

# ONE HIT WONDER

If working with used parts, clean with hot soapy water before proceeding to step one. All debris (dirt, oil, etc.) must be cleaned from parts before painting or dipping.

**1. CLEAN:** Clean part with a solvent based cleaner/degreaser. Work on small areas at a time, wiping wet with cleaner and wiping dry with clean cloth. Do not allow cleaner to evaporate before wiping with clean cloth as this will leave behind residue. If working with HDPE plastic, flame treat\* before proceeding to step two.

**2. SCUFF:** Scuff or sand parts until consistent scratch is achieved. The part should have a dull finish with no shine. Most parts can be scuffed with a gray Scotch pad. For harder materials (like heat treated metals) use 400 grit sandpaper.

**3. WIPE:** If you have compressed air, blow any dust off with a nozzle and then wipe with tack cloth to remove fine particles left behind from sanding/scuffing.

**4. PAINT (AEROSOL):** Shake well for 1-2 minutes. Spray on paper for 1-2 seconds to empty filler tube and release propellant. Apply paint about 8" from surface with light, even coats and a 2" overlap.

**5. PAINT (SPRAY GUN):** With a standard mixing stick, stir paint well to remove any heavy residue that may have settled at the bottom of the can. Strain paint into spray gun using a disposable mesh paint filter. For HVLP spray guns set gun pressure to around 22 psi (this is the pressure reading when the trigger is depressed halfway, allowing only air, not paint, to leave the gun). Using a 1.3 or 1.4 tip, apply a light coat of One Hit Wonder. If part is not fully covered apply a second light coat after 15 minutes or once the first coat is dry to the touch.

**6. DIP:** Once paint is dry to the touch (test hidden area) the part is ready to dip. For temperatures at 70 degrees and 50% humidity this should be about 10-20 minutes after painting. Colder temperatures and higher humidity can result in slower drying times.

\*Flame, degrease, flame and repeat as necessary until plastic loses shine.