

a/Title : Pre-painted or Primed Aluminum cleaning procedure

b/ Description : This document explains the process of cleaning and preparing pre-painted or primed aluminum for the application of AquaSurTech D200 & AquaSurTech AquaUltra Basecoat.

c/ Required pre-requisite procedure(s):

N/A

d/ Products Required :

Acetone

e/ Expected Coverage:

Varies depending on shape & complexity of the extrusion or surfaces to be cleaned.

f/ Optimum Environment:

Dust free environment

Open area with ample ventilation

g/ Tools Needed:

Clean lint free rags or cloths

Scotch Brite pads

Air gun on filtered compressed air system

Recommended safety equipment (refer to product instructions and 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:

Acetone should be stored and used in its original approved container. No prior preparation is required before use.

j/ Method

Profiles must be cleaned and scuffed thoroughly prior to spraying. Contaminants such as silicones, wax and grease 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.

Safety measures must be observed when handling Acetone. Please refer to the manufacturer's or suppliers instructions and safety data prior to use.

Scuff the surfaces lightly to be painted using a Scotch Brite pad soaked in Acetone. Full removal of the pre-painted surface is not recommended, the purpose is to break the smooth surface of the pre-painted or primed aluminum to allow the coating to bond not to remove it completely. After scuffing and prior to coating wipe down the surfaces thoroughly with a clean rag soaked in Acetone to clean the aluminum.

k/ Drying/Curing:

The Acetone will evaporate on its own so no further wiping is necessary.

l/ Clean-Up & storage:

Acetone must be kept sealed in a cool dry area in its original approved container. Dispose of used rags and Scotch-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 had a final wipe with Acetone.

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.

Painting a test piece and performing a cross hatch test after curing to verify adhesion is recommended for QC and as a retainer.

n/ Optional Follow-On Processes:

N/A

o/ Alternative Processes :

Mill finish aluminum will require the use an epoxy primer prior to applying AquaSurTech waterbased coatings. Please contact us for more details and specific recommendations.