

Substrates and Preparation

Technical Bulletin

05/08/2023

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

Substrates and Preparation

Technical Bulletin

05/08/2023

L8.06.02 AUS

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.

Substrates and Preparation

Technical Bulletin

05/08/2023

L8.06.02 AUS

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.

Akzo Nobel Pty Ltd T/A Akzo Nobel Car Refinishes Australia
Address: Unit 3/344 Lorimer Street, Port Melbourne, VICTORIA, 3207
Tel: +61 3 9644 1711

FOR PROFESSIONAL USE WITH SUITABLE HS&E EQUIPMENT

IMPORTANT NOTE: The information in this data sheet is not intended to be exhaustive and is based on the present state of our knowledge and on current laws: any person using the product for any purpose other than that specifically recommended in the technical data sheet without first obtaining written confirmation from us as to the suitability of the product for the intended purpose does so at his own risk. It is always the responsibility of the user to take all necessary steps to fulfill the demands set out in the local rules and legislation. Always read the Material Data Sheet and the Technical Data Sheet for this product if available. All advice we give or any statement made about the product by us (whether in this data sheet or otherwise) is correct to the best of our knowledge but we have no control over the quality or the condition of the substrate or the many factors affecting the use and application of the product. Therefore, unless we specifically agree in writing otherwise, we do not accept any liability whatsoever for the performance of the product or for any loss or damage arising out of the use of the product. All products supplied and technical advices given are subject to our standard terms and conditions of sale. You should request a copy of this document and review it carefully. The information contained in this data sheet is subject to modification from time to time in the light of experience and our policy of continuous development. It is the user's responsibility to verify that this data sheet is current prior to using the product.

Brand names mentioned in this data sheet are trademarks of or are licensed to AkzoNobel.

Head Office

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