
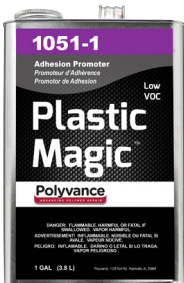







Plastic Refinishing Guide

How to refinish plastic parts after nitrogen plastic welding

To complete the plastic repair after performing a nitrogen plastic weld, the part must be refinished. This tech sheet provides an overview of the products and processes required to restore your PP/EPDM or TPO plastic bumper fascia back to its original appearance.

1. Sand Weld	After allowing the plastic weld to cool completely, sand the welding rod slightly flush with 80 grit sandpaper. Feather the paint back with 180 grit. Blow dust free with clean, dry compressed air.	
2. Adhesion Promoter	Before applying filler, apply adhesion promoter on PP/TPO substrates. (1050 Plastic Magic is National Rule-compliant; 1051 is California-compliant)	<div> <div>1050 Plastic Magic</div>  </div> <div> <div>1051 Low-VOC Plastic Magic</div>  </div>
3. Filler	Apply a skim coat of flexible or rigid filler over the repair area. Allow to cure completely, then sand with 80 and 180 grit paper.	<div> <div>2000-T Flex Filler epoxy filler</div>  </div> <div> <div>2020-T SMC Hardset Filler</div>  </div> <div> <div>1047 Putty Flex polyester glaze</div>  </div>
4. Adhesion Promoter	Before spraying primer, apply adhesion promoter again over any exposed raw plastic areas (same products as used in Step 2).	
5. Primer-Surfacer	Spray a high-build waterborne primer-surfacer over the repair area. Allow to dry completely. (All of our waterborne primer surfacers are 50-state VOC-compliant.)	<div> <div>3041 All Seasons E-Z Sand Light Gray</div>  </div> <div> <div>3043 All Seasons Black Jack</div>  </div>
6. Spot putty, sand, and prime again	Apply spot putty over any visible imperfections. Allow to dry, then sand the repair area with 220 and 320 grit paper. Prime again and repeat process until desired appearance is obtained.	

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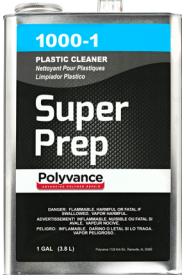





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Refinishing Repaired Plastic Parts (continued)

7a. Apply texture	<p>If the bumper is textured, apply a flexible texture coating to simulate original texture.</p> <p>(Use 3804N-4 Standard Reducer in National Rule areas and 3804R-4 Zero VOC Reducer in Low-VOC areas)</p>	<p>3804 Flextex VT Variable Texture Coating</p>  <p>3804N-4 Standard Reducer</p>  <p>3804R-4 Zero VOC Reducer</p> 
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Refinishing Raw PP/TPO Replacement Bumpers (e.g. Toyota, Nissan, Hyundai, Subaru)

1. Clean plastic	<p>Spray a heavy wet coat of 1001-4 EcoPrep or 1000 Super Prep plastic cleaner; wipe off with a clean cloth to remove mold release agents. No scuffing or sanding required.</p>	<p>1000 Super Prep Plastic Cleaner</p>  <p>1001-4 EcoPrep Zero-VOC Plastic Cleaner</p> 
2. Apply Bumper & Cladding Adhesion Primer	<p>Spray one medium coat of Bumper & Cladding Coat Adhesion Primer to hide. Allow to dry completely. Available in white, light gray, and dark gray.</p>	<p>3601 Bumper & Cladding Adhesion Promoter</p>  <p>3611 Bumper & Cladding Low VOC Adhesion Promoter</p> 
3. Topcoat	<p>Topcoat with approved base-clear system. Adhesion to raw PP / TPO substrates is guaranteed by Polyvance.</p>	



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