



STANDARD OPERATING PROCEDURE FOR COATING FLEXIBLE PLASTIC COMPONENTS

TPO, EDPM, Polypropylene, and most flexible plastics

RAPTOR is suitable for use on most flexible plastics, including TPO, EDPM, and Polypropylene. For application instructions on all other substrates, see the full Standard Operating Procedure, included instructions, or the Technical Data Sheet.

Tools Required:

- RAPTOR Product
- Protective Eye Glasses
- Respirator
- Latex or Nitrile Gloves
- GRIP#4
- 120-320 Grit Sandpaper
- Red Scuff Pad
- RAPTOR Application Gun (UP0726) or Roller

1 CLEAN SUBSTRATE	Remove any loose material. Clean and degrease surface with a wax and grease remover that is compatible with plastics, like U-POL UP2002 water-based degreaser.	6 SHOOT	Attach the RAPTOR Application Gun (UP0726) to the bottle. Adjust supplied air pressure to 40-60 PSI. At a distance of 18 - 30 inches, apply to the prepared surface in a sweeping motion. Different textures can be created by adjusting the air pressure, distance, and gun tip size as well as using different types of spray guns. Pot life: Approximately 60 minutes @ 68°F.
2 SAND SURFACE	Lightly sand the surface with 220-320 grit sand paper. Use a red scuff pad for difficult to sand areas. Blow off loose material. To avoid solvent entrapment, DO NOT reclean the surface.	7 ADDITIONAL COATS	Applying 2-3 light coats are better than applying one heavy coat. Allow RAPTOR to flash off 60 minutes in between coats. If more than 5 hours in between coats, allow RAPTOR to set overnight, then lightly scuff and apply additional coat(s).
3 PRIME SURFACE	RAPTOR can be applied over cleaned and sanded painted rigid plastic surfaces. RAPTOR does not adhere directly to flexible plastics. Prime any exposed plastic with 2 coats of U-POL GRIP#4 Universal Adhesion Promoter Aerosol and allow to dry for 15 - 20 minutes.	8 TOP COATING	RAPTOR can be overpainted with most paint systems. Allow RAPTOR to dry for 24 hours, scuff with a fine scuff pad, clean, apply a top coat or a clearcoat if desired.
4 MIX RAPTOR	RAPTOR has a 3:1 mix ratio. Pour 250ml of the RAPTOR hardener into the pre-filled bottle of 750 ml of RAPTOR coating or combine RAPTOR and hardener at a 3 parts RAPTOR to 1 part hardener ratio in a separate container. For tinting, please consult the technical datasheet.	9 DRY TIMES	Dry to touch: 1 hour Light duty use: 2-3 days Heavy duty use: 7 days RAPTOR can be baked for 30 minutes at 140°F; however you should still wait the dry times above. Avoid contact with water, including rain, for the first 24 hours.
5 SHAKE	Shake the bottle or stir (if mixing in a separate container) for 2 minutes to thoroughly mix the product.	10 EQUIPMENT CLEAN UP	Clean gun, equipment and overspray with lacquer thinner or acetone before RAPTOR is fully cured.