New Parts (Factory Primer) Refinishing

Best Demonstrated Practices

Area: Paint Prep

**STEP 1:**
Solvent test E-Coat. If insoluble proceed to Step 2. If E-Coat is soluble, remove E-Coat and follow "Repaired Metal Part Refinishing" procedure.

**STEP 2:**
Thoroughly clean part with FA1XSC Surface Cleaner or for VOC restricted areas use 4600800 AWX Performance Plus” Waterborne Spray Gun and Surface Cleaner.

**STEP 3:**
Remove Factory E-Coat imperfections using a DA with P600 grit sandpaper on an interface pad with no break through to E-Coat. NOTE: If P30/P27 Sealer was applied to the exterior of the new part in the “Jambing Parts Refinishing” procedure, sand the P30/P27 Sealer with P600 grit before topcoating.

**STEP 4:**
Re-clean the new part with FA1XSC Surface Cleaner or for VOC restricted areas use 4600800 AWX Performance Plus” Waterborne Spray Gun and Surface Cleaner.

**STEP 5:**
Small cut-throughs in the factory coating may be treated with P30 or P27 Primer Sealer. Large areas must be treated with PE995 or E2G970 Corrosion Shield® Primer.

Area: Spray Booth

**STEP 6:**
Apply 1 full even wet coat of P30 or P27 Primer Sealer. Allow to flash handslick before topcoating. NOTE: If the exterior of the new part has been prepared using the “NOTE” under Step 3, no additional P30/P27 Sealer is required and can be directly topcoated.

**STEP 7:**
Apply AWX Performance Plus® Basecoat until coverage is achieved. If blending is necessary, refer to 4550500 AWX Performance Plus® Blender.

**STEP 8:**
Allow the AWX Performance Plus® Basecoat to flash 15–30 minutes or until fully dehydrated before clearcoating.

**STEP 9:**
Apply one of the Sherwin-Williams Automotive Finishes Premium Clearcoats - check local VOC regulations. Follow all mixing and application recommendations on the Product Data Sheets.

See Safety Data Sheet and Labels for additional safety information and handling instructions. Safety Data Sheets for the products contained on this Product Data Sheet can be located at www.sherwin-automotive.com. Products shall not be repackaged, modified, blended, or tinted except as specifically instructed by Sherwin-Williams, including but not limited to the incorporation of non Sherwin-Williams products or the use or addition of products in proportions not specified by Sherwin-Williams. Before opening the packages, READ AND FOLLOW WARNING LABELS ON ALL COMPONENTS.

WARNING: This product contains chemicals known to the State of California to cause cancer and birth defects or other reproductive harm. For additional product information, please contact (216) 566-2917.