

# Substrates and Preparation

Technical Bulletin

11/02/2019

L8.06.02 UK &amp; 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.*

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## PREPARATION

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### **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.

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### **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.

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**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.

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**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.

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