



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:

PPG (248) 641-2000

Rohm and Haas (800) 323-3224

Red Spot (734) 454-9200

BASF (248) 304-5700

DuPont (248) 583-8000

Sherwin Williams (248) 588-3500