



Polypropylene PROCEDURE

PPG Tech Service: (440) 572-6111

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Use www.PPGRefinish.com for dealer locator and complete product details.

Subject: Painting Procedures for Polypropylene

This bulletin provides the painter with the proper procedures to be followed when painting Polypropylene with Concept® DCC Single Stage system. These procedures must be followed to ensure the proper adhesion of paint. Use the following steps, in conjunction with the correct PPG Product Information Bulletins.

PAIN T PROCEDURE:



WASH

Wash the entire part with soap and hot water.



DA SAND

Option 1. DA sand area to be painted using 320-400 grit dry paper.*

Option 2. Scuff sand area using gray or red scotchbrite pad.*

Option 3. Proceed to Multi- Prep step.

* Panels that were sanded/scuffed improved performance.



AIR BLOW

Air blow entire unit thoroughly.



Clean

Clean with DX 330 Acryli-Clean®. Refer to PPG Bulletin P-178.



WIPE

MULTI-PREP™

Saturate a clean white cloth, wipe in one direction only, and immediately dry with a clean cloth.

Refer to product information bulletin P-177 for more details.

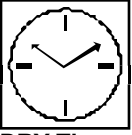
APPLY Universal Plastic Adhesion Promoter: DPX 801



APPLICATION

DPX 801 is ready to spray. No reduction is necessary.
Thoroughly shake or stir DPX 801 before use.

Apply: 1 (one) medium wet coat



DRY Times

Pot Life: N/A

Fluid Tip: 1.3 – 1.5 mm or equivalent.

Air Pressure: 7 – 10 PSI at the cap for HVLP Guns. 25 – 30 PSI at the gun for conventional guns.

Dry to topcoat: 30 minutes at 70°F (21°C)

Note: Topcoat within the same working day. If longer than 24 hours, lightly sand and re-apply DPX 801 before topcoating.

Please refer to product information bulletin P-194 for more details.

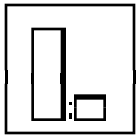
APPLY PRIMA™ Acrylic Urethane Primer Surfacer – K36

K 36 -- 5 parts

K 201 – 1 part

Pot life is _ hour at 70°F (21°C).

Up to 1 part of DT reducer may be added increasing the pot life to 1 _ hours at 70°F (21°C)



MIX RATIO

2 – 4 wet coats

1.4 – 1.6 mm or equivalent

10 psi at the cap for HVLP guns

40 – 50 psi at gun for conventional guns



APPLICATION

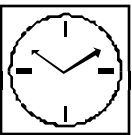
10 – 15 min. dry between coats

Dry to sand reduced: 1 – 2 hours at 70°F(21°C)

Dry to sand unreduced: 4 hours at 70°F(21°C)

Purge Time: 10 minutes @ 70°F(21°C)

Force Dry: 30 minutes at 140°F(60°C)

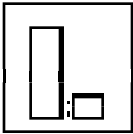


DRY TIMES

Please refer to product information bulletin P-169P for more details.

PRIMA™ may be used as a non sanding sealer.

Please refer to product information bulletin P-169S for more details.



MIX

Mix Ratio: Option 1

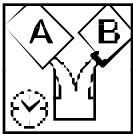
4 parts DCC
1 part DT Reducer
1 part DCX 9 or DCX 61

Mix Ratio: Option 2

4 parts DCC
1 part DT Reducer
2 parts DU 5 or DU 6

Mix Ratio: Option 3

2 parts DCC
1 part DT reducer
2 parts DFX 11



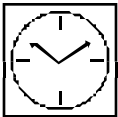
POT LIFE

Pot life **option 1** is 1 - 3 hours at 70° F & 50% RH
Pot life **option 2** is 2 – 4 hours.
Pot life option 3 is 1 – 2 hours.



TOPCOAT

Apply: 2 wet coats or until hiding
Fluid tip: 1.3 – 1.6 or equivalent
8 – 10 psi at the cap for HVLP
40 – 50 psi at the gun for conventional guns



AIR DRY

Air dry: 6 – 8 hours at 70°F (21°C)

Please refer to product information bulletin P - 168 for more details

For VOC compliant systems or clearcoat recommendations please refer to complete product information bulletins or contact your local PPG distributor.