

a/Title : Complete Production Oriented Process for Preparing Doors for Application of D200 or AquaSurTech Stain Products.
(Steel and Smooth and Textured Fiberglass)

b/ Description : This document explains the complete process & techniques of preparing doors for application of D200 or AquaSurTech stain products.

c/ Required pre-requisite procedure(s):

None

d/ Products Required :

Vinyl Kleen

Vinyl Prep

e/ Expected Coverage:

N/A

f/ Optimum Environment:

Proper lighting

Temperature 60 – 90 degree Fahrenheit

Humidity range moderate

g/ Tools Needed:

400 Grit Wet / Dry Sandpaper

600 Grit Wet / Dry Sandpaper

Lint Free Rags

Compressed Air

Pneumatic sander (recommended)

Recommended safety equipment (refer to MSDS)

h/ Preparation of substrate:

The object of the preparation is to make the substrate dull, smooth, clean and water wettable. This will work to ensure that the coating wets out thoroughly in application, resulting in a smooth film with adhesion to the substrate.

i/ Preparation of Product:

N / A

j/ Procedure

Wet sand the door with 400 grit wet / dry sandpaper and Vinyl Kleen to dull the surface in all areas and ensuring that no glossy surface areas remain. Wipe the door down with a clean lint free rag to remove sanding residue.

Wet sand the door with 600 grit wet / dry sandpaper and Vinyl Kleen to smooth out any scratches in the surface and to remove any remaining gloss. Wipe the door down with a clean lint free rag to remove sanding residue.

Liberally wipe the door with Vinyl Prep using a lint free rag to remove any residual Vinyl Kleen and sanding dust. Wipe off Vinyl Prep completely with lint free rags to ensure the door is free from all residue and sanding dust.

k/ QC

The door can be visually inspected for any areas of gloss that may remain. Glossy areas indicate that sufficient sanding was not done and is required further to gain adhesion.

Visual inspection will also determine if any dirt or dust remains. As the final wiping off of the Vinyl Prep is done, no white sanding dust should be visible on the clean lint free rag. Sanding dust allowed to remain on the door will rest in between it and the coating which will prevent adhesion in that area. It is imperative that the door is completely free of all dirt and dust before application. A water test will serve as an indication as to whether or not the door has been sufficiently prepared and ready for application of D200. Pouring some water on an area of the door that has been prepared following the steps prescribed above

will test the wettability and provide visual feedback of the surface preparation. If the water wets out, not beading up or pulling back as it is spread, the D200 coating will wet out similarly, helping to produce desirable results of a smooth film formation and adhesion of the coating to the substrate. Any area where the water beads up or pulls back will require more preparation attention before application.

Water Test – FAIL



Water Test - PASS

