

Carbon Steel

NOTE:

An important aspect for a coating systems successful performance is matching the surface preparation with the primers, primer surfacers and primer sealers being applied. The primer coat must have a minimum amount of material above the abrasion profile to perform properly. Consult the Technical Data Sheet of the primer being used or if you have further questions consult your Endura representative.

For other substrates, refer to the Endura recommended surface preparation instruction sheets or contact your Endura Representative or contact us at 1-800-661-9930 or online at www.endurapaint.com.

GALVANIZED STEEL – NEW UNCOATED

The zinc layer of galvanized steel is a hinderance to the adhesion of most coatings if oxide layers have developed. The best preparation of galvanized steel is through a chemical process described below.

Cleaning:

Cleaning is an important part of the surface preparation process and should be performed first. Cleaning removes any grease, release agents or any surface contaminants which may interfere with the optimal adhesion of the coating system. These surfaces contaminants can be driven deeper into the metal by the preparation processes of sanding or sandblasting and may affect future adhesion.

Degreaser 10

1. Read the Technical Data Sheet and Safety Data Sheet before using Degreaser 10 and assure that you have and are wearing all the recommended Personal Protective Equipment (PPE) prior to commencing use.
2. If the surface is hot, wet, and cool down before applying Endura Degreaser 10.
3. Apply the Degreaser 10 liberally to the surface with brush or low-pressure spray, keep the surface wet for 5 -10 minutes and using a maroon nylon scuffing pad scrub the surface during this time.
4. Rinse with plenty of clean water and do not let the Degreaser 10 dry on the surface while you are cleaning. For larger surfaces, rinsing with a power washer (1500psi minimum) is recommended.
5. Once well rinsed, any seams, crevices or rivet areas should be blown down with clean compressed air.
6. Once the surfaced has been properly rinsed and dry the final part of the preparation process can be completed.

Surface Preparation:

Option 1: Neutralizer 20

1. Read the Technical Data Sheet and Safety Data Sheet before using Neutralizer 20 and assure that you have and are wearing all the recommended Personal protective equipment prior to commencing use.
2. If the surface is hot, wet, and cool down before applying Neutralizer 20.
3. Apply the Neutralizer 20 liberally to the surface with brush or low-pressure spray, keep the surface wet for 5 -10 minutes and using a maroon nylon scuffing pad scrub the surface during this time.
4. Rinse with plenty of clean water and do not let the Neutralizer 20 dry on the surface while you are preparing. For larger surfaces, rinsing with a power washer (1500psi minimum) is recommended.
5. Once well rinsed, any seams, crevices or rivet areas should be blown down with clean compressed air.
6. Once the surfaced has been properly dried apply the primer within 8 hours, high humidity may reduce this time. Zinc oxidizes quickly, If the time between preparation and priming exceeds 8 Hours, the preparation process must be repeated.

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Option 2: Brush blasting

Brush Blast Cleaning: SSPC-SP7, this blasting method cleans less aggressively than an industrial blast clean. A brush-off blast cleaned surface is described as a surface free of all visible oil, grease, dirt, dust, loose mill scale, loose rust, and loose coating when viewed without magnification. The surface may still include profiled and tightly adherent mill scale, rust, and coating.

Zinc oxidizes quickly, If the time between preparation and priming exceeds 8 Hours, the preparation process must be repeated.

When Brush blasting a galvanized metal surface it is important to remove only the top layers of zinc oxides to reveal clean a clean bright zinc surface. Sandblasting too aggressively will remove the zinc from the substrate and eliminate its corrosion protection properties.

Adhesion loss of paint finishes are generally the result of poor surface preparation.