

RAPTOR APPLICATION GUIDE



STANDARD APPLICATION

RAPTOR PROCESS	
STEPS	PROCESS
1. CLEAN SUBSTRATE 	Clean / Degrease with solvent or waterborne degreaser UP2002, UP2012, UP2022 or equivalent.
2. SAND SURFACE 	Painted Surfaces: 180 - 320 grit Flexible Plastics (TPO, PP, EPDM)**: 180 - 320 grit Bare Steel: 80 - 180 grit Aluminum, Galvanized: 120 - 180 grit Fiberglass, SMC, Carbon Fiber: 120 - 180 grit E-Coat: Coarse abrasive pad
3. RE-CLEAN 	Blow off with compressed air. Re-clean with wax and grease remover.
4. PRIME 	Exposed bare metal, aluminum, galvanized and large areas: ACID#8 Etch Primer or RAPTOR Epoxy Primer. Flexible plastics (TPO, PP, EPDM): Adhesion Promoter. Note: Polyethylene (PE/HDPE) cannot be coated.
5. MIX 	From bottle (fill level 24 fl. oz.): pour 237ml / 8 fl. oz. hardener into bottle. From mixing bank: Mix ratio is 3:1 in graduated mix cup. 1 activated quart yields theoretical 2 coat coverage of 21.5 sq ft (2 square meters). Note: RAPTOR may be reduced 10-20% based on texture desired and application equipment used.
6. TINTING 	Option 1: Add one (1) U-POL tint pack per activated quart of RAPTOR. Option 2: 3 fl. oz. solvent basecoat toner* per activated quart of RAPTOR. Mix / Shake thoroughly for 2 minutes until well mixed. Note: Refer to RAPTOR Tintable TDS Guide for additional mixing and tinting guideline.
7. SHOOT 	Attach RAPTOR bottle to RAPTOR gun (UP0726 or UP4880.) Adjust air inlet pressure between 40-60 psi. Hold gun 18 - 24" from surface. Adjust distance, speed, and air pressure to achieve desired texture. Note: Refer to RAPTOR Texture Guide and Equipment Selector for additional texture recommendations.
8. ADDITIONAL COATS 	If applying more than one coat, allow RAPTOR to flash 60 minutes between coats. If more than 5 hours between coats, allow it to set overnight, lightly scuff and apply additional coat(s).
9. FLASH AND DRY TIMES 	Dry to Touch: 1 Hour Light Duty Use: 2 - 3 Days Heavy Duty Use: 7 Days Bake Booth: 30 minutes at 140°F (60°C)

ADDITIONAL SOP AND RECOMMENDED GUIDELINES

- RAPTOR Black Technical Data Sheet
- RAPTOR Tintable Technical Data Sheet

*Check local legislations for compliance. **For tight corners or flexible plastics, a red scuff pad is also recommended.

