**General Guidelines for Painting TPO**

**NOTE:** All parts should be fully supported with a metal fixture to help prevent warpage. Warpage can occur through the many steps required to paint TPO parts.

1. **Power wash parts** (5 or more stages typical)
   - City water rinse, wash, city water rinse, DI recirculated rinse, virgin DI rinse.
   **General application requirements:**
   - Parts are washed and then dried (20 minutes @ 80°C). Make sure to follow your paint supplier’s time and temperature recommendations, as each supplier may vary.
   - **NOTE:** It is very important to properly clean and prep the TPO surface prior to painting to make sure the paint properly adheres to the TPO surface.

2. **Adhesion promoter** (or other pre-treat system – flame, corona, plasma, waterborne, solventborne, atomized adhesive spray)
   - Solvent or water based, formulated for TPO plastics.
   **General application requirements:**
   - Spray applied films (non-electrostatic, electrostatic, hand, or robotic) will produce a thickness of approximately 0.2-0.4 mils.
   - Waterborne adhesion promoter needs to be baked prior to basecoat application (30 minutes @ ~ 80°C).
   - Consult your paint supplier to determine which method is recommended, along with their specific instructions.

3. **Basecoat** (color coat)
   - Flexible 1 K or Flexible 2 K.
   - Solvent or water based.
   **General application requirements:**
   - Spray applied films (non-electrostatic, electrostatic, high-speed bells, hand, or robotic) will produce a thickness of 0.8-1.6 mils depending on color.
   - Follow your specific paint supplier’s recommended procedure.

4. **Clearcoat**
   - Flexible 1 K or Flexible 2 K.
   - Solvent based.
   **General application requirements:**
   - Spray applied films (non-electrostatic, electrostatic, high speed bells, hand, or robotic) will produce a thickness of 1.6-1.8 mils.
   - Parts are then final baked (~20-40 minutes @ 80-125°C).
   - Follow your specific paint supplier’s recommended procedure.

**Major Paint Suppliers:**

<table>
<thead>
<tr>
<th>PPG</th>
<th>BASF</th>
</tr>
</thead>
<tbody>
<tr>
<td>(248) 641-2000</td>
<td>(248) 304-5700</td>
</tr>
<tr>
<td>Rohm and Haas (800) 323-3224</td>
<td>DuPont (248) 583-8000</td>
</tr>
<tr>
<td>Red Spot (734) 454-9200</td>
<td>Sherwin Williams (248) 588-3500</td>
</tr>
</tbody>
</table>

Note: All statements, information, and data given herein are believed to be accurate and reliable but are presented without guarantee, warranty, or responsibility of any kind, expressed or implied. Statements or suggestions concerning possible use or our products are made without representation of warranty that such use is free of patent infringement and are not recommendations to infringe any patent. The user should not assume that all safety measures are indicated, or that other measures may not be required.