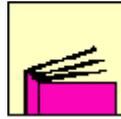


FOR PROFESSIONAL USE ONLY



Q0100

Date of Issue : August 2002

Preparation and Pre-treatment

Products	
P850-1367	Cleaner and Degreaser
P850-1378	Spirit Wipe
P800-127	De-ruster
P271-571	Paint Stripper
P273-901	Body Cleaner
P273-1050	Anti-static Cleaner
A 273-1041	Mordant Solution
P856-1	Gunwash

DESCRIPTION

With the variety of substrates used in the manufacture of commercial vehicles, it is essential that they are identified and treated correctly before the primer and topcoat are applied. When the following procedures are carried out thoroughly the maximum life span of the paint system will be ensured.

THESE PRODUCTS ARE FOR THE PROFESSIONAL PAINTING OF AUTOMOTIVE VEHICLES ONLY AFTER REFERENCE TO THE MANUFACTURER'S MATERIAL SAFETY DATA SHEET

WORKS PRIMER & FINISH

Vehicles components treated with protective wax or grease-based materials should be carefully steam cleaned in accordance with the vehicle manufacturer's recommendations. After steam cleaning, remove any residual wax by wiping down with P850-1378 (degrease with P850-1367), then sand the complete vehicle using P180-P240 dry sanding machine discs (or using P400-P500 paper if wet flattening).

Following flattening remove all dust by blowing off with dry compressed air and wipe clean with P850-1378, using one rag to apply and a clean rag to wipe off. Any areas of primer or finish not in sound condition should be stripped back and the unpainted surface pre-treated accordingly.

POWDER COATINGS

Any components treated with wax or grease based materials should be carefully steam cleaned. After steam cleaning remove any residual contaminants by wiping down with P850-1367 degreaser. Sand with P180-P240 dry sanding machine discs or P400 if wet flattening. After flattening remove all dust by blowing off with dry compressed air and wipe clean with P850-1378, using one rag to apply and a clean rag to wipe off.

Any areas of primer or finish not in sound condition should be stripped back mechanically or with Paint Stripper (P271-571) and the unpainted surface pre-treated accordingly.

UNPAINTED SURFACES

The appropriate pre-treatment procedure varies according to the type of material. Recommendations for the preparation of various types of material are given below. All surfaces should be cleaned thoroughly prior to painting and should be free of any surface contaminants.

Steel

Bare steel requires careful preparation if the **Nexa Autocolor** paint system is to provide maximum protection against corrosion.

The preferred pre-treatment method for hot/cold rolled steel chassis constructions is blast cleaning, as this offers the most efficient method for the removal of rust and mill scale. This process should be carried out to BS7079 Part A1 (2nd Quality Swedish Standard SA2.5) resulting in a fine surface profile no coarser than fine-medium grade as defined by ISO Standard 8503. After blast cleaning, all contaminants should be removed using a brush and dry compressed air or vacuuming. The surface should be primed immediately after blasting with the relevant **Nexa Autocolor** holding primer.

As a general rule, blast cleaning and painting is not recommended when the relative humidity exceeds 85%. Care should also be taken not to contaminate the cleaned surfaces by excessive handling. Alternatively for good quality cold rolled steel, flat thoroughly using P80-180 dry sanding machine discs or P120-220 wet and dry paper the wipe clean with P850-1378.

Small areas of steel and steel metal panels may be prepared by using De-ruster (P800-127) to remove rust and other contaminants and to lightly etch the metal. De-ruster should be mixed 1 part of De-ruster to 2 parts of water in a plastic or rubber bucket. Brush well into the surface and leave in contact until the corrosion is removed. Rinse off with fresh water. Dry the metal immediately to prevent staining and prime as soon as possible.

Steel without surface rust may be degreased using P850-1367. Finally wipe and clean using P850-1378, using one rag to apply and a clean rag to wipe off.

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Hot dipped galvanised steel (with frost flake pattern)

Degrease with P850-1367 using Scotch-Brite™ Fine pad. Treat by brushing on a coat of Mordant Solution (A273-1041) scrubbing until the surface darkens. The Mordant Solution should be washed off using clean cold water, and the surface allowed to dry. Wipe clean with P850-1378, using one rag to apply and a clean rag to wipe off.

If using a quality 2-pack Epoxy Primer, the use of Mordant Solution is not required. In this case thoroughly degrease the surface with P850-1367, scuff with Scotch-Brite™ fine or P400 and clean with P850-1378.

