



DO THE JOB RIGHT.®

Item #23135

OPTIFLOW ROLL-ON PAINT SYSTEM INSTRUCTIONS



The **EASTWOOD OPTIFLOW SYSTEM** provides an alternative method of prepping and priming a vehicle without the need of an air compressor or spray gun. Specifically formulated primers were developed for application with a foam roller and can be accomplished without time constraints, one panel at a time. Includes items needed to properly take a vehicle from “rough” to “ready” for a traditional sprayed color finish.

⚠ NOTICE

The Eastwood OptiFlow System is not a conventional sprayed-on automotive primer, but a high quality Roll On system, and **MUST** be applied very carefully, in multiple steps, per instructions. A point to remember is that when done, the vehicle will be ready for the final finish after having saved thousands of dollars in preparation labor costs.

THE SPECIFIC STEPS INCLUDE:

- Disassemble vehicle, remove components as needed.
- Strip off old paint or scuff existing coating.
- Assess vehicle body for rust and/or damage repair.
- Thoroughly solvent wipe-down/degrease entire vehicle with Eastwood PRE or acetone.
- Prep sand with 120 and 180 grit abrasive paper.
- Repeat the solvent wipe-down with Eastwood PRE or acetone.
- Apply 2 coats of Epoxy Primer to seal surface following specific roll-on application instructions.
- Apply Eastwood 2K Aerosol Epoxy Primer to edges, door jambs and other tight areas.
- Spray vehicle surface with Guide Coat.
- Block sand with 320 grit to reveal low and high spots.
- Fill low spots with polyester filler, metal work to lower high spots.
- Repeat Guide Coat and sanding steps as often as required to achieve even surface.
- Once again solvent wipe with Eastwood PRE or acetone.
- Apply additional 2 coats of Epoxy Primer (1 mil/coat).
- Apply 4 to 5 coats of Eastwood Urethane Primer Surfacer.
- Block sand with 220, 320, then 400 grit abrasive paper.
- Vehicle is ready for finish paint.

PLEASE READ ALL APPLICATION INSTRUCTIONS AND SAFETY INFORMATION BEFORE USE!



WATCH AND LEARN

with FREE Instructional Videos Available at **eastwood.com** – keyword search “OPTIFLOW”

SAFETY INFORMATION

The following explanations are displayed in this manual, on the labeling, and on all other information provided with this product:

⚠ DANGER

DANGER indicates a hazardous situation which, if not avoided, will result in death or serious injury.

⚠ WARNING

WARNING indicates a hazardous situation which, if not avoided, could result in death or serious injury.

⚠ CAUTION

CAUTION indicates a hazardous situation which, if not avoided, could result in minor or moderate injury.

⚠ NOTICE

NOTICE is used to address practices not related to personal injury.



⚠ READ INSTRUCTIONS

- Thoroughly read and understand this manual before using.
- Save for future reference.



⚠ CAUTION HEALTH HAZARD!

- Wear appropriate ANSI approved eye protection to avoid the possibility of any product splashing into eyes.
- Wear protective, chemical resistant gloves. Disposable nitrile or latex gloves are acceptable.
- Avoid breathing vapors produced by Eastwood solvents, activators and primers. Always wear appropriate NIOSH approved breathing apparatus and use in a well-ventilated area.



⚠ CAUTION FIRE AND EXPLOSION HAZARD!

- **DO NOT** use near sparks, open flame or other potential ignition sources.
- Use in a well-ventilated area.



▲ NOTICE

THERE ARE FOUR INDIVIDUAL KITS AVAILABLE FROM BASIC TO COMPLETE. THE CONTENTS OF EACH IS DEFINED BELOW.

EASTWOOD #23120ZP, OPTIFLOW EPOXY PRIME KIT**Includes:**

- (1) Large, 7" Roller Frame
- (1) Small, 4" Roller Frame
- (4) 2-Packs, Large 7" Foam Roller Covers (total 8 pcs)
- (2) 2-Packs, Small 6" Foam Roller Covers (total 4 pcs)
- (1) Plastic Paint Rolling Tray
- (1) 12-Pack Paint Roller Tray Liners
- (1) 5-Pack, 1 Quart Mixing Cups with Lids
- (1) Eastwood #23130ZP OptiFlow DTM Epoxy Primer Gray, Gallon
- (1) Eastwood #23131ZP OptiFlow Epoxy Catalyst, Gallon
- (2) Eastwood #12416Z Aerosol Guide Coat, Black
- (2) Eastwood #14149Z 2K Aerosol Epoxy Primer, Gray