To find out more visit www.raptorcoatings.com

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HOOD

GRILLE

BUMPER

WHEEL

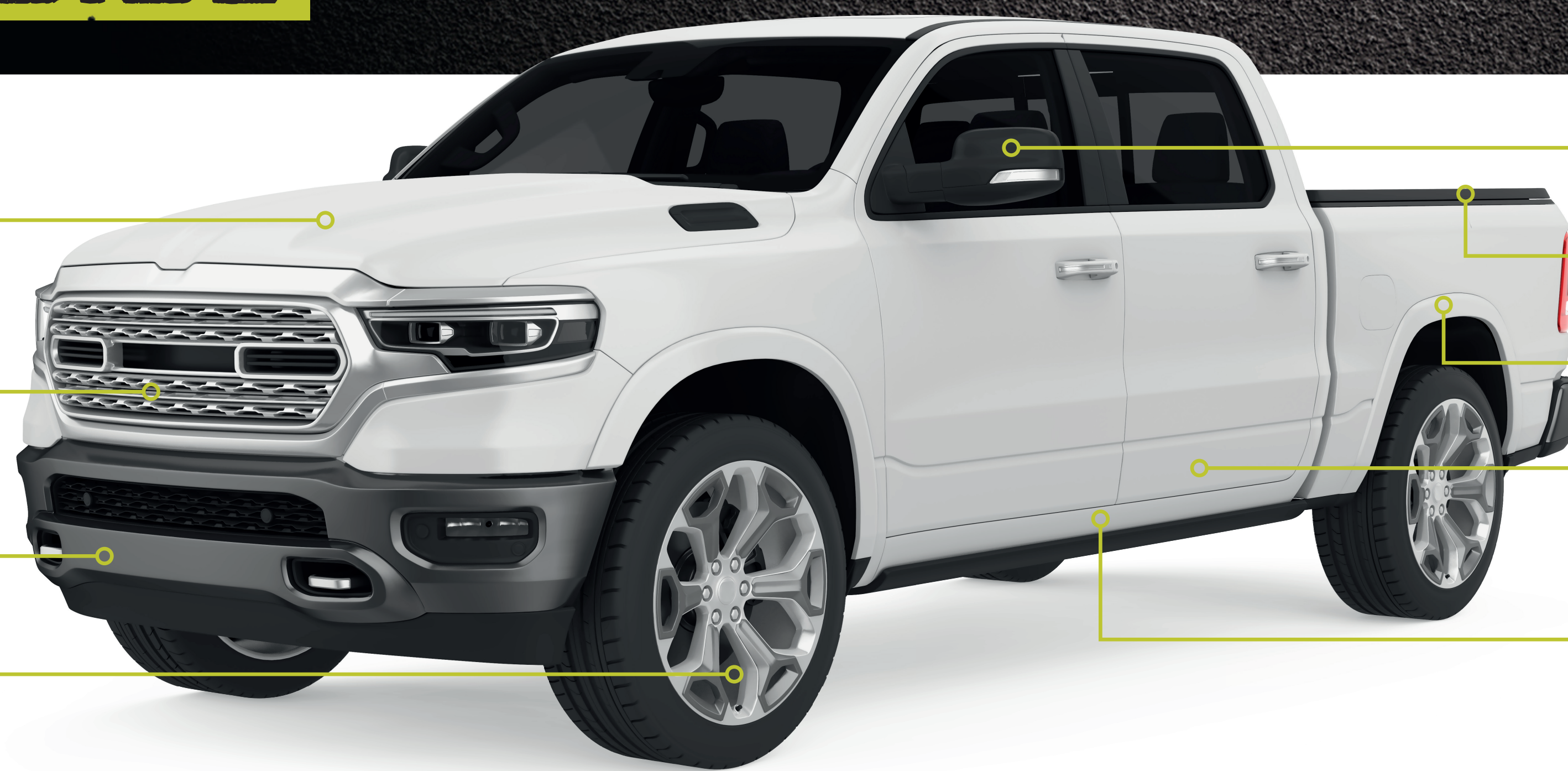
SIDE MIRROR

BEDLINER

FENDER FLARE

DOOR / QUARTER PANEL

ROCKER PANEL



RAPTOR TEXTURE & EQUIPMENT SELECTOR GUIDE FOR SPRAY APPLICATIONS

OPTION #1

Standard application of RAPTOR with UP0726 and UP4880 Application Guns

- 1 Activate RAPTOR with hardener at a 3:1 mix ratio.
- 2 Shake for 2 minutes.
- 3 Adjust inlet air pressure then attach application gun to RAPTOR bottle.
- 4 Spray test panel to ensure desired texture is achieved.
- 5 Apply 2 coats with an even sweeping motion allowing 60 minutes to flash between coats. If applying additional coats, allow to flash off for 60 minutes between coats.

