



SALEEN SPEEDLAB TPO PLASTIC BODY KIT PAINT PROCEDURE

OPERATION MANUAL: 2005 to '09 Mustang

P/N: 10-8002-C11464C

SALEEN

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***IF YOU ARE NOT EXPERIENCED IN THE
AREA OF AUTOMOTIVE MECHANICS, WE
STRONGLY URGE THAT YOU REFER THIS
INSTALLATION TO A CERTIFIED INSTALLER
OR TECHNICIAN***



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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!



TPO Plastic Body Kit Paint Procedure

Exclusive for: Saleen Performance c/o Saleen 1225 East Maple, Troy, MI 48083
Saleen Tech Line TEL: 800-888-8945

Tools needed:

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

Time Required to Complete Operation: 2 ½ to 3 hours

NOTE: Painting of virgin TPO plastic body kits and components bumpers using Glasurit 55-Line /923-200 Clearcoat. This process and brand must be followed or any warranty claims will be void. No sanding or the parts is required and will adversely affect adhesion if sanded; no prep work is required.

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

Procedure:

1. Wash virgin (un-painted) TPO plastic bumper 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 be sanded or reworked, this will void the warranty and affect the adhesion. They are paint ready as received.**

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 864 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.

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

Make sure the virgin TPO parts are properly and thoroughly cleaned with 541-30 Plastic Cleaner and tacked before applying the polypropylene plastic primer. R-M864 is ready for use (RFU). Apply 1 thin coat of R-M864 using 40 psi air pressure for optimum adhesion. Allow R-M864 to dry for 15-30 minutes at room temperature (68-72 F), but no longer than 6 hours before applying Glasurit BC.



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.

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

Note: Refer to Glasurit TDS for 55-Line basecoat and 923-200 Clear for details and use.

6. Force Dry: Bake at 140°F /15-20 minutes or use SW Infra-Red for 8-10 minutes.

Air Dry: Air dry at room temperature (68-72 F) for 1 to 2 hours.

Sand, Nib & Buff Imperfections - Wait for 2-4 hours cure before wet or dry sand using #1200 grit.

Test Results:

Passed: 96 hours and 240 hours (GM) Spec for Humidity testing with no loss of adhesion or #10 GM rating. (ASTM D2247)

Passed: GM Gravel meter Stress test with GM09 rating. (ASTM D3170)

Passed: Adhesion 1 week Dry Adhesion GM10.