

# PREPARATION GUIDE FOR ALUMINUM SURFACE



## 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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