

Preparation description: Multiple substrates (Steel, Galvanized Steel, Aluminium, GFK)

General Information:

Commercial vehicles, trucks, motor homes, caravans, trailers etc., are very often produced or manufactured with different substrates. Any metal surfaces may be protected by a thin layer of oil; Glass fibre may have a film of residues on the surface from the production process. Use selected cleaning products to remove the oil coat or residues.

OEM or old painted parts which are to be recoated, must be free from damage and have good adhesion. If the adhesion is not good enough, remove the coating completely by sanding, or suitable beam technology to make the new coating durable. Do not use beam technology on glass fibre or plastic objects.

It is very important to use the correct PPE (personal protective equipment) such as gloves, glasses and masks. Use only the appropriate tools, equipment with anti static properties to avoid cross contamination (sanded aluminium is highly explosive!), and certified grinding media. Avoid contact corrosion.

Aluminium should not be exposed to temperature fluctuations before coating. This can result in dew point (the atmospheric temperature, which varies according to pressure and humidity, at which water droplets begin to condense and dew can form). This can be very light and not obviously visible.

Use slower evaporating cleaners to avoid condensation on the surfaces. 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.

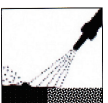
Cleaning

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. Purity test: wipe the surface with white clean cloth, repeat this step until the cloth remains clean after wiping; this ensures there is no contamination left on the surface.

Sanding

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

	Beam technology (Do not use for GFK/plastic)	Use suitable beam methods with non-metal material, if necessary with low pressure to avoid the risk of deformation.
	sanding	Hard/Soft Aluminium has to be sanded after the cleaning process with an eccentric grinding machine (<5mm rotary lift unit), a P180 – P240 sanding disk and special aspirator for aluminium. Galvanized steel P180 – P240 (eccentric grinding machine). → Do not destroy the protective zinc layer! Steel P180 – P240 (eccentric grinding machine) Glass fibre P240 (eccentric grinding machine)
	scuffing (recommended for respray)	With a nylon-perlon abrasive part to roughen the surface, e.g. fine/ultra fine scuff pad (do not use wire wool or similar metal content medium). Treat edges and corners with care.
Do not use grinding machines or other abrasive products on rivets, this can reduce their strength. Use only a scuff pad (fine/ultra fine Scotch-Brite). After grinding/scuffing, the surfaces must sanded smooth before applying any primer and/or topcoat. (Weathering/corrosion residues and other impurities must be removed before any painting operation).		

Cleaning

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

	cleaning with pressured air	The sanded/scuffed aluminium 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. Purity test: wipe the surface with white clean cloth, repeat this step until the cloth remains clean after wiping. This ensures there is no contamination left on the surface.

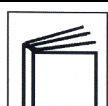
Coating

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.
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Please select a suitable paint system from the “System Technique” datasheets.

Further Information

	More information see:
	• Information at CRS (ICRIS, COINS, Valspar refinish) • Information sheets in our Purple Box starter pack • 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 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 intend 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.
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