

# Altra~Build® 520

## Guidelines & Flowcharts for Preparation and Top-Coating with Polyurethane Finish



### Sanding Notes: Altra~Build® 520 when used as a High Finish Surfacer

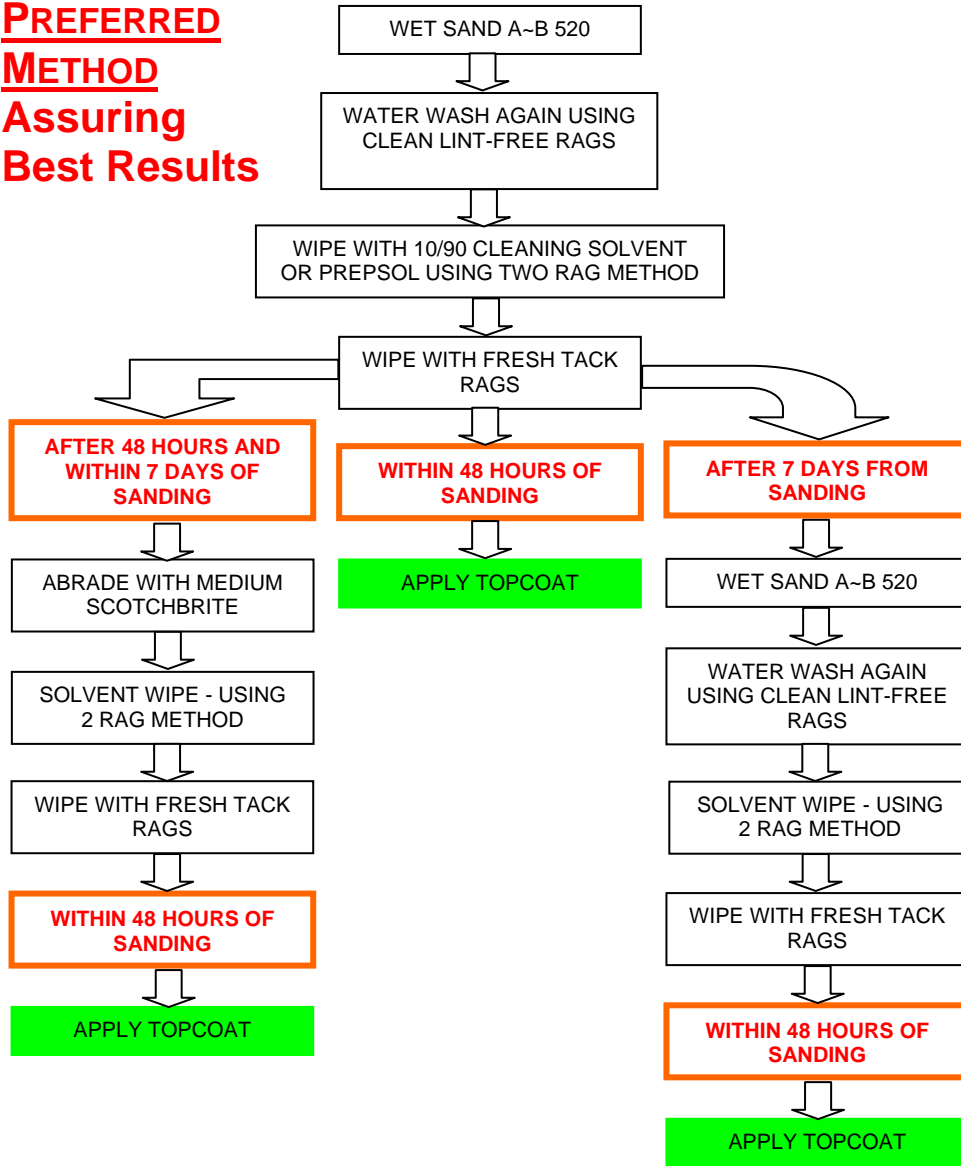
- The Altra~Build 520 recoat schedule and procedures flow-charted overleaf are based around ambient surface and air temperatures in the range 10°C to 30°C and it is assumed that work is carried out under cover and away from direct sunlight on the work-piece. For items directly exposed to sunlight it is recommended to halve the guide recoat intervals.
- **Sanding:** Where possible it is highly recommended to adopt wet sanding procedures, especially at the final sanding stage. Wet sanding can overcome problems inherent with dry sanding methods; there are two good reasons for wet sanding which effectively cancel out the adverse effects of dry sanding as follows:-
  - **1. Wet sanding**, by obvious implication, leads to water rinsing and wiping of sanded surfaces - this latter 'washing' effect is proven to be the most effective method for removal of sanding residues, which can produce imperfections in the gloss finish and, more importantly compromise adhesion of the finish coat.
  - **2.** Even with added time for drying the surface it is well-proven that wet sanding greatly increases the cutting power of the abrasive by reducing heat build up, 'flushing' the sanded profile, and thus leading to increased production.
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  - If **dry sanding** is the only option then it is imperative to follow the three stage cleaning process after sanding:-
    - **1.** Blow down the surface with clean dry compressed air while dry wiping with clean rags (changing rags frequently) to remove sanding dust and residue.
    - **2.** Carefully wipe the entire surface using clean rags soaked in 10/90 Preparation Solvent or Prepsol - use the two rag method and change rags frequently
    - **3.** Tack off the surface with high quality tack rags (such as Trempro Tack Cloth-2K) - turn and change tack-rags frequently

It should be noted that the tack rag procedure should ideally also be carried out on wet-sanded and rinsed surfaces once they are dry; thus ensuring no 'mud residue' is present.

