



# 2K LOWER PANEL PROTECTION

## STANDARD OPERATING PROCEDURE

1

### PREP



Clean with **Scaff & Clean** and gray scuff pad. Rinse with water and dry. Clean with **SEM Solve** or **Zero VOC Surface Cleaner**. Wipe clean in one direction with clean, lint-free cloth.

2

### SAND, CLEAN & PRIME



Sand with P180 – P220 grit. Re-clean with **SEM Solve** or **Zero VOC Surface Cleaner**. Wipe clean in one direction with clean, lint-free cloth.

- ① “Back-taping” helps eliminate any heavy edges and provides smooth transition to other surfaces.
- ⚠ Prime bare metal with a direct-to-metal epoxy or 2K urethane primer. Allow primer to fully cure.

3

### MIX



If tinting, mix 8 parts **Pro-Tex™ 2K Chip Guard** to 1 part solvent-based colorant. Mix 2 parts tinted mixture to 1 part **Pro-Tex 2K Chip Guard Catalyst**. Stir well.

- ⚠ Use only automotive solvent-based paint without any binders or reducers – color only. Do not use water based or lacquer based colorants.

4A

### APPLY HEAVY TEXTURE

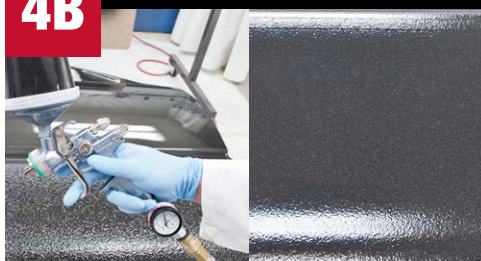


Using a **Premium Undercoat Gun & Plastic Schutz Bottle**

**Air Pressure:** 45 – 90 psi  
**Distance:** 18" – 24"  
**Coats:** 2  
**Flash time:** 10 – 20 min  
**Topcoat:** 30 min  
**Dust free:** 60 – 90 min

4B

### APPLY MEDIUM TEXTURE



Using a **Spray Gun**

**Fluid Tip:** 1.8 – 2.5  
**Air Pressure:** 45 – 90 psi  
**Distance:** 8" – 10"  
**Coats:** 2  
**Flash time:** 10 – 20 min  
**Topcoat:** 30 min  
**Dust Free:** 60 – 90 min

5

### FINISH & CLEAN



Remove masking tape while final coat is still wet. Clean gun with **XXX Gun Cleaner**.

## PRODUCT LIST



### PREP

Part	Product	Size
38391	Scaff & Clean	Gallon Pump
38398	Scaff & Clean	16 oz. Tube
38371	SEM Solve	Gallon
38373	SEM Solve	20 oz. Aerosol
38374	SEM Solve	Square Quart
40401	Zero VOC Surface Cleaner	Gallon
40404	Zero VOC Surface Cleaner	Quart



### PRIME

Part	Product	Size
ML010	Metallock™ DTM Primer Kit	1.25 Gallon
ML014	Metallock DTM Primer	Quart
MLH16	Metallock DTM Hardener	Half Pint
50121	World Class™ DTM Primer	Gallon
50124	World Class DTM Primer	Quart
50134	World Class DTM Primer Activator	Cone Top Quart
50136	World Class DTM Primer Activator	Half Pint



### APPLY

Part	Product	Size
40820	Pro-Tex™ 2K Chip Guard	3 Pint Kit

### EQUIPMENT

Part	Product	Size
71109	Premium Undercoat Gun	1 Applicator
71004	Plastic Schutz Bottle	1 Bottle
77743	XXX Gun Cleaner	20 oz. Aerosol

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