



OCTORAL

PLASTIC REPAIR

<p>STEP 1</p> 	<p>PREPARATION</p> <ul style="list-style-type: none"> Inspect small plastic repair damage. Degrease and clean repair area & adjacent area. Cleaning: <ul style="list-style-type: none"> Air blow. 	<p>STEP 2</p> 	<p>COLOUR CHECK</p> <ul style="list-style-type: none"> Option 1: Use the Valspar Spectrophotometer. Option 2: Check for identification plate colour code. Refer to Valspar Color Box. Check for the best match. Mix the formulation in the required quality and quantity. Make spray out for colour match.
<p>STEP 3</p> 	<p>SAND & ROUGH MASK</p> <ul style="list-style-type: none"> Sanding with limited step increments e.g. P120-P240-P320. Area where blending, sand with P1000 <ul style="list-style-type: none"> P2000 Trizact or equivalent. Clean and degrease. Rough masking application. Clean and degrease once more. Cleaning: <ul style="list-style-type: none"> Air blow Tack rag. 	<p>STEP 4</p> 	<p>FINAL MASKING</p> <ul style="list-style-type: none"> For small repairs, mask directly for basecoat application. Place masking paper over the top of this for priming. Degrease: <ul style="list-style-type: none"> Anti static degreaser Airblow and tack rag.
<p>STEP 5</p> 	<p>PLASTIC PRIMER</p> <ul style="list-style-type: none"> Apply 1 coat of plastic primer on the repair area. Flash off. 	<p>STEP 6</p> 	<p>SURFACER APPLICATION</p> <ul style="list-style-type: none"> Apply 1-3* coats of surfacer allowing for flash off in between. <ul style="list-style-type: none"> *Depending on final sanding & filling requirements. 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. Drying: <ul style="list-style-type: none"> Infra Red or Force drying at 60°C/140°F.
<p>STEP 7</p> 	<p>FINAL SAND & CLEAN</p> <ul style="list-style-type: none"> Sand carefully using P400 or P500 for final sand. Final degreasing, cleaning and tack rag before basecoat application. Cleaning: <ul style="list-style-type: none"> Air blow Tack rag. 	<p>STEP 8</p> 	<p>BASECOAT APPLICATION</p> <ul style="list-style-type: none"> Apply 1-2 coats or until dropcoat is covered. Spray at lower pressure and overlap each coat. Flash off as required.
<p>STEP 9</p> 	<p>CLEAR COAT APPLICATION</p> <ul style="list-style-type: none"> 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. Apply 2 overlapping coats with flash off. <p>FADE-OUT CLEAR COAT</p> <ul style="list-style-type: none"> 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). Or use the aerosol Octoral TA875 Fade-Out Thinner. 	<p>STEP 10</p> 	<p>DRYING</p> <ul style="list-style-type: none"> Infra Red drying has the preference as that is the most economical and fastest way or. Force drying at 60°C/140°F. TIP: Points to take care of when using Infra Red: distance, half or full bake cycle, time & temperature (max 70°C/158°F). Keep enough distance between plastic parts and Infra Red to prevent deformation (check instructions Infra Red).
<p>STEP 11</p> 	<p>POLISHING</p> <ul style="list-style-type: none"> Before starting to polish - check for through hardening. If areas still soft, IR dry once more. Polish with a fine compound at low speed to avoid generating heat. Complete with a finishing polish. 	<p>STEP 12</p> 	<p>FINISH</p> <ul style="list-style-type: none"> Hand over vehicle to happy & satisfied customer.