EHS Turbo Plus Systems Process Chart

NEXA AUTOCOLOR

SUBSTRATE	PREPARATION	PRIMER / UNDERCOAT	TOPCOAT

If Extra Build Required:

Steel

Preparation:
- Blast-clean to Swedish Standard SA2.5 to give a blast profile of 20-30 microns
- Degrease with P850-1367 Cleaner & Degreaser
- Remove rust with P800-127 Deruster using Red 3M Scotchbrite
- Machine sand (P80-180)
- Clean with P850-1367

Stainless Steel

Preparation:
- Degrease with P850-1367 Cleaner & Degreaser
- Machine sand (P180-320)
- Clean with P850-1367

Galvanised Steel (Weathered) / Zintec

Preparation:
- Remove heavy road film with P273-901 Body Cleaner
- Degrease with P850-1367 Cleaner & Degreaser using Red 3M Scotchbrite
- Clean with P850-1367

Minor Damage (Steel / Stainless / Galvanised Weathered / Zintec):
- Dry sand affected areas with P80-180 paper
- Apply P551-1052 Universal Stopper to bare metal only
- Dry sand to shape with P80-240

Primer / Undercoat:

Product	Code
HP Epoxy Primer P580-3501/2, P580-3005	T8000 / T8500
Fastbuild (unthinned) P540-4xx	T0650
Buildprimer 2 P540-51x	T3000
Primecoat P565-625	S0200
Chromate-Free Etch Primer P565-767	S0100

If Extra Build Required:

Product	Code
High Build Primer Surfacer P565-1027/1028	U1130
Wet-on-Wet Undercoat P565-897	U0830

Galvanised Steel (New)

Preparation:
- Degrease with P850-1367 Cleaner & Degreaser using Red 3M Scotchbrite
- Clean with P850-1367

Minor Damage:
- Dry sand affected areas with P80-180 paper
- Apply P551-1052 Universal Stopper to bare metal only
- Dry sand to shape with P80-240

Primer / Undercoat:

Product	Code
Primecoat P565-625	S0200
Chromate-Free Etch Primer P565-767	S0100
HP Epoxy Primer P580-3501/2, P580-3005	T8000 / T8500

If Extra Build Required:

Product	Code
High Build Primer Surfacer P565-1027/1028	U1130
Wet-on-Wet Undercoat P565-897	U0830

Aluminium and its Alloys

Preparation:
- Degrease with P850-1367 Cleaner & Degreaser
- Machine sand (P240-400) or abrade with Red 3M Scotchbrite
- Clean with P850-1367

Minor Damage:
- Dry sand affected areas with P180-240 paper
- Apply P551-1052 Universal Stopper to bare metal only
- Dry sand to shape with P80-240

Primer / Undercoat:

Product	Code
HP Epoxy Primer P580-3005	T8500
Primecoat P565-625	S0200
Chromate-Free Etch Primer P565-767	S0100

If Extra Build Required:

Product	Code
High Build Primer Surfacer P565-1027/1028	U1130
Wet-on-Wet Undercoat P565-897	U0830

GRP and "Glasonite"

Preparation:
- Remove mould release agents with P273-901 Body Cleaner
- Abrade with Red 3M Scotchbrite or machine sand with P320-400

Minor Damage / Pinholes:
- Dry sand with P240-400
- Apply P551-1052 Universal Stopper, then dry-sand to shape with P80-240

Primer / Undercoat:

Product	Code
HP Epoxy Primer P580-3501/2, P580-3005	T8000 / T8500
Buildprimer 2 P540-51x	T3000
Primecoat P565-625	S0200
Transparent Sealer P565-755	U0930
High Build Primer Surfacer P565-1027/1028	U1130
Wet-on-Wet Undercoat P565-897	U0830

Factory Finish / Old 2-Pack Topcoat

Preparation:
- Remove heavy road film with P273-901 Body Cleaner
- Machine sand with P280-600
- Degrease with P850-1378
- Spirit Wipe

Minor Damage:
- Dry sand affected areas with P180-400 paper
- Apply P551-1052 Universal Stopper to bare metal only
- Dry sand to shape with P80-240

Old 1-Pack Topcoat

Preparation:
- Remove heavy road film with P273-901 Body Cleaner
- Machine sand with P280-600
- Degrease with P850-1378
- Spirit Wipe

Minor Damage:
- Dry sand affected areas with P180-400 paper
- Apply P551-1052 Universal Stopper to bare metal only
- Dry sand to shape with P80-240

Primer / Undercoat:

Product	Code
Buildprimer 2 P540-51x (activated)	T3000
Waterborne Epoxy Primer P950-6502	T3500

Powder Coating

Preparation:
- Remove transit wax according to manufacturers instructions
- Then clean with P850-1367 Cleaner & Degreaser
- Machine sand with P120-180
- Wipe with P850-1378 Spirit Wipe

Minor Damage:
- Dry sand affected areas with P180-400 paper
- Apply P551-1052 Universal Stopper to bare metal only
- Dry sand to shape with P80-240

Primer / Undercoat:

Product	Code
HP Epoxy Primer P580-3501/2, P580-3005	T8000 / T8500
Buildprimer 2 P540-51x	T3000
Transparent Sealer P565-755	U0930
Wet-on-Wet Undercoat P565-897	U0830

Topcoat (general)

Product	Code
EHS Turbo Plus Single Layer Solid Colours P498-Line	V0930
EHS Turbo Plus Structured Finish P478-Line	V4320

Plastics

Other Plastics — Preparation:
- Clean with P273-1333 Detergent Cleaner for Plastic, applied using 3M Scotchbrite, Rinse thoroughly with water. When completely dry, wipe with P273-1050 Anti-Static Wipe
- Denib if required with P800 and wipe with P273-1050 Anti-Static Wipe

Primer / Undercoat:

Product	Code
Adhesion Primer for Plastics P572-2000 / -2001	L0800
Wet-on-Wet Undercoat P565-897 using P100-2020 Flexible Additive if Required	U0830

Topcoat:

Product	Code
EHS Turbo Plus Single Layer Solid Colours P498-Line using P100-2020 Flexible Additive if Required	V0930
EHS Turbo Plus Structured Finish P478-Line using P100-2020 Flexible Additive if Required	V4320