EASTWOOD #23123ZP, COMPLETE OPTIFLOW EPOXY PRIME KIT**Includes:**

- (1) Large, 7" Roller Frame
- (1) Small, 6" Roller Frame
- (4) 2-Packs, Large 7" Foam Roller Covers (total 8 pcs)
- (2) 2-Packs, Small 6" Foam Roller Covers (total 4 pcs)
- (1) Plastic Paint Rolling Tray
- (1) 12-Pack Paint Roller Tray Liners
- (1) 5-Pack, 1 Quart Mixing Cups with Lids
- (1) Eastwood #23130ZP, OptiFlow DTM Epoxy Primer Gray, Gallon
- (1) Eastwood #23131ZP, OptiFlow Epoxy Catalyst, Gallon
- (2) Eastwood #12416Z, Aerosol Guide Coat, Black
- (2) Eastwood #14149Z, 2K Aerosol Epoxy Primer, Gray
- (1) Eastwood #19857, 16" Dura-Block, Sanding Board
- (1) Eastwood #19855, 5" Dura-Block, Sanding Board
- (1) 2.75" x 81.75' Roll #31374, P120 Grit, Adhesive Back, Abrasive Paper
- (1) 2.75" x 81.75' Roll #19627, P180 Grit, Adhesive Back, Abrasive Paper
- (1) 2.75" x 81.75' Roll #19628, P220 Grit, Adhesive Back, Abrasive Paper
- (1) 2.75" x 81.75' Roll #31376, P320 Grit, Adhesive Back, Abrasive Paper
- (1) 2.75" x 81.75' Roll #31377, P400 Grit, Adhesive Back, Abrasive Paper

EASTWOOD #23121ZP, OPTIFLOW EPOXY/URETHANE PRIME AND SEAL KIT

Includes:

- (1) Large, 7" Roller Frame
- (1) Small, 4" Roller Frame
- (4) 2-Packs, Large 7" Foam Roller Covers (total 8 pcs)
- (2) 2-Packs, Small 6" Foam Roller Covers (total 4 pcs)
- (1) Plastic Paint Rolling Tray
- (1) 12-Pack Paint Roller Tray Liners
- (1) 5-Pack, 1 Quart Mixing Cups with Lids
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- (1) Eastwood #23131ZP OptiFlow Epoxy Catalyst, Gallon
- (2) Eastwood #12416Z, Aerosol Guide Coat, Black
- (2) Eastwood #14149Z, 2K Aerosol Epoxy Primer, Gray
- (1) Eastwood #23132ZP OptiFlow Urethane Primer Surfacer Gray, Gallon
- (1) Eastwood #23133ZP OptiFlow Urethane Primer Activator, Quart
- (2) Eastwood #14794Z, 2K Aerosol Urethane Primer, Gray

EASTWOOD #23122ZP, OPTIFLOW EPOXY/URETHANE PRIME AND SEAL KIT

Includes:

- (1) Large, 7" Roller Frame
- (1) Small, 4" Roller Frame
- (4) 2-Packs, Large 7" Foam Roller Covers (total 8 pcs)
- (2) 2-Packs, Small 6" Foam Roller Covers (total 4 pcs)
- (1) Plastic Paint Rolling Tray
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- (1) 2.75" x 81.75' Roll #31376, P320 Grit, Adhesive Back, Abrasive Paper
- (1) 2.75" x 81.75' Roll #31377, P400 Grit, Adhesive Back, Abrasive Paper

MORE COLORS AND SIZES AVAILABLE: VISIT EASTWOOD.COM

SURFACE PREP

The final finish will project every scratch, flaw and dust particle in the base. The amount of time and work spent on the surface prep will be directly proportional to the quality of the final paint job

DISASSEMBLY:

All parts attached to the vehicle body that may be damaged by the stripping process or may otherwise block access to coating open panel expanses should be removed. It is important to take many photos and notes of all components and any attaching hardware before and during the disassembly process to avoid confusion at re-assembly time.

Items to remove:

- Wipers
- Mirrors
- Cowl intake grills
- Spoilers
- Body Details (vents, scoops, rocker molding, ground effects etc.)
- Antenna
- Tail & License Lamps
- Side Marker Lamps
- Emblems & trim
- Headlamps
- Bumpers/Bumper Covers
- Door Handles
- Window Trim
- Wheel Lip Moldings

STRIP OFF OLD PAINT:

