



Technical Bulletin TB-004

Sand and Bead Blast Media Refinishing

When using various types of sand or plastic media blasting materials in paint removal, the following guidelines should be followed for proper refinishing performance.

SAND BLASTING:

Most types of sand blasting media will effectively clean and prepare steel, aluminum, galvanized and galvaneal for priming.

- If the substrate is thoroughly sandblasted, no metal treatments are recommended.
- Blow off the substrate with clean compressed air and reclean with ONECHOICE® SX330/SXA330 ACRYLI-CLEAN® Wax and Grease Remover or SX440 DITZ-O® Wax and Grease Remover prior to priming.
- Apply DPLF or DPLV Epoxy Primers immediately or within a maximum of 12 hours for steel substrates and within 15 minutes for aluminum.
- Do not allow the substrate to set unprimed for long periods as corrosion will form and cause loss of adhesion due to rust under the primer or paint film.

PLASTIC MEDIA BLASTING:

Plastic bead blast media is designed for paint removal, cleaning, deflashing, deburring, and surface preparation. Media selection will determine the effectiveness of the surface preparation.

The plastic blasting method is not the answer to all surface coating removal requirements.

- Plastic blasting media may not remove severe corrosion.
- Use of large sized media at high pressures can result in penetration through Alclad surfaces and anodized coatings.
- It is possible to remove cadmium if blasting pressures are too high.
- Damage can occur to certain types of fiberglass and thin honeycomb if the process is not carefully controlled.

However, properly utilized the plastic blasting process offers immediate labor, time, equipment, material, and energy savings in the many applications for which the material's use is appropriate.

- If the surface is thoroughly blasted with the proper media for the corresponding substrate no metal treatments or additional sanding may be necessary.
- Blow off substrate with clean compressed air and reclean with SX330/SXA330 *Acryli-Clean* or SX440 *Ditz-O* Wax and Grease removers prior to priming.
- Apply DPLF or DPLV Epoxy Primers immediately or within the same day for best results.
- *OneChoice* SX1071 ECOBASE® 5.5 Etch Prime may also be used on the appropriate recommended substrates prior to priming or topcoating.
- The same precautions apply as when using a sand blast media.

