








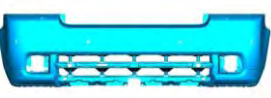
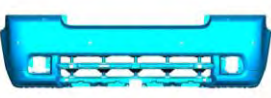
# Land Rover Standard Operating Procedure

Plastic coating process for new replacement parts

## Landrover Plastic Paint Guidelines

Plastic parts such as bumpers, mirror covers and external trim finishers are painted to match the vehicle body colour. Successful finishing of these parts is dependent on thorough preparation, cleaning and, the use of the correct products to protect the vehicle and part warranty.



<p>01. <b>New replacement plastic part preparation</b></p>	<p>Inspect parts for damage and establish if the part is pre-primed?  Or raw plastic?</p>			<p>If unsure inspect the inside of the cover for primer overspray.</p>		
<p>02. <b>New un-primed raw plastic part Part A</b></p>	<p>Clean with Plastic cleaner or anti-static cleaner.</p>		<p>Wet a lint free cloth and wipe on to clean the part. Do not allow to dry on the surface.</p>	<p>Wipe dry with a lint free cloth.</p>	<p>Repeat until satisfied no residue remains or, until cloths stay clean.</p>	<p>Support the part and heat to 60°C for 30 mins to remove release agent from the plastic pores.</p>
<p>03. <b>New un-primed raw plastic part Part B</b></p>	<p>Clean again for the final time. Do not allow to dry on the surface.</p>		<p>Wipe dry with a lint free cloth.</p>	<p>Mix and apply 2K Plastic Primer according to the TDS.</p>		<p>1K Adhesion Primer and 2K Elasticized Primer can also be used according to the TDS.</p>
<p>04. <b>Primed Plastic part preparation</b></p>	<p>Pre-primed Plastic parts should be sanded carefully taking care not to break-through the primer.</p>	<p>Sand primer with P400-500.</p>	<p>Re-clean with anti-static wipe.</p>	<p>Wipe dry.</p>		
<p>05. <b>Basecoat colour for primed parts</b></p>	<p>Primed and sanded parts can now be painted with approved basecoat material.</p>	<p>Mix and apply the basecoat colour according to the TDS.</p>		<p>Dry as TDS.</p>		
<p>06. <b>Clear coat for base coated or fine sanded parts</b></p>	<p>After drying the base coat the approved elasticised clear coat can be mixed and applied.</p>	<p>Mix according to the TDS.</p>		<p>Dry as TDS.</p>		