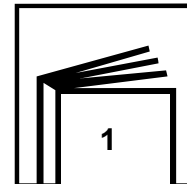


Standex Charts & Systems

Substrate Pretreatment



WORKING PROCESS

SUBSTRATE PRETREATMENT

Substrates First Cleaning

Sanding
* See Important
Remarks

Final Cleaning

Bare			
Steel	Standex Silicone Remover Antistatic (11654/15099), Standohyd Silicone Remover 0.4 (15889) or Standohyd Cleaner (16155/16166)	Dry sand P80 - P220	Standex Silicone Remover Antistatic (11654/15099), Standohyd Silicone Remover 0.4 (15889) or Standohyd Cleaner (16155/16166)
Soft Aluminum	Standex Silicone Remover Antistatic (11654/15099), Standohyd Silicone Remover 0.4 (15889) or Standohyd Cleaner (16155/16166)	Dry sand P180 - P240	Standex Silicone Remover Antistatic (11654/15099), Standohyd Silicone Remover 0.4 (15889) or Standohyd Cleaner (16155/16166)
Galvanized Substrates	Standex Silicone Remover Antistatic (11654/15099), Standohyd Silicone Remover 0.4 (15889) or Standohyd Cleaner (16155/16166)	Scuff pad (red)	Standex Silicone Remover Antistatic (11654/15099), Standohyd Silicone Remover 0.4 (15889) or Standohyd Cleaner (16155/16166)

Old Paintwork			
Through-hardened Paintwork	Standex Silicone Remover Antistatic (11654/15099), Standohyd Silicone Remover 0.4 (15889) or Standohyd Cleaner (16155/16166)	Orbital sand P400 -P500 Wet sand P600 - P800	Standex Silicone Remover Antistatic (11654/15099), Standohyd Silicone Remover 0.4 (15889) or Standohyd Cleaner (16155/16166)
Through-hardened 2K Paintwork	Standex Silicone Remover Antistatic (11654/15099), Standohyd Silicone Remover 0.4 (15889) or Standohyd Cleaner (16155/16166)	Orbital sand P400 - P500 Wet sand P600 - P800	Standex Silicone Remover Antistatic (11654/15099), Standohyd Silicone Remover 0.4 (15889) or Standohyd Cleaner (16155/16166)
Through-hardened Synthetic Paintwork	Standex Silicone Remover Antistatic (11654/15099), Standohyd Silicone Remover 0.4 (15889) or Standohyd Cleaner (16155/16166)	Orbital sand P400 - P500 Wet sand P600 - P800	Standex Silicone Remover Antistatic (11654/15099), Standohyd Silicone Remover 0.4 (15889) or Standohyd Cleaner (16155/16166)
TPA Paintwork	Standex Silicone Remover Antistatic (11654/15099), Standohyd Silicone Remover 0.4 (15889) or Standohyd Cleaner (16155/16166)	Wet sand P800	Standex Silicone Remover Antistatic (11654/15099), Standohyd Silicone Remover 0.4 (15889) or Standohyd Cleaner (16155/16166)
Cellulose Paintwork	Standex Silicone Remover Antistatic (11654/15099), Standohyd Silicone Remover 0.4 (15889) or Standohyd Cleaner (16155/16166)	Wet sand P800	Standex Silicone Remover Antistatic (11654/15099), Standohyd Silicone Remover 0.4 (15889) or Standohyd Cleaner (16155/16166)

Pre-primed Substrates			
OEM primed	Standex Silicone Remover Antistatic (11654/15099), Standohyd Silicone Remover 0.4 (15889) or Standohyd Cleaner (16155/16166)	Orbital sand P280-P400** Wet sand P280 - P600 Dry sand P280 - P600 Gray or gold scuff pads	Standex Silicone Remover Antistatic (11654/15099), Standohyd Silicone Remover 0.4 (15889) or Standohyd Cleaner (16155/16166)
1K Primer / Acid Primer	Standex Silicone Remover Antistatic (11654/15099), Standohyd Silicone Remover 0.4 (15889) or Standohyd Cleaner (16155/16166)	Wet sand P800 Gray or gold scuff pads	Standex Silicone Remover Antistatic (11654/15099), Standohyd Silicone Remover 0.4 (15889) or Standohyd Cleaner (16155/16166)
1K Filler	Standex Silicone Remover Antistatic (11654/15099), Standohyd Silicone Remover 0.4 (15889) or Standohyd Cleaner (16155/16166)	Wet sand P800 Gray or gold scuff pads	Standex Silicone Remover Antistatic (11654/15099), Standohyd Silicone Remover 0.4 (15889) or Standohyd Cleaner (16155/16166)
2K Primer Surfacer/ 2K Filler	Standex Silicone Remover Antistatic (11654/15099), Standohyd Silicone Remover 0.4 (15889) or Standohyd Cleaner (16155/16166)	Orbital sand P400 - P500 Wet sand P600 - P800	Standex Silicone Remover Antistatic (11654/15099), Standohyd Silicone Remover 0.4 (15889) or Standohyd Cleaner (16155/16166)

*** 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.

* Wet/dry sanding paper should always be used wet. If this type of paper is used dry it can generate a scratch 2-3 grit sizes coarser than when used correctly wet.

** = 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.**