

Preparation description: Shot Blasted Iron/Steel

General Information:

All shot blasted iron/steel components (must be more than 3mm material thickness) should be have a roughness of 20-50µm. Depending on the condition of the rough surface, the user needs to decide which coating system to apply, e.g. direct lacquer or primer and topcoat..

The corrosion protection layer (primer) should be 3 times more than the grade of shot blasted surface.
The purity of iron/steel surface should be SA 2½ (EN ISO 12944, part 4), the surface must be dry and free from any contamination, e.g. oil or grease.

Avoid condensation on the steel surface: do not apply any paint products to objects which are subject to the influence of moisture at temperatures below 8°C, Recoating must be executed without any undue delay (within 60-90 minutes), with direct lacquers or primer and topcoat.

It is very important to use the correct PPE (personal protective equipment) such as gloves, glasses, mask, and protective overalls.

Shot blasting

Products: blasting material such as aluminium oxide, steel grit, steel shot, garnet, blast furnace slag.



Beam technology

Recommended methods are: air blasting, centrifugal wheels (dry) or any other blasting medium that is suitable for the iron/steel surface.

The purity of the iron/steel surface should be SA 2½

Cleaning



cleaning with
pressurized air

The blasted surface must be cleaned with compressed air so that loose abrasive, shot blasted particles are removed. Use a suction device.

If there is contamination such as oil or grease on the shot blasted surface, use: RS605/607/609 Universal Reducer or AD690 Degreaser.



to apply
1x

Use the recommended products with spray equipment or a brush to remove the residues on the surface.

If the contamination is too severe, repeat the cleaning step.



drying

Use compressed air to dry and clean the surface.

Coating

Depending on the recommendation, such as a HVLP/LVLP/RP spray gun or low-high pressure pump...

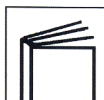


to coat

Application of direct to metal topcoats, primer, primer surfaces with basecoat and clearcoat or topcoat.

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



This preparation description has been developed in order to enable professional users to maintain 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 webpage: 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.