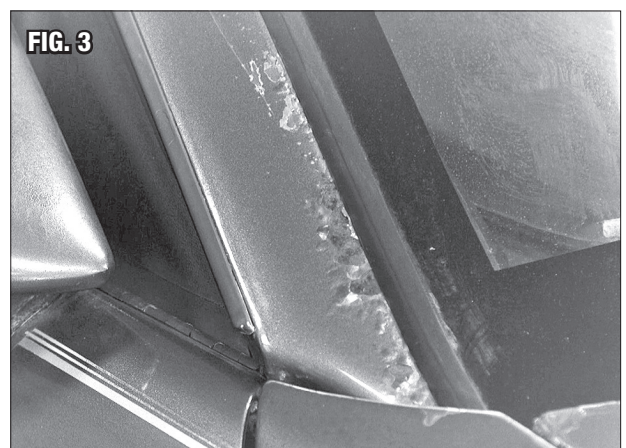
In order to produce the highest quality final paint job, it is best to strip the vehicle surface down to bare metal and build-up from there. As an alternative, the existing finish may be primed however; if doing so, it must be thoroughly prep-sanded, and solvent wiped as described in following sections of these instructions.

Methods of stripping include chemical stripping, hand sanding, machine sanding, abrasive blasting or using an Eastwood # 21145, Contour SCT Surface Conditioning Tool (**FIG 1**).

- Always, as a very first step, remove all surface contaminants to avoid spreading them around or imbedding them into the surface.
 - Wash entire vehicle with a quality dish detergent and Eastwood #15177 Non-woven nylon pads. Repeat this process several times as any remaining microscopic traces of silicone or other contaminates can produce problematic fish-eyes in the roll-on finish.
 - After drying, wipe down entire surface with Eastwood #10594Z PRE or acetone (**FIG 2**).
- When stripping, carefully follow specific product instructions for whatever method of stripping is employed.

ASSESS VEHICLE BODY FOR RUST AND/OR DAMAGE REPAIR.

If body damage is apparent, it should be repaired at this time (**FIG 3**). When inspecting for the presence of rust, be aware of the "Iceberg Rule" which is: Only 20% of an iceberg (or rust) is generally visible on the surface. The majority of the rust lies below or behind the panel and, if discovered, should be properly ground or cut out and replaced with sound metal.



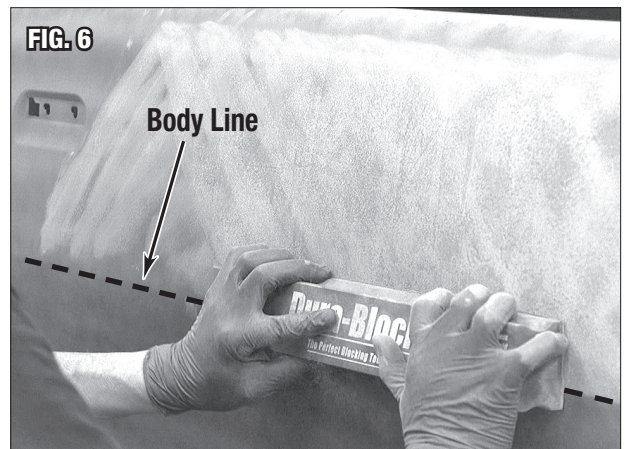
FULLY PREP-SAND THE VEHICLE BODY BEFORE APPLYING PRIMER.

For the best results and to help produce as level of a surface as possible, it is very important to sand in alternating directions, using a crisscrossing, "Cross-Block" technique in the sanding pattern by working the sanding strokes at 45° angle to previous sanding passes (FIG 4). Sanding constantly in a straight line, in the same direction should be avoided.

For panels with lesser surface area such as windshield pillars, cowl areas etc., hand-sanding can be done with the fingers behind the Abrasive Paper, but they must travel while at a 45° angle to the surface. Never sand with the fingers in-line with an area or it will cause grooving in the primed/filled surface (FIG 5).

When encountering a body character line, styling feature or crease, never sand over it but sand up-to it. The feature can be lightly hand-sanded afterward (FIG 6).

- Prep sand the entire vehicle surface beginning with P120 Grit Abrasive Paper.
- When done, repeat the process with P220 Grit.
- Follow up with P320 Grit.
- Abrade door jambs, panel edges and difficult to sand contoured areas with Eastwood # 15177, Grey Medium, Non-woven nylon pads (FIG 7).
- Wipe down entire surface with Eastwood #10594Z PRE or acetone (FIG 8).



APPLYING 2 COATS OF OPTIFLOW EPOXY PRIMER

The Eastwood OptiFlow Epoxy Primer needs to be mixed with a Catalyst in the specified 1:1 ratio (refer to can label for specific instructions) for proper curing.

DO NOT mix the entire gallon, but only the amount needed to coat the planned body panel, or not to exceed what can be coated within a 20 minute working window.

