

Previously Painted

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.

PREVIOUSLY PAINTED SUBSTRATES

Evaluation

Degreaser 10

For sanding and repainting over existing finishes it is important to carefully examine and evaluate the existing finish.

- 1) Evaluate the type of existing coating with a solvent rub test. Some existing single component products can be affected by the aggressive solvents from a subsequent coating application and potentially wrinkle and cause adhesion failure to the substrate. A solvent rub test should be performed to test the existing coatings solvent resistance. The solvent rub test is performed using the most aggressive thinner used in the new coating being applied. Solvent is applied to a rag and rubbed over the surface at least 20 -30 rubs. If there is no material color on the rag, then the existing coating is stable for application of the new product. If color removal is present on the rag, the surface is not stable for the application of the new coating and should be removed.
- 2) Another evaluation point is the total film thickness of the existing coating. If the coating on the substrate is already over 8 mils dry (203 microns) it should be removed.
- 3) Evaluate the overall adhesion of the existing paint system as the new paint system adhesion to the substrate is only as good as the existing system. Tape adhesion tests can be performed at random points to evaluate the overall existing coating adhesion. Where there will be spot repairs, ensure the adhesion is sufficient to be able to featheredge without breaking away from the primer or substrate.

After evaluation there will be two courses of action:

- 1) Total removal of the existing coating
- 2) Preparation of the existing coating for application of the new system

Existing Paint System Removal

When it is determined that an existing paint system needs to be removed, there are three main options for removal. The choice will depend on the equipment at hand or the substrate. The following are the choices:

- 1) Chemical removal – Paint Stripper
- 2) Sanding
- 3) Abrasive Blasting

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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 surface 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 surface has been properly rinsed and dry the final part of the preparation process can be completed.

Existing Paint System Removal

Chemical Removal Paint Stripper – Acid Free

1. Before using any chemical remover, product assure that all Technical information and Safety Data Sheets have been read. Assure that you follow all recommendations for Personal Protection Equipment (PPE).
2. If using Endura Paint Stripper apply by non-atomizing spray, brush, or pour on methods.
3. Allow the Stripper to sit on the surface for 15-20 mins or until the film starts to bubble up from the substrate.
4. Use a metal scraper to lift and remove the old finishes.
5. Depending on the film build and adhesion to the surface, multiple applications may be necessary.
6. Brush with a stiff bristle brush to remove paint residue.
7. Dispose of all paint remnants and stripper remnants in an environmentally safe manner, following all local, state, provincial and federal regulations.
8. Once the existing coating is removed, refer to the surface preparation information sheet for the substrate that you are working on to assure that the preparation prior to priming has been met.

Note: Take care in removal on thin skin aluminum surfaces.

Sanding

To remove existing finishes using the sanding method use 80 grit mechanical sanding to remove the coating to the substrate.

1. Once the existing coating is removed refer to the surface preparation information sheet for the substrate that you are working on to assure that the preparation prior to priming have been met.

Note: Take care in removal on thin skin aluminum surfaces.

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Sand Blasting

For Carbon Steel, Stainless Steel (Thick Wall), Aluminum (Thick Wall)

1. For removal of existing coatings from the above listed substrates sandblasting can be used.
2. Perform a Commercial Blast SSPC-SP 6: NACE 3, SSPC-SP6, or Sa 2, is a method of preparing steel surfaces to be free of all visible oil, grease, dirt, dust, mill scale, rust, and paint. Generally, evenly dispersed, very light shadows, streaks and discoloration caused by stains of rust, stains of mill scale, and stains of previously applied paint may remain on no more than 33% of the surface. Slight residue of rust and paint may also be left in the craters of pits if the original surface is pitted.
3. Once the existing coating is removed refer to the surface preparation information sheet for the substrate that you are working on to assure that the preparation prior to priming have been met.
- 4.

Existing Paint System – Preparation

If it has been determined that the existing coating is in good condition with good adhesion and that the new paint system will not cause lifting, the following preparation procedures can be followed.

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.

Mechanical Sanding:

1. Once the existing surface has properly dried from using degreaser 10, mechanically sand the surface with 180 grit-220 grit. A maroon nylon scuffing pad can be used in hard to reach areas.
2. If there are spot repairs, featheredge the areas with mechanical sanding of 180 grit-220 grit.
3. Assure that all surface gloss has been removed. An existing finish surface that is not properly prepared will have adhesion problems.
4. Once sanded, blow off all sanding dust with clean compressed air.

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