

# Plastic System

## Refinishing Recommendations

### Unprimed (Bare) Plastic



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Automotive Finishes

#### Notes

**Caution:** The following “Sandable” and “Unsandable” recommendations are for bare plastic parts only.

Prior to following these recommendations, closely inspect the part to determine if the exterior has been primed. The color of OE applied primer can be similar to the color of the substrate. Look for signs of overspray on the backside of the part around edges, flanges, etc. In an inconspicuous area of the exterior, sand a small area and check for primer powdering.

#### **Identification of Bare Plastic Substrates by Sanding**

On the backside of the plastic part perform a sanding test. Clean a small area then sand using a DA finishing sander and P600 grit sandpaper. If the plastic substrate “**powders**”, the part must be thoroughly sanded following the “**Sandable**” plastic recommendations. If the plastic substrate does not powder but rather “**gums**” the paper, follow the “**Unsandable**” plastic recommendations.

#### **Unsandable Plastic**

##### **Step 1:**

- Clean all surfaces (inside and outside) thoroughly with SC155 Low VOC Plastic Surface Cleaner and a gold nylon scuffing pad.
- Thoroughly rinse with clean water and wipe dry.

##### **Step 2:**

- Thoroughly scuff sand using a gold nylon scuff pad along with USP-90 Liquid Scuffing Gel, paying close attention to small grooves and depressions.
- Thoroughly rinse off the scuffing gel with clean water and completely dry the surface.

# Plastic System Refinishing Recommendations Unprimed (Bare) Plastic (cont.)



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## Notes

### Step 3:

- Thoroughly clean the plastic substrate with SC159 Plastic / Anti-Stat Cleaner and a gold nylon scuff pad. Dry excess material with a clean cloth and re-apply the SC159, followed by wiping the part dry with a clean cloth.
- Tack surface to be painted with a clean tack cloth.

### Step 4:

- Apply 1 medium coat of UPO7226 Clear or UPO7227 gray Plastic Adhesion promoter to the bare plastic substrate to be refinished, achieving no more than .2 - .4 mils of dry film thickness. Allow 10 minutes to flash.

### Step 5:

- Apply Ultra 7000 basecoat with UH904 hardener. (1 oz of UH904 per RTS quart of basecoat)

### Step 6:

- Apply Ultra 7000 clearcoat.
- No flex additive is required in the following clearcoats:
  - ✓ CC637
  - ✓ CC639
  - ✓ CC930
  - ✓ CC939
  - ✓ CC940
  - ✓ CC947
  - ✓ CC950

# Plastic System Refinishing Recommendations Unprimed (Bare) Plastic (cont.)



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## Notes

### Sandable Plastic

#### Step 1:

- Clean all surfaces (inside and outside) thoroughly with SC155 Low VOC Plastic Surface Cleaner and a gold nylon scuffing pad.
- Thoroughly rinse with clean water and wipe dry.

#### Step 2:

- Thoroughly clean the plastic substrate with SC159 Plastic / Anti-Stat Cleaner and a gold nylon scuff pad.
- Dry excess material with a clean cloth.

#### Step 3:

- Sand thoroughly using P600, and/or a gray scuff pad and USP90 Liquid Scuffing gel.
- Thoroughly rinse off the scuffing gel with clean water and completely dry the surface.

#### Step 4:

- Thoroughly clean the plastic substrate with SC159 Plastic / Anti-Stat Cleaner. and a gold nylon scuff pad. Dry with a clean cloth.
- Tack surface to be painted with a clean tack cloth.

#### Step 5:

- Apply 1 medium coat of UPO7226 Clear or UPO7227 gray Plastic Adhesion promoter to the bare plastic substrate to be refinished, achieving no more than .2 - .4 mils of dry film thickness. Allow 10 minutes to flash.

# Plastic System Refinishing Recommendations Unprimed (Bare) Plastic (cont.)



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## Notes

### Step 6:

- Apply Ultra 7000 basecoat with UH904 hardener. (1 oz of UH904 per RTS quart of basecoat)

### Step 7:

- Apply Ultra 7000 clearcoat.
- No flex additive is required in the following clearcoats:
  - ✓ CC637
  - ✓ CC639
  - ✓ CC930
  - ✓ CC939
  - ✓ CC940
  - ✓ CC947
  - ✓ CC950

**Although the above recommendations should be sufficient for most bare plastic substrates, refer to the following page for additional technique tips for maximum performance on bare plastic substrates.**

# Plastic Refinishing

## Technique Tips For Maximum Performance on Bare Plastics



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### Notes

- When cleaning a part, always clean all sides, including the back, to avoid transferring contaminants to the outside during handling or set-up.
- For unsandable plastics, Gray, and especially Red, scuff pads have been shown to severely scratch some bare plastic parts to the point of telescoping sand scratches in the final finish. The gold scuff pad eliminates this problem, while providing adequate cleaning of the surface. Pay special attention to cleaning all edges, grooves and feature lines.
- USP-90 Scuffing Gel can be used to enhance the effectiveness of the white scuff pad.
- Use a stiff bristle brush or an appropriate scuff pad and liquid scuffing gel for textured surfaces.
- Tempering of bare plastic parts is optional, but may be beneficial when topcoat adhesion is compromised by imbedded mold release agents.
- If a part primed with UPO-7226/7227 sets overnight, use only clean water to wash any dust off prior to refinishing with hardened basecoat and clearcoat. Do not use wax and grease removers.
- When refinishing with basecoat/clearcoat hardener must be used in the basecoat color at the ratio of 16:16:1. (UH-60, UH-70, UH-80, or UH904 hardener may be used)
- No flex additive is required in the following clearcoats:  
CC637      CC639      CC930      CC939  
CC940      CC947      CC950
- Urethane Sealers S56/S57/S58 or S59 must use a flex additive. S61 transparent Adhesion promoter must use flex additive. S65 Basecoat Transparent must be used 2K only. PSE4600/4601 Epoxy requires no flex additive. P30 SpectraPrime surfacer/sealer requires no flex additive. P47 must use flex additive.