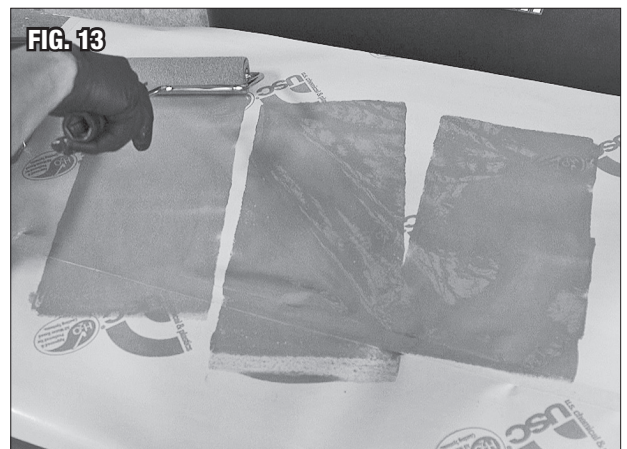
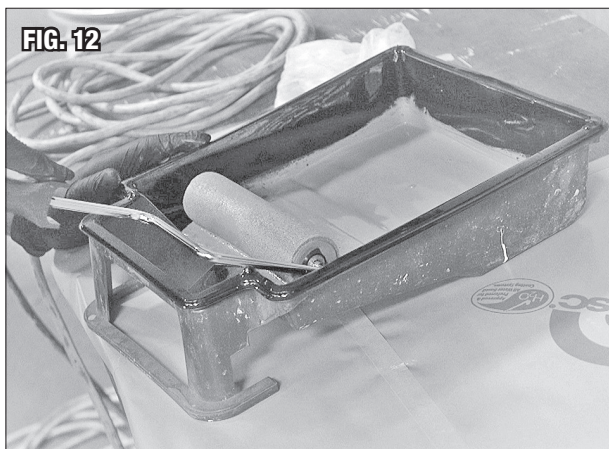
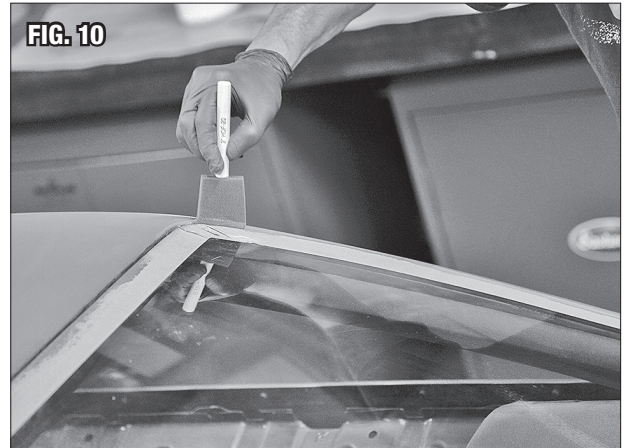
- Place a Roller Tray Liner in the Plastic Roller Tray.
- Mount a Large, 7" Foam Roller Cover onto the Large, 7" Roller Frame.
- Mount a Small, 6" Foam Roller Cover onto the Small, 4" Roller Frame.
- Pour the mixed epoxy into the Tray to an approx. 1/2" depth (**FIG 9**).
- Select the proper Roller for the area to be coated (Larger 7" for large, flat panels such as doors, hoods, roofs etc.) Use the Smaller 6" Roller for roof edges, wind-shield pillars, body line contours etc.

NOTE: Foam brushes (not included) are also very useful for getting into tight areas such as window frames, trunk openings etc. (**FIGS 10 & 11**).