Weathered galvanised steel / Electronically deposited zinc (Zintec)

Wash off any dirt using Body Cleaner (P273-901) and degrease with P850-1367 and then scuff using Scotch-Brite Fine. Wipe clean with P850-1378 using one rag to apply and a clean rag to wipe off before priming with the relevant etch primer (e.g. Primecoat P565-625). Alternatively sand the surface using P240-320 dry sanding machine discs prior to priming with an epoxy primer.

Note: Weathered Galvanised Steel must be free from oxidation residues.

Stainless steel

Degrease with P850-1367 and scuff with P400 paper or P240-320 dry sanding machine discs before cleaning with P850-1378, using one rag to apply and a clean rag to wipe off. Prime with an etch or epoxy primer.

Zinc sprayed steel

Remove oil and grease using P850-1367 and then scrub with clean water and stiff bristle brushes to remove white deposits of any soluble salts present on the surface. Allow to dry completely before applying one double coat of Primecoat (P565-625), activated with **Slow Activator (P275-232)**. Allow to dry overnight. This etching primer will seal and provide temporary protection only. Apply primer / undercoat as soon as possible.

Aluminium

Degrease with P850-1367. Thoroughly abrade the surface using P240-320 dry sanding machine discs or by hand with P400 wet and dry paper. Difficult parts such as rivet heads or irregular sections should be scuffed very thoroughly with Scotch-Brite Fine. P850-1378 is useful as a lubricant. Wipe clean with P850-1378 using one rag to apply and a clean rag to wipe off.

Glass reinforced polyester (GRP) / Glasonite / SMC

Where possible refer to the substrate manufacturers' recommendations on preparation prior to painting. As a general guide remove any release agent using Body Cleaner (P273-901) and sand carefully using P320-P400 dry sanding machine discs or scotchbrite. Take care not to break through the gel coat. Wipe clean with P850-1378 using one rag to apply and a clean rag to wipe off. Allow to dry thoroughly before painting.

Considerable care should be taken when preparing GRP/Glasonite/SMC.

Plastic surfaces

Clean the plastic by applying diluted Body Cleaner (P273-901) with Scotch-Brite Ultrafine to remove traffic film or other contaminants and at the same time lightly scuffing the surface. Rinse thoroughly with water and allow to dry.

Apply Anti-static cleaner for plastics (P273-1050) to the whole of the area to be painted. Use one lint free cloth for application and one for wiping off contaminants.

Look for imperfections on the surface, such as pinholes and pores. Rag in Porefiller (P551-1700) and wipe or de-nib off.

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PREVIOUSLY PAINTED SURFACES

Look carefully for any signs of film breakdown, e.g. chalking, cracking, humidity blistering. Low gloss levels often indicate surface irregularities caused by chalking, or micro-blistering and more thorough investigation with a magnifying glass is needed. Look for evidence of brittleness or poor adhesion often indicated by excessive stone chipping. If in doubt, test the film by scraping with a penknife.

Defective paint must be removed. If the existing film weight is high, it may be advisable to strip it rather than apply further coats, as excessive film weight impairs durability.

Old finish in sound condition / Factory finish

Thoroughly clean to remove all traces of surface contamination by washing down with Body Cleaner (P273-901).

Flat with abrasive paper not coarser than P280 grade. Deep scratches should be "feather edged" with 180 grit abrasive paper.

Clean off thoroughly and dry.

Defective paintwork

Areas of defective paintwork should be removed using Paint Stripper (P271-571). Clean with P850-1378 using one rag to apply and a clean rag to wipe off. Areas of bare steel should be primed immediately to prevent surface rusting.

Composite coated plyboard shutters

Remove any surface dust from the substrate and apply 1 full coat of 2-pack Chromate Free Etch Primer (P565-767). Dry for a minimum of 1 hour or until hard dry. Dry flat with P400 paper wet and dry or with P320 stearate paper. Tack rag wipe.

Apply one coat of Repaint Undercoat (P595-line) and flash off for 20-30 minutes. Apply second coat of Repaint Undercoat. Dry for 2 hours. Apply EHS Hi-Gloss 383™ (P383-line).

FILLING DENTED OR IRREGULAR SURFACES

Degrease the area to be filled using P850-1367 and sand using P80-P120 abrasive discs.

Any deep dents should be filled using Universal Stopper (P551-1052). Allow to dry for approximately 45 minutes at 20°C. Sand to shape with P80-P180 dry abrasive discs. Wipe clean using P850-1378 using one rag to apply and a clean rag to wipe off.

This information is given in good faith but without warranty.

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