AquaSurTech OEM Document
#PREP-01-0712
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a/Title : PVC Cleaning Procedure

b/ Description : This document explains the process of cleaning and preparing PVC for the application of AquaSurTech D200 & AquaSurTech AquaUltra Basecoat.

c/ Required pre-requisite procedure(s):
N/A

d/ Products Required :
Vinyl Kleen
Vinyl Prep

e/ Expected Coverage:
Varies depending on shape & complexity of the extrusion or frames to be cleaned.

f/ Optimum Environment:
Dust free environment close to paint area to minimize handling
Proper lighting
Temperature 70 – 90 degree Fahrenheit

g/ Tools Needed:
Clean lint free rags or cloths
Scotch Brite pads
Air gun on filtered compressed air system
Recommended safety equipment (refer to MSDS)

h/ Preparation of substrate:
Place extrusion or frames on a solid surface or rack where unnecessary handling will be minimized in a dust free environment and blow off any debris with an air gun.

i/ Preparation of Product:
Make use of spray bottles to apply the Vinyl Kleen and Vinyl Prep onto the rags. Dipping a cloth directly into the containers of Vinyl Kleen or Vinyl Prep will contaminate the cleaners.

Vinyl Kleen and Vinyl Prep should be used as is and not diluted.

j/ Method
Profiles must be cleaned thoroughly prior to spraying. Contaminants such as silicones, wax and grease (commonly found on PVC fabricator premises) cause major problems on surfaces to be sprayed. Silicones are particularly problematic, as they diffuse through the air at a high rate and are carried long distances. The majority of all application problems arise through inadequate cleaning. The following cleaning stages are essential:

Using a clean cloth soaked with Vinyl Kleen wash the surface area to be coated followed by a clean dry cloth.
The amount of cleaning required is determined by the amount of contamination on the substrate. If a more aggressive cleaning is necessary place a Scotch-Brite pad on your cleaning cloth. Soak the pad with Vinyl Kleen and scuff the entire surface to be cleaned (the cleaning cloth will absorb any excessive liquid on the Scotch Brite pad).
Wipe the surface dry woth a clean dry cloth.

It is essential that the final cleaning be done with Vinyl Prep to remove any remaining residue. Using a clean cloth soaked with Vinyl Prep wipe the surface to remove the residue followed by a clean dry cloth.
This process requires only one cleaning pass.

k/ Drying/Curing:
Once the Vinyl Prep has been applied and wiped off the substrate is ready for application. No further drying or flash off is required.

l/ Clean-Up & storage:
Vinyl Kleen and Vinyl Prep can be stored in the spray bottles used for application. Dispose of used rags and Scoth-Brite pads accordingly

m/ QC :
An important step in the coating process is to make sure the substrate has been properly cleaned. Wettability testing can be performed by a simple water test. Testing is performed AFTER the substrate has been wiped with VinylPrep.

Water Test Procedure: A squeeze bottle is adequate for this process. Place a few drops of water on the cleaned surface.

- No contaminants are present if the water does NOT bead and the surface remains wet = Pass (photo # 1)

- Contaminants are present if the water beads and can be rolled across the surface without wetting the substrate = Fail (photo # 2)
- FAIL – If the surface fails the wet-ability test the product must be placed back into the cleaning process and a more aggressive cleaning performed.

Water Test Photo #1 – Prep Pass

Water Test Photo #2 – Prep Fail

n/ Optional Follow–On Processes:
N/A

o/ Alternative Processes :
N/A