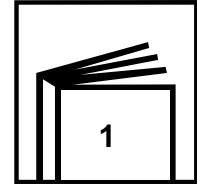


Standex Charts & Systems

Substrate Pretreatment



WORKING PROCESS

SUBSTRATE PRETREATMENT

Substrates First Cleaning

Sanding
* See Important
Remarks

Final Cleaning

Bare			
Steel	Standex Silicone Remover Antistatic (16203), Standohyd VOC Cleaner 25 (16178) or Standohyd Cleaner (16176) Standex Silicone Cleaner (16208)	Dry sand P80 - P220	Standex Silicone Remover Antistatic (16203) Standohyd VOC Cleaner 25 (16178) or Standohyd Cleaner (16176)
Soft Aluminum	Standex Silicone Remover Antistatic (16203), Standohyd VOC Cleaner 25 (16178) or Standohyd Cleaner (16176) Standex Silicone Cleaner (16208)	Dry sand P180 - P240	Standex Silicone Remover Antistatic (16203), Standohyd VOC Cleaner 25 (16178) or Standohyd Cleaner (16176)
Galvanized Substrates	Standex Silicone Remover Antistatic (16203), Standohyd VOC Cleaner 25 (16178) or Standohyd Cleaner (16176) Standex Silicone Cleaner (16208)	Scuff pad (red)	Standex Silicone Remover Antistatic (16203), Standohyd VOC Cleaner 25 (16178) or Standohyd Cleaner (16176)

Old Paintwork			
Through-hardened Paintwork	Standex Silicone Remover Antistatic (16203), Standohyd VOC Cleaner 25 (16178) or Standohyd Cleaner (16176) Standex Silicone Cleaner (16208)	Orbital sand P400 - P500	Standex Silicone Remover Antistatic (16203), Standohyd VOC Cleaner 25 (16178) or Standohyd Cleaner (16176)
Through-hardened 2K Paintwork	Standex Silicone Remover Antistatic (16203), Standohyd VOC Cleaner 25 (16178) or Standohyd Cleaner (16176) Standex Silicone Cleaner (16208)	Orbital sand P400 - P500	Standex Silicone Remover Antistatic (16203), Standohyd VOC Cleaner 25 (16178) or Standohyd Cleaner (16176)
Through-hardened Synthetic Paintwork	Standex Silicone Remover Antistatic (16203), Standohyd VOC Cleaner 25 (16178) or Standohyd Cleaner (16176) Standex Silicone Cleaner (16208)	Orbital sand P400 - P500	Standex Silicone Remover Antistatic (16203), Standohyd VOC Cleaner 25 (16178) or Standohyd Cleaner (16176)
TPA Paintwork	Standex Silicone Remover Antistatic (16203), Standohyd VOC Cleaner 25 (16178) or Standohyd Cleaner (16176) Standex Silicone Cleaner (16208)	Orbital sand P500	Standex Silicone Remover Antistatic (16203), Standohyd VOC Cleaner 25 (16178) or Standohyd Cleaner (16176)
Cellulose Paintwork	Standex Silicone Remover Antistatic (16203), Standohyd VOC Cleaner 25 (16178) or Standohyd Cleaner (16176) Standex Silicone Cleaner (16208)	Orbital sand P500	Standex Silicone Remover Antistatic (16203), Standohyd VOC Cleaner 25 (16178) or Standohyd Cleaner (16176)

Pre-primed Substrates			
OEM primed	Standex Silicone Remover Antistatic (16203), Standohyd VOC Cleaner 25 (16178) or Standohyd Cleaner (16176) Standex Silicone Cleaner (16208)	Orbital sand P280-P400** Dry sand P280 - P600 Gray or gold scuff pads	Standex Silicone Remover Antistatic (16203), Standohyd VOC Cleaner 25 (16178) or Standohyd Cleaner (16176)
1K Primer / Acid Primer	Standex Silicone Remover Antistatic (16203), Standohyd VOC Cleaner 25 (16178) or Standohyd Cleaner (16176) Standex Silicone Cleaner (16208)	Gray or gold scuff pads	Standex Silicone Remover Antistatic (16203), Standohyd VOC Cleaner 25 (16178) or Standohyd Cleaner (16176)
1K Filler	Standex Silicone Remover Antistatic (16203), Standohyd VOC Cleaner 25 (16178) or Standohyd Cleaner (16176) Standex Silicone Cleaner (16208)	Gray or gold scuff pads	Standex Silicone Remover Antistatic (16203), Standohyd VOC Cleaner 25 (16178) or Standohyd Cleaner (16176)
2K Primer Surfacer/ 2K Filler	Standex Silicone Remover Antistatic (16203), Standohyd VOC Cleaner 25 (16178) or Standohyd Cleaner (16176) Standex Silicone Cleaner (16208)	Orbital sand P400 - P500	Standex Silicone Remover Antistatic (16203), Standohyd VOC Cleaner 25 (16178) or Standohyd Cleaner (16176)

*** Important Remarks = Recommended Sanding Procedures**

*Machine paper is not recommended for hand sanding. This type of paper is designed for the action of a machine and generates a deeper scratch when used by hand.

*Dry hand sanding should be done with dry hand sanding paper only. Use the same grit recommendations as wet sanding.

** = First cleaning as recommended is sufficient if the substrate is a sound, solvent-resistant OEM primer coat

***Please see the Standoflex® Plastic Refinishing section for plastic substrate information.**