

Substrates and Preparation

Technical Bulletin

11/02/2019

L8.06.02 UK & Ireland

DESCRIPTION

This document gives an overview of the substrates and their pre-treatment used in the car refinishing industry.

The indicated sanding steps in this document are based on the 3M 255P Gold line:

P80 - P120 - P220 - P320 - P400 - P500.

All sanding grits are related to dry sanding unless explicitly otherwise mentioned.

PREPARATION

Existing finishes:

Cleaning steps:

1. Wash the surface with warm water and detergent. Rinse sufficiently with clean water.
2. Degrease thoroughly with a solventborne degreaser.

Final sanding before application of:

1. Sanding filler: P220 grit.
2. Non sanding filler: P320 grit.

Previous sanding steps should not exceed 100 in grit size.

Clean and degrease thoroughly.

OEM Electrocoat:

Thoroughly clean before application of filler

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Steel, Aluminum, Galvanized / Zinc coated steel:

Cleaning:

Degrease thoroughly with a solventborne degreaser.

Final sanding before application of:

1. Sanding filler: P220 grit.
2. Non sanding filler: P320 grit.

Previous sanding steps should not exceed 100 in grit size.

Clean and degrease thoroughly with a solventborne degreaser.

Note: In case of anodized aluminum, remove the oxide layer.

Polyester, gel coated laminates (fiberglass):

Cleaning:

Degrease thoroughly with Antistatic Degreaser SB.

Final sanding: P320 grit.

Previous sanding steps should not exceed 100 in grit size.

Degrease thoroughly with Antistatic Degreaser SB

- o The gel coat of the polyester laminate contains very small pinholes that are difficult to detect and therefore a sanding filler is advised.
- o If the gel coat is damaged, additional bodyfiller application is necessary.

Polyester bodyfillers and polyester spraying fillers:

Cleaning:

Degrease thoroughly with a solventborne degreaser.

Final sanding before application of:

1. Sanding filler: P220 grit (P320 grit for the featheredge)
2. Non sanding filler: P320 grit.

Previous sanding steps should not exceed 100 in grit size.

Clean and degrease thoroughly with a solventborne degreaser.

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Fillers

Degrease thoroughly.

Final sanding before application of:

1. Single Stage Topcoat: P400 grit.
2. Basecoat: P500 grit.

Previous sanding steps should not exceed 100 in grit size.

Clean and degrease thoroughly.

Akzo Nobel Coatings LTD

Address: Unit 2B, Didcot Park
Churchward, Southmead Industrial Estate
Didcot, Oxfordshire, OX11 7HB
Tel: 00 44 (0)1235 862226

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Head Office

Akzo Nobel Car Refinishes B.V., PO Box 3 2170 BA Sassenheim, The Netherlands. www.Lesonal.com