RAPTOR Gun Options	3M™ PPS™ Cup System	DeVilbiss D Kup System
• UP0726 RAPTOR Application Gun	• S12 adaptor #26015	• DPC-502
• UP4880 RAPTOR Professional Vari-Nozzle Gun	• S8 #26015	

UP0726 RAPTOR APPLICATION GUN		
TEXTURE	INLET PRESSURE	DISTANCE FROM OBJECT
COARSE	45 - 50 PSI (3.1 - 3.4 Bar)	18" (45 cm)
MEDIUM	60 - 65 PSI (4.1 - 4.5 Bar)	24" - 30" (61 - 71 cm)

UP4880 RAPTOR PROFESSIONAL VARI-NOZZLE GUN			
TEXTURE	INLET PRESSURE	NOZZLE ADJUSTMENT	DISTANCE FROM OBJECT
COARSE	45 - 50 PSI (3.1 - 3.4 Bar)	From closed position: Open 3 - 5 turns	24" - 30" (61 - 71 cm)
MEDIUM	55 - 65 PSI (3.8 - 4.5 Bar)	From closed position: Open 1 ½ - 2 turns	24" - 30" (61 - 71 cm)

OPTION #2

Standard application of RAPTOR with 1.6-2.5mm HVLP Gravity-Fed Gun

- 1 Activate RAPTOR with hardener at a 3:1 mix ratio in a graduated mixing cup.
- 2 Add 15% of urethane reducer* into the mixing cup.
- 3 Stir for 2 minutes.
- 4 Pour contents into spray gun cup, adjust fan pattern and follow guidelines (increase fluid flow for coarser texture; reduce fluid flow for finer texture).
- 5 Spray test panel to ensure desired texture is achieved.
- 6 Apply 2 coats with an even sweeping motion allowing 60 minutes to flash between coats. If applying additional coats, allow to flash off for 60 minutes between coats.

HVLP GUN			
TEXTURE	TIP SIZE**	INLET PRESSURE	DISTANCE FROM OBJECT
MEDIUM	2.0 - 2.5mm	See gun manufacturer's recommendations	8" - 12" (10 - 30 cm)
FINE	1.6 - 1.8mm	See gun manufacturer's recommendations	8" - 10" (10 - 25 cm)

*Addition of urethane reducer may affect VOC. Please check local regulations for suitable reducers.
**For even finer textures, tip sets smaller than 1.6mm may be used, however, additional reduction of RAPTOR between 15% and 25% may be necessary.

OPTION #3

Standard application of RAPTOR with 26832 3M™ Performance Spray Gun H/O

Texture and setting examples require H/O Conversion Pack (26837).

- 1 Activate RAPTOR with hardener at a 3:1 mix ratio in a graduated mixing cup.
- 2 Stir for 2 minutes.
- 3 Pour contents into spray gun cup and use tip size 2.0 mm.
- 4 From a closed position, open fan adjustment and H/O pressure knob adjustment 1 full turn.
- 5 Spray test panel to ensure desired texture is achieved.
- 6 Apply 2 coats with an even sweeping motion allowing 60 minutes to flash between coats. If applying additional coats, allow to flash off for 60 minutes between coats.

26832 3M™ PERFORMANCE SPRAY GUN H/O			
TEXTURE	INLET PRESSURE	FLUID ADJUSTMENT	DISTANCE FROM OBJECT
COARSE	4 - 6 PSI (.27 - .41 Bar)	From closed position: Open 2 - 2 ½ turns	8" - 12" (10 - 30 cm)
MEDIUM	10 PSI (.69 Bar)	From closed position: Open 1 ½ turn	8" - 12" (10 - 30 cm)
FINE	10 PSI (.69 Bar)	From closed position: Open 1 turn	8" - 10" (10 - 25 cm)
EXTRA FINE	15 PSI (1 Bar)	From closed position: Open 1 turn	8" - 10" (10 - 25 cm)

26121 Mid H/O cup for 3oz, 6.8oz, and 13.5oz PPS™ liners. 26124 Large H/O cup for 22oz and 28oz PPS™ liners. Please see the 3M™ Performance Spray Gun Owner's Manual for more information.

RAPTOR TEXTURE GUIDE

