li>Option 1: Use the Valspar Spectrophotometer.</li> <li>Option 2: Check for identification plate colour code.</li> <li>Refer to Valspar Color Box.</li> <li>Check for the best match.</li> <li>Mix the formulation in the required quality and quantity.</li> <li>Make spray out for colour match.</li> </ul>
<p><b>STEP 3</b></p> 	<p><b>SAND &amp; ROUGH MASK</b></p> <ul style="list-style-type: none"> <li>Sanding with limited step increments e.g. P120-P240-P320.</li> <li>Area where blending, sand with P1000             <ul style="list-style-type: none"> <li>P2000 Trizact or equivalent.</li> </ul> </li> <li>Clean and degrease.</li> <li>Rough masking application.</li> <li>Clean and degrease once more.</li> <li>Cleaning:             <ul style="list-style-type: none"> <li>Air blow</li> <li>Tack rag.</li> </ul> </li> </ul>	<p><b>STEP 4</b></p> 	<p><b>FINAL MASKING</b></p> <ul style="list-style-type: none"> <li>For small repairs, mask directly for basecoat application.</li> <li>Place masking paper over the top of this for priming.</li> <li>Degrease:             <ul style="list-style-type: none"> <li>Anti static degreaser</li> <li>Airblow and tack rag.</li> </ul> </li> </ul>
<p><b>STEP 5</b></p> 	<p><b>PLASTIC PRIMER</b></p> <ul style="list-style-type: none"> <li>Apply 1 coat of plastic primer on the repair area.</li> <li>Flash off.</li> </ul>	<p><b>STEP 6</b></p> 	<p><b>SURFACER APPLICATION</b></p> <ul style="list-style-type: none"> <li>Apply 1-3* coats of surfacer allowing for flash off in between.             <ul style="list-style-type: none"> <li>*Depending on final sanding &amp; filling requirements.</li> </ul> </li> <li>If repairing a flexible plastic part, you will be required to add the elastic additive when mixing to give the primer filler more flexibility over a plastic part, this can be added from 5-30% depending on how flexible the part is, consult TDS for more detailed information.</li> <li>Drying:             <ul style="list-style-type: none"> <li>Infra Red or</li> <li>Force drying at 60°C/140°F.</li> </ul> </li> </ul>
<p><b>STEP 7</b></p> 	<p><b>FINAL SAND &amp; CLEAN</b></p> <ul style="list-style-type: none"> <li>Sand carefully using P400 or P500 for final sand.</li> <li>Final degreasing, cleaning and tack rag before basecoat application.</li> <li>Cleaning:             <ul style="list-style-type: none"> <li>Air blow</li> <li>Tack rag.</li> </ul> </li> </ul>	<p><b>STEP 8</b></p> 	<p><b>BASECOAT APPLICATION</b></p> <ul style="list-style-type: none"> <li>Apply 1-2 coats or until dropcoat is covered.</li> <li>Spray at lower pressure and overlap each coat.</li> <li>Flash off as required.</li> </ul>
<p><b>STEP 9</b></p> 	<p><b>CLEAR COAT APPLICATION</b></p> <ul style="list-style-type: none"> <li>If repairing a flexible plastic part, you will be required to add the elastic additive when mixing to give the clearcoat more flexibility and stone chip resistance over a plastic part, this can be added from 5-30% depending on how flexible the part is, consult TDS for more detailed information.</li> <li>Apply 2 overlapping coats with flash off.</li> </ul> <p><b>FADE-OUT CLEAR COAT</b></p> <ul style="list-style-type: none"> <li>Over reduce the clear with 100% spot repair thinner and extend the area. Once more over reducing can be done for very smooth repairs (no orange peel).</li> <li>Or use the aerosol Octoral TA875 Fade-Out Thinner.</li> </ul>	<p><b>STEP 10</b></p> 	<p><b>DRYING</b></p> <ul style="list-style-type: none"> <li>Infra Red drying has the preference as that is the most economical and fastest way or.</li> <li>Force drying at 60°C/140°F.</li> <li>TIP: Points to take care of when using Infra Red: distance, half or full bake cycle, time &amp; temperature (max 70°C/158°F). Keep enough distance between plastic parts and Infra Red to prevent deformation (check instructions Infra Red).</li> </ul>
<p><b>STEP 11</b></p> 	<p><b>POLISHING</b></p> <ul style="list-style-type: none"> <li>Before starting to polish - check for through hardening.</li> <li>If areas still soft, IR dry once more.</li> <li>Polish with a fine compound at low speed to avoid generating heat.</li> <li>Complete with a finishing polish.</li> </ul>	<p><b>STEP 12</b></p> 	<p><b>FINISH</b></p> <ul style="list-style-type: none"> <li>Hand over vehicle to happy &amp; satisfied customer.</li> </ul>