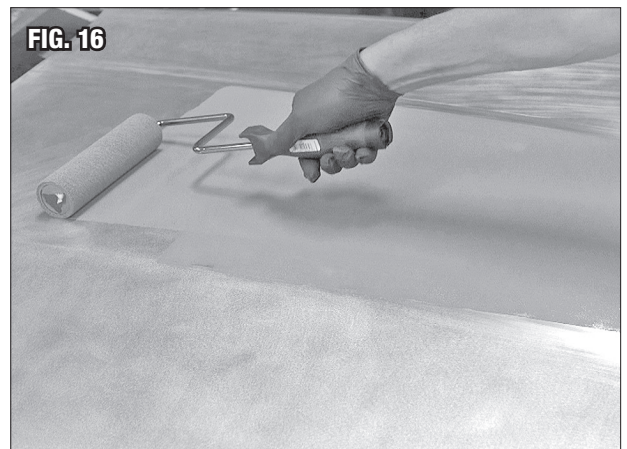
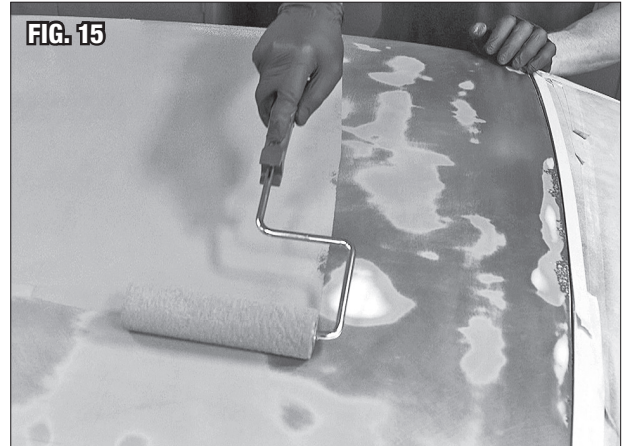
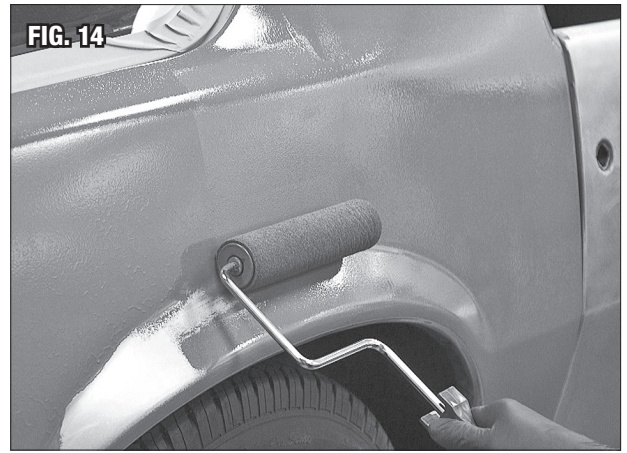
NOTE: For smoothest application, the foam roller should be "conditioned" before use. To do so:

- Tape down several feet of painters masking paper to a level and flat surface
- Dip the 1st Foam Roller into the mixed epoxy in the tray and roll it forward and back lightly allowing it to wick up some primer (**FIG 12**).
- Lightly roll the roller back and forth atop the painters masking paper to condition the Foam Roller Cover (**FIG 13**).

TIP: Start by mixing 20 oz. total (10 oz. Part A; 10 oz. Part B) to start priming vehicle.
If more primer is required, mix another small batch in a 1:1 ratio.
Only mix what can be used in 20 minutes!



- Re-roll the Roller in the Plastic Tray to absorb a sufficient quantity of Primer.
- Transfer the Roller to the vehicle panel and roll the Primer onto the surface. **DO NOT** apply excessive pressure to the Roller (**FIG 14**).
- Work the Roller back and forth several times in long, even and gentle strokes (**FIG 15**).
- When done coating the panel, pull the Roller, once across the surface *lightly* to flow out the primer applied to the surface and remove roller marks (**FIG 16**).
- Let the 1st coat cure for 30 minutes, then apply a 2nd or 3rd coat, with 30 minute flash time between coats, to get complete coverage and not showing any bare metal spots.
- Start applying Epoxy Primer on the roof or hood and work down the vehicle.
- Do not worry about contours or areas the roller can not coat. You will coat these spots with the 2K cans next.



APPLYING AEROSOL SPRAY-ON 2K EPOXY PRIMER

Once the initial OptiFlow Epoxy Primer application is done, carefully observe all difficult to access areas, tight inside corners, door jambs, panel edges and any other areas not possible to coat with a roller.

- Thoroughly mask and cover any interior, underhood, wheels, glass, or other areas where overspray is not desired.
- Activate the 2K product per instructions on the can label.
- Evenly and consistently coat all exposed doorjambs, panel edges, inside or deeply contoured areas with the spray pattern (FIG 17).
- When cured, remove any masking materials that may interfere with large panels.

