ALUMINUM SURFACE PREPARATION GUIDE FOR APPLICATION OF SPI SPRAY PURE POLYUREA PRODUCTS

1. Clean surface to remove contaminants. All surfaces must be sound, dry, clean and free of oil, grease, dirt, mildew and other contaminants.
2. Best results are obtained over a surface sandblasted as follows.
3. For a non-working substrate: Achieve a 1-2 mil anchor profile using 80 mesh Garnet or equal.
4. For a working substrate: Such as pick-up beds, dump trucks, redi-mix trucks, hoppers, traffic decks, etc. achieve a 2-3 mil anchor profile using 60 or 40 mesh Garnet or equal.
5. Equipment: Use an air compressor with 250 CFM (min.) (0.08 m/s) at a minimum of 70-80 psi for a 1-2 mil anchor profile or 90 psi (620.5 kPa) for a 2-3 mil anchor profile. Use a 7/16-1/2" (11-13mm) nozzle.
6. Profile depth to be confirmed with comparators, replica tape or depth micrometers.
7. Surface temperature must be at least 5° F (3 °C) Above the dew point for dry blast.
8. Following grit blast, blow off or vacuum up dust from surface. Optionally, a phosphoric acid wash solution may be used – rinse clean and dry.
9. It is recommended that the acid wash be followed by an Aluminum conditioner, following the instructions of the manufacturer of the aluminum conditioner.
10. The adhesion of SPI SPRAY PURE POLYUREA PRODUCTS to aluminum can be enhanced with penetrating bonding agents. Please consult technical service personnel for specific primer recommendation.
11. Coating should be applied within 4 hours of blasting the surface to insure no oxidation occurs which could affect coating adhesion.

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