



IMRON®

Repaired Plastic Process

Step 1 | Quality Control

- Blow off with clean, dry air
- Inspect for imperfections
- If imperfections exist, return to body area

Step 2 | Sand

- Dual action (DA) sand to featheredge with P400-P600
- Sand 6-8 inches (15-20 cm) beyond the featheredge for adhesion of primer/surfacer

Step 3 | Clean

- Thoroughly clean surface with Axalta 210 or 220 as per Surface Cleaning SOP

Step 4 | Adhesion Promoter

- Apply 1 light coat of Axalta 300 or 305 Adhesion Promoter to raw plastic areas only as per TDS

Step 5 | Surfacer

- Apply primer mixed as per Surfacer SOP and TDS
- Use the outside-in process as per Surfacer SOP
- Dry as per surfacer TDS

Step 6 | Sand

- Sand surfacer as per Sanding Surfacer SOP

Step 7 | 5S (Sort, Straighten, Shine, Standardize, and Sustain)

- Clean and return all items back to their proper place