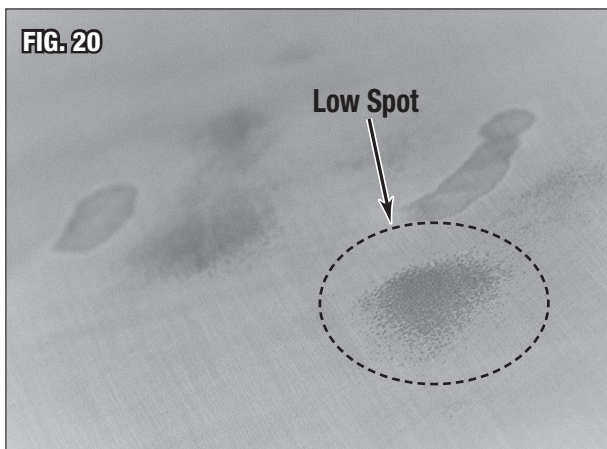
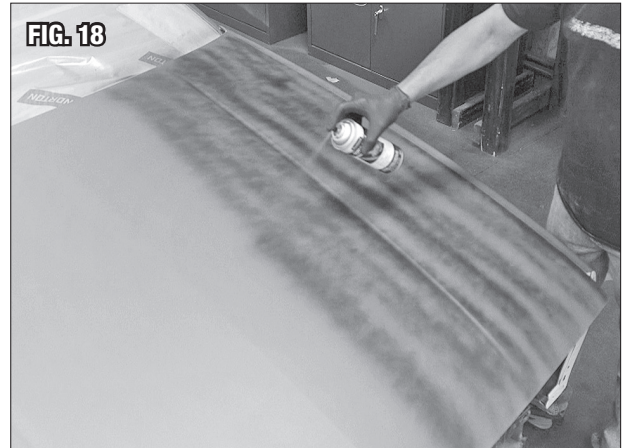
GUIDE COAT APPLICATION

(ONCE EPOXY COATING HAS CURED FOR 4 DAYS)

Guide Coat is a thin, black aerosol coating that is intended to be sprayed on in a light coat (FIG 18). It is important that it be applied evenly over the entire project surface in order to provide an accurate surface profile after sanding.

The intent of Guide Coat is to reveal low spots on the surface by having Guide Coat remain in them after sanding while high spots will be sanded through, sometimes into the Primer,

- Apply Guide Coat according to instructions on can.
- Use an Eastwood #19857 Dura-Block Sanding Board (Included with Kits #23122ZP & 23123ZP) and P320 Grit abrasive paper, lightly sand the entire project surface using the previously described crisscrossing technique in the sanding pattern by working alternately in a 45° angle (FIG 19).
- After completing the initial Guide Coat procedure, asses the surface to determine the low spots as they will require a skim coat of filler to bring them to the surrounding surface contour (FIG 20).
- Any visible high spots, viewed as shiny metal spots, can be ground down if shallow or may need some hammer and dolly work to reduce them (FIG 21).



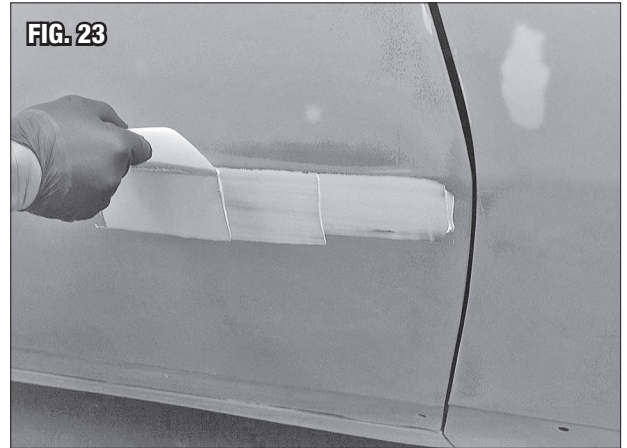
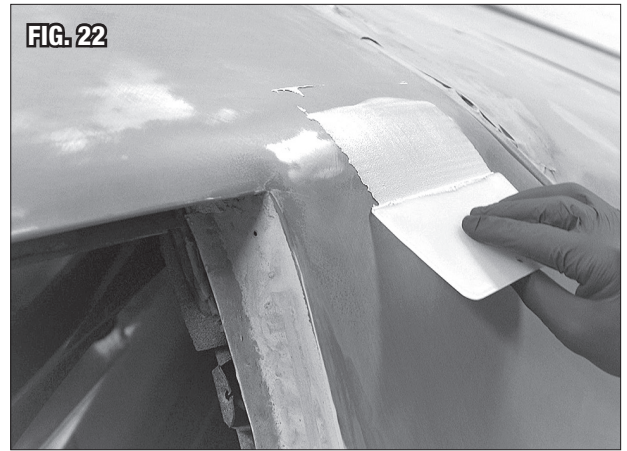
FILLING LOW SPOTS

A high quality Polyester Filler such as Eastwood Contour #13521 or #13522ZP Contour Polyester Filler should be used to fill low spots. Follow supplied instructions on container for best results.

- Mix Filler and apply in sufficient quantity to low spots allowing for minimal shrinkage (FIGS 22 & 23).

⚠ NOTICE

Never apply filler in thicknesses greater than 1/8". If more filler than this is required, it is a good indication that body repair metal work must first be performed.