May 2008

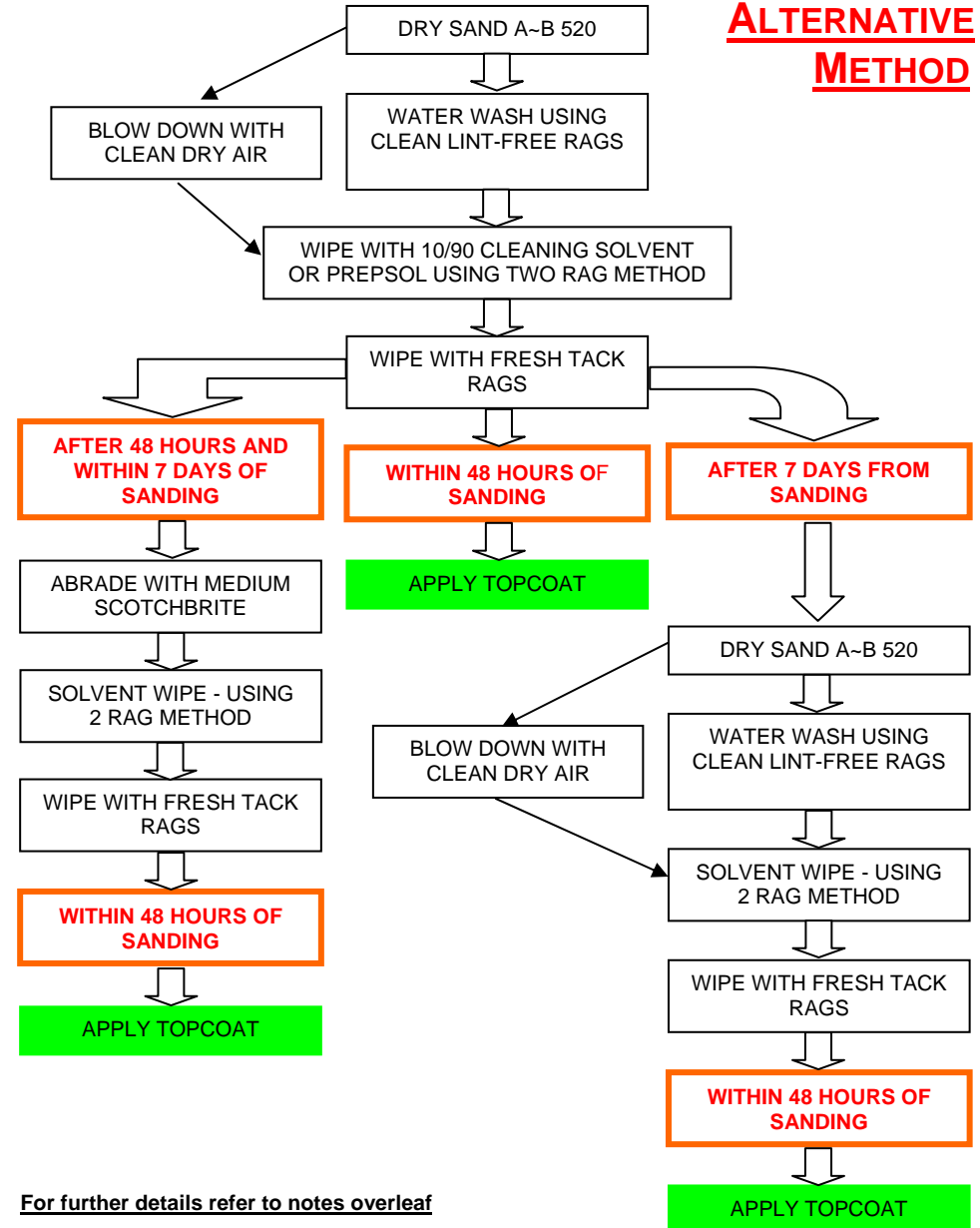
# Preparation & Timing Procedure Flow-Charts for Top-Coating Altra~Build<sup>®</sup> 520

## PREFERRED METHOD Assuring Best Results



For further details refer to notes overleaf

## ALTERNATIVE METHOD



For further details refer to notes overleaf