



SALEEN SPEEDLAB ABS PLASTIC BODY KIT PAINT PROCEDURE

P/N: 10-8002-C11930A

SALEEN

Saleen Performance, Inc. 1225 East Maple Rd. Troy, MI 48083 800-888-8945
www.saleen.com



***IF YOU ARE NOT EXPERIENCED IN THE
AREA OF AUTOMOTIVE PAINTING, WE
STRONGLY URGE THAT YOU REFER THE
PAINTING OF THE KIT TO A PROFESSIONAL
PAINT SHOP***



Saleen Speedlab ABS Plastic Body Kit Paint Procedure

WELCOME!

Thank you for buying the Saleen body parts. We appreciate your business, and we hope you enjoy your product.

For your benefit, please read the following instructions completely and thoroughly before attempting to paint the body parts. Many questions we have received from customers about the installation of our products could have been easily solved by information listed in the accompanying installation guide. We want you to enjoy the product in its fully functional state, and reading this tutorial is a great way to ensure that will happen.

Again, thank you for choosing Saleen!



ABS Plastic Body Kit Paint Procedure

CAUTION: FOR OPTIMAL RESULTS, AND SAFE USE OF THESE MATERIALS IT IS RECOMMENDED THAT A PROFESSIONAL PAINT SHOP DO THE PREPERATION AND PAINTING.

Tools needed:.

- Glasurit 55-Line Basecoat / 923-200 Clear (2.0 VOC) ONLY
- Virgin ABS Plastic Body Parts

Time Required to Complete Operation: 2 ½ to 3 hours

Recommended Use:

Painting of virgin ABS plastic rear supercharged wings using Glasurit 55-Line/923-200 Clearcoat. This process and brand must be followed or any warranty claims will be void. Light sanding of the part is required and will adversely affect adhesion if not lightly sanded; no prep work is required.

Exclusive for: Saleen Performance/SSV c/o Saleen 76 Fairbanks, Irvine, Ca, 93618
Bryan Chambers TEL: 949-597-4900 FAX 949-829-8707
Saleen Tech Line TEL: 949-597-3819

Step #1: Wash virgin (un-painted) ABS plastic wing or area to be finished with Glasurit 541-30 Universal Plastic Cleaner or Glasurit 541-92 in order to remove grease, wax based mold release agents and other contaminants. Glasurit 541-30 is recommended for cleaning virgin plastic parts to help dissipate static electricity build up. **NOTE: These parts are not to reworked, this will void the warranty and affect the adhesion.**

Step #2: Use pressurized air to remove embedded debris or dirt. Wipe dry with clean lint-free cloth or paper towel. Use clean BASF Tack Cloth B120 to tack the whole plastic part before spraying the R-M 934-0 Plastic Adhesion Promoter (Ready for use). The use of an anti static air nozzle is recommended but not required to assure the cleanest parts possible and alleviate dirt in the base coat.



Step #3: REQUIRED: R-M 864 Polypropylene (Clear) Plastic Primer (No Substitution Allowed)

Make sure the ABS parts are properly and thoroughly cleaned with 541-30 Plastic Cleaner and tacked before applying the plastic primer. R-M 934-0 is ready for use (RFU). Apply 1 thin coat of R-M 934-0 using 40 psi air pressure for optimum adhesion. Allow R-M 934-0 to dry for 15-30 minutes at room temperature (68-72 F), but no longer than 6 hours before applying Glasurit BC.

Step #4: Glasurit 55-Line Basecoat catalyzed with 355-55 Basecoat Activator

Mix Ratio: 10 : 1 : volume parts **RFU Viscosity:** 17 to 22 secs. #4 Ford Cup.

Mix 10 parts Glasurit55-Line Color : 1 parts 355-55 Basecoat Activator : 4 parts 352 Series Reducer

Spray 2-3 coats of the above 55-Line Basecoat using appropriate 352- series reducers, depending on shop conditions. Use 50 - 60 psi of air pressure for conventional suction type spray gun observing 5-10 minutes flash in between coats. Allow 10-15 minutes final flash before lightly tacking with A-11 BC/CC Tack Cloth and applying 923-200 2.0 VOC Clear coat.

Step #5: Glasurit 923-200 2.0 VOC Clear Coat

Mix Ratio: 2 : 1 volume parts **RFU Viscosity:** 15-18 sec. #4 Ford

Mix 2 volume parts of 923-200 with 1 volume part of 929-21, -23, -24 Low VOC Hardener depending on shop condition.

Spray 2 medium wet coats with 5-10 minutes flash in between coats of 2.0 VOC 923-200 Low VOC Clear over catalyzed 55-Line Basecoat. Allow 5-10 minutes flash before force drying.

Potlife: 1.0 hour at 68°F