










## RAPTOR™ PROTECTIVE COATING APPLICATION SOP

### Recommended Procedure for Obtaining Consistent Results

Process Tools Required		
<b>RAPTOR Black or Tintable:</b> <ul style="list-style-type: none"> <li>UP5130, UP5131 Quart Bottle</li> <li>UP4838, UP4839 Gallon Can</li> <li>UP4870, UP4871, UP4872 200L Drum</li> </ul>	<b>Acid Etch Primer or Epoxy Primer (optional):</b> <ul style="list-style-type: none"> <li>UP5023, UP0741V or UP0837 Acid Etch Primer</li> <li>UP4842 RAPTOR 2K Epoxy Primer Aerosol</li> <li>UP4830/UP4831 RAPTOR 2K Epoxy Primer Kit*</li> </ul>	<b>Spray Equipment:</b> <ul style="list-style-type: none"> <li>UP0726 or UP4880 RAPTOR guns</li> <li>HVLP (1.6 - 2.5mm)</li> <li>26832 3M™ Performance Spray Gun H/O (2.0mm)</li> </ul>
<b>RAPTOR Hardener:</b> <ul style="list-style-type: none"> <li>UP5125 1/2 Pint Can</li> <li>UP5126 Quart Can</li> <li>UP4824 5 Liter</li> <li>UP4826 (for use with UP4872)</li> </ul>	<b>Adhesion Promoter (optional):</b> <ul style="list-style-type: none"> <li>UP5024 RAPTOR or UP0799 GRIP#4 Adhesion Promoter</li> </ul>	<b>For detailed information, please refer to RAPTOR Texture &amp; Equipment Selector Guide.</b>
<b>Wax and Grease Remover:</b> <ul style="list-style-type: none"> <li>UP2002 Waterborne Degreaser</li> <li>UP2012/UP2022 Solvent Degreaser</li> </ul>	<b>Sandpaper:</b> 180 – 320 grit <b>Red Scuff Pad:</b> optional	<b>Personal Protection Equipment:</b> Respirator, latex or nitrile gloves, safety glasses

<b>1. CLEAN SUBSTRATE</b>  <p><b>Clean / Degrease</b> all areas to be coated with solvent or water borne degreaser UP2002, UP2012, UP2022 or equivalent to remove surface contaminants.</p>	<b>6. TINTING</b>  <p><b>Option 1</b> - add one (1) U-POL tint pack per activated quart of RAPTOR.</p> <p><b>Option 2**</b> - add 3 fl. oz. solvent basecoat toner per activated quart of RAPTOR. Mix / Shake thoroughly for 2 minutes until well mixed.</p> <p><i>Refer to RAPTOR Tintable TDS Guide for additional mixing and tinting guidelines.</i></p>												
<b>2. SAND SURFACE</b>  <table border="0"> <tr> <td>Painted Surfaces:</td> <td>180 – 320 grit</td> </tr> <tr> <td>Flexible Plastics (TPO, PP, EPDM):**</td> <td>180 – 320 grit</td> </tr> <tr> <td>Bare Steel:</td> <td>80 – 180 grit</td> </tr> <tr> <td>Aluminum, Galvanized:</td> <td>120 – 180 grit</td> </tr> <tr> <td>Fiberglass, SMC, Carbon Fiber:</td> <td>120 – 180 grit</td> </tr> <tr> <td>E-Coat:</td> <td>Coarse abrasive pad</td> </tr> </table> <p><b>**For tight corners or flexible plastics, a red scuff pad is also recommended.</b></p>	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	<b>7. SHOOT</b>  <p>Attach RAPTOR bottle to RAPTOR gun (UP0726 or UP4880.) Adjust air inlet pressure between 40-60 psi. Hold gun 18 - 24" from surface.</p> <p>Adjust distance, speed, and air pressure to achieve desired texture.</p> <p><i>Refer to RAPTOR Texture and Equipment Selector Guide for additional texture recommendations.</i></p>
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<b>3. RE-CLEAN</b>  <p>Blow off with compressed air and re-clean with wax and grease remover to remove sanding dust and any area that may have been contaminated during sanding process.</p>	<b>8. ADDITIONAL COATS</b>  <p>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).</p>												

<p><b>4. PRIME</b></p>  <p>Exposed bare metal, aluminum, galvanized and large areas: ACID#8 Etch Primer or Raptor Epoxy Primer Flexible plastics (TPO, PP, EPDM): Adhesion Promoter</p> <p><i>Note: Polyethylene (PE/HDPE) cannot be coated.</i></p>	<p><b>9. FLASH AND DRY TIMES</b></p>  <p>Dry to Touch 1 hour Light Duty Use 2-3 days Heavy Duty Use 7 days</p> <p>Bake booth: 30 minutes at 140°F (60°C)</p>
<p><b>5. MIX</b></p>  <p><b>From bottle</b> (fill level 24 fl. oz.): pour 237ml / 8 fl. oz. hardener into bottle. <b>From mixing bank: Mix ratio is 3:1</b> in graduated mixing cup. (1 activated quart yields theoretical 2 coat coverage of 21.5 sq ft.)</p> <p><i>Note: RAPTOR may be reduced 10-20% based on texture desired and application equipment used.</i></p>	<p><b>ADDITIONAL SOP &amp; RECOMMENDED GUIDELINES:</b></p> <p><i>RAPTOR Black Technical Data Sheet RAPTOR Tintable Technical Data Sheet RAPTOR Texture &amp; Equipment Selector Guide RAPTOR Application Wall Chart</i></p>

\*RAPTOR 2K Epoxy Kit is US National Rule compliant only. As with all products, please check local regulations for VOC compliance before use.

\*\*Check local legislations for compliance.

E-RAPTSOPUS