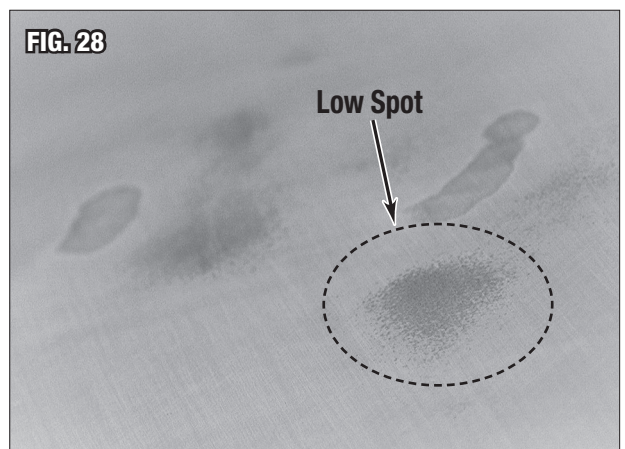
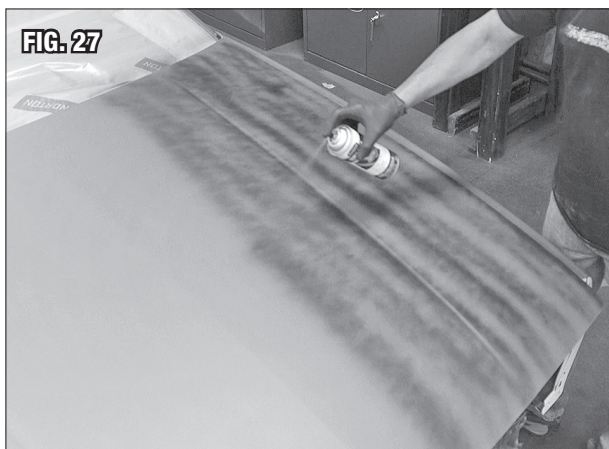
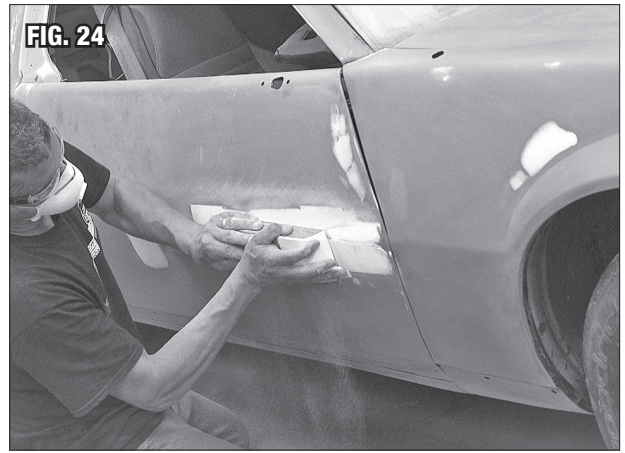
- After a full cure, sand the Filler with an Eastwood #19857 Dura-Block Sanding Board (Included with Kits #23122ZP & 23123ZP) reduce the filler to match the surrounding contour with successive grades of P120, P220 and P320 Abrasive Paper (FIGS 24, 25 & 26).
- Once again apply the Guide Coat between sanding each application with a progressively finer grit of paper, as described previously in these instructions (FIG 27).
- Check for High and or Low spots and repeat the entire process as required (FIG 28).

⚠ NOTICE

This repeated phase of block sanding, filling, guide coating, can become quite labor intensive and tedious however the time and effort expended at this stage will dramatically affect the final quality and outcome of the finished paint job.

Rule of thumb: "If in doubt; go back and do it again"...

Every flaw and sanding mark is visible in the final paint finish once it cures and shrinks back...no flaws reflect perfection. Only you can determine the outcome!

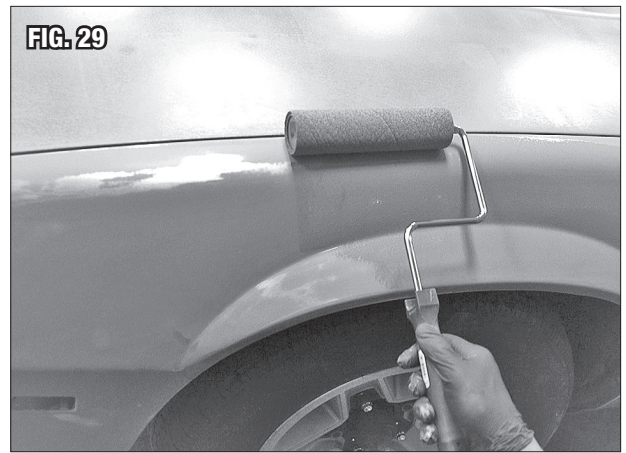


APPLY ADDITIONAL 2 COATS OF OPTIFLOW EPOXY PRIMER

This should be done only after all body work is as perfect as it can be.

