

Substrates and Preparation

Technical Bulletin

05/10/2020

L8.06.02 AUS

DESCRIPTION

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

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

P80 - P120 - P220/P240 - 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 primer filler: P320 grit.
2. Non sanding primer filler: P320 - P400 grit.

Previous sanding steps should not exceed 100 in grit size.

Clean and degrease thoroughly.

OEM Electrocoat:

Thoroughly clean before application of primer 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 primer filler: P220/P240 grit.
2. Non sanding primer 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 primer filler: P220/P240 grit (P320 grit for the featheredge)
2. Non sanding primer filler: P320 – P400 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 (minimum)
2. Basecoat: P500 grit (minimum)

Previous sanding steps should not exceed 100 in grit size.

Clean and degrease thoroughly.

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