

Preparation description: **Hot/Cold rolled steel**

General Information:

Rolling is a metal-forming process in which metal stock is passed through one or more pairs of rollers to reduce the thickness and to achieve a uniform thickness. Rolling is classified according to the temperature of the metal rolled. If the temperature of the metal is above its recrystallization temperature, then the process is termed **hot rolling**. If the temperature of the metal is below recrystallization temperature, this is known as **cold rolling**.

The surface to be painted must be dry, clean and free from any contamination, e.g. corrosion, oil, grease, release agents.

It is very important to use the correct PPE (personal protective equipment) such as: gloves, glasses, mask. Only use appropriate tools and equipment, and certified grinding media.

Use slower evaporating cleaners to avoid condensation on the surface; do not apply any paint products to objects which are subject to the influence of moisture. Recoating must be executed without any undue delay (within 60-90 minutes), with direct lacquers or primer and topcoat.

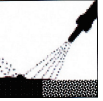
Cleaning

Products: RS605/607/609 Universal Reducer or AD690 Degreaser

	to refine 1x	Use the recommended products with a brush or soaked cloth/rag to remove the residues on the surface. If the contamination level is too high, repeat the cleaning step.
	wipe dry	With a clean dry cloth, wipe the dissolved contaminant from the surface, repeat until the surface is dry.

Sanding

Products: P80 – P180 – P240 (eccentric) grinding machine or scuff pad

	Beam technology (optional)	Recommended methods are: dry ice blasting or possible blasting medium for the iron/steel surface. Choose the right pressure depending on the thickness and construction of the object.
	sanding	Hot/cold rolled iron/steel has to be sanded after the cleaning process with an eccentric grinding machine (<5mm orbital unit), P80 – P180 sanding disk. For direct lacquers use a P180 – P240 sanding disk (this size grit is needed to avoid sanding marks in the finish).
	scuffing	With a nylon-perlon abrasive part to roughen the surface, e.g. fine scuff pad; treat edges and corners with care.
After grinding/scuffing the bare metal surface must appear. (Weathering -, corrosion residues and other impurities must not be visible).		

Cleaning

Products: RS605/607/609 Universal Reducer or AD690 Degreaser

	cleaning with pressured air	The sanded/scuffed surface must be cleaned with compressed air so that loose abrasive particles which were not vacuumed by the suction device are removed.
	to refine 1x	Use the recommended products with a soaked cloth/rag to remove the residues on the surface.
	wipe dry	With a clean dry cloth, wipe the dissolved contaminant from the surface, repeat until the surface is dry.

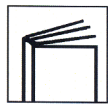
Coating

Depending on the recommendation, such as HVLP/LVLP/RP Spray gun or Low-High pressure pump...

	to coat	Application of direct to metal topcoats, primer, primer surfaces with basecoat and clearcoat or topcoat.
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Please select a suitable paint system from the “System Technique” datasheets.

Further Information

		For more information see: • Information at CRS (ICRIS, COINS, Valspar refinish) • Purple Box starter pack information sheets • Information on our web page (www.valsparindustrialmix.com) ○ Technical Information ○ Technical Data sheets
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This preparation description has been developed in order to enable professional users to maintain the high quality standards for Valspar (Light) Industrial Mix and Commercial vehicle systems.

Precautions: During application all health and safety measures referring to the use and handling of coating materials are to be observed, e.g. existing regulations issued by the trade associations in the chemical industry. For Health and Safety information, please refer to the Material Safety Datasheet (MSDS). Information is also available on our web page: www.valsparindustrialmix.com

Note: The products listed are intended only for the professional user and for professional use. All recommendations given in writing on the use of our products to customers or users are non-binding and do not give reasons for secondary obligations resulting from the bill of sale. Every care is taken to ensure that the technical information provided is accurate and up to date according to the present state of knowledge in science and our experience. These recommendations do not, however, exempt the customer from independently checking whether our products are suitable for the intended purpose. The durability of the coating system largely depends on thorough preparation of the surface. Furthermore our uniform terms of delivery and payment are applicable

With the publication of this Technical Data Sheet all previous versions regarding this product are no longer valid.