Following the same steps outlined for the 1st two coats, mix the Epoxy Primer with Catalyst in the specified 1:1 ratio for proper curing. Only mix the amount needed to coat the planned body panel. Do Not exceed what can be coated within a 20 minute working window.

- After a full cure (4 days), sand the Primer with an Eastwood #19857 Dura-Block Sanding Board (Included with Kits #23122ZP & 23123ZP) with P320 grit, then finally P400 grit Abrasive Paper, using the previously described 45° crisscrossing sanding pattern technique, again using Guide Coat.
- If the optional coats of Eastwood Roll-On Urethane Primer/Surfacer are not being applied, the vehicle can now be considered ready for the final, spray-applied finish coat (**FIG 31**).

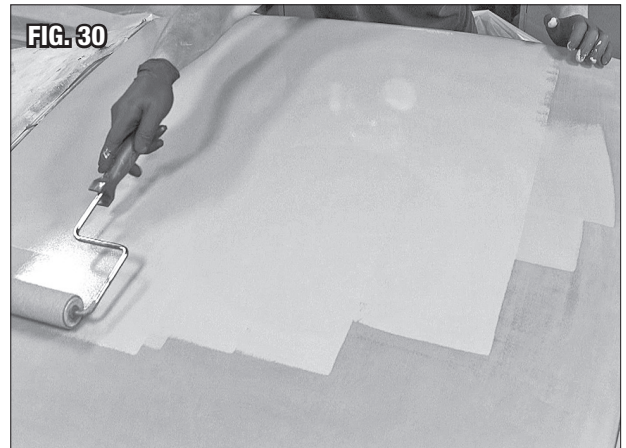


APPLYING ROLL-ON URETHANE SEALER

The Eastwood Urethane Primer/Surfacer is mixed with the Activator in the specified 4:1 ratio for proper curing. DO NOT mix the entire gallon but only the amount needed to coat the planned body panel or not to exceed what can be coated within a 30 minute working window.

TIP: Start by mixing 25 oz. total (20 oz. Part A; 5 oz. Part B) to start priming vehicle.
If more primer is required, mix another small batch in a 4:1 ratio.
Only mix what can be used in 30 minutes!

- Apply the Eastwood Roll-On Urethane Primer/Surfacer over cured Epoxy Primer. Epoxy Primer must be cured for at least 4 days and sanded to a 400 grit finish, as described in the steps outlined for application of the Eastwood Epoxy Primer at the beginning of these Instructions.
- After allowing 30 minutes between each coat, roll on 3 to 4 coats of Eastwood Roll-On Urethane (**FIGS 29 & 30**).
- After a full cure of 4 hours, sand the Urethane Primer/Surfacer with an Eastwood #19857 Dura-Block Sanding Board (Included with Kit #23123ZP) with successive grades of P220 grit, P320 grit, then finally P400 grit Abrasive Paper, using the previously described 45° crisscrossing sanding pattern technique.
- The Urethane Primer may be successfully wet-sanded after overnight cure.
- The Prep, Prime and Seal job is complete (**FIG 31**).



WELL DONE! You now have the peace of mind knowing that the best possible paint prep job was done all while saving valuable labor costs which can be applied to other aspects of the project.

OPTIFLOW REPLACEMENT ITEMS AND ACCESSORIES

- #23130ZP Eastwood OptiFlow DTM Epoxy Primer, Gray, Gallon
- #23131ZP Eastwood OptiFlow Epoxy Primer Catalyst, Gallon
- #23132ZP Eastwood OptiFlow Urethane Primer/Surfacer, Gray, Gallon
- #23133ZP Eastwood OptiFlow Urethane Primer Activator, Quart
- #23140 Eastwood OptiFlow Roller and Tray Kit
- #66186ZP Eastwood OptiFlow DTM Epoxy Primer, Black, Gallon
- #66187ZP Eastwood OptiFlow Urethane Primer/Surfacer, Black, Gallon
- #66188ZP Eastwood OptiFlow DTM Epoxy Primer, Gray, Quart
- #66189ZP Eastwood OptiFlow DTM Epoxy Primer, Black, Quart
- #66190ZP Eastwood OptiFlow Epoxy Primer Catalyst, Quart

If you have any questions about the use of this product, please contact

The Eastwood Technical Assistance Service Department: 800.343.9353 >> email: tech@eastwood.com

PDF version of this manual is available at eastwood.com

The Eastwood Company 263 Shoemaker Road, Pottstown, PA 19464, USA 800.343.9353 eastwood.com

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