

Preparation description: Fibreglass – GFK/GRP/GFRP (glass-fibre reinforced plastic)

General Information:

During the construction of Fibreglass a release agent is used to release the plug from the mould. This is a liquid type of wax. The most common construction is a 2-component resin: polyester, vinyl or epoxy mixed with hardener and applied on to the mould surface. Sheets of fibreglass matting are laid into the mould and then more resin mixture is added using a spray, brush or roller.

Problems during paint application could include: contamination from the release agent and/or pin holes, (this is the result of air bubbles getting trapped in the production process; when sanded they reveal a half bubble, a pin-hole.

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

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

Use only the appropriate tools and equipment, and certified grinding media.

The surface may be contaminated from the release agent. The release agent can be removed with water but the wax content must be removed with degreaser. Use water and/or degreaser on the surface. Do not apply any paint products to objects which are subject to the influence of moisture and temperatures below 8°C. Recoat with direct lacquers or primer and topcoat. Note: it is advisable to heat fibreglass to 40°C-50°C for one hour before cleaning to expel all release agents.

Cleaning

Products: distilled water, suitable water cleaner and AD690 Degreaser

	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.

Preparation - Sanding

Products: P180 – P240 – P320 eccentric grinding machine or scuff- pad

	sanding	Existing coatings and new parts must to be sanded after the cleaning process with an eccentric grinding machine (<5mm rotary lift unit), sanding disk and aspirator. The sanding surface should be: for putty, P180; for primer and surfacer, P240; for direct lacquers, use a P320 sanding disk (to reduce sanding marks).
	scuffing	With a nylon-perlon abrasive part to roughen the surface, e.g. a fine/ultra fine scuff. Treat the edges and corners with care.

Optional:

	Putty (in case of damage)	Remove the coating from the damaged areas and choose suitable Valspar putty. Spray filler (polyester spray filler/putty) is also an option. Add the hardener according to the TDS
	sanding	Sand the putty zone back with P150 or P180 and finally P240 for primer application (do not increase by more than P100 when changing grit sizes).

Cleaning

Products: suitable water cleaner or AD690 Degreaser

	cleaning with pressurized air	The sanded/scuffed surface must be cleaned with compressed air so that loose abrasive particles that were not vacuumed by the suction device are removed.
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	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.

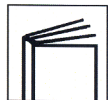
Coating

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

	to coat	Application of direct to metal topcoats, primer, primed surfaces with basecoat and clearcoat or topcoat. Note: For the best result use primer with filler, sand the primer/filler back after drying and apply the topcoat. Recommendation for outdoor use and high humidity zones: use Epoxy primer.
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Please select a suitable paint system from the “System Technique” datasheets.

Further Information

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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 intend purpose. The durability of the coating system largely depends on the 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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