

TECHNICAL REGULATIONS FOR COATING SANDWICH PANELS

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1 Recognise polyester with pinholes

Pinholes in polyester undergrounds are frequently only visible after applying the coat layer. The consequence is a coated surface in which small holes are visible. These pinholes are so small that they cannot be filled up with a filler layer. This filler even worsens the problem because it forms an edge around the pinhole.







To check the to be painted polyester in advance on the presence of these pinholes, we recommend to apply a thin layer of Autobase black or Spraycan Primer Grey on the underground or parts of it. Possibly present pinholes are now clearly perceptible.

1.1 Filling up pinholes








When by controlling the underground appears that pinholes are present, treat the underground according to the system mentioned below.

<p>Pre-processing</p>   	<p>Clean the underground with:</p> <p>Degrease the underground:</p> <p>Rougher the underground:</p> <p>Make the underground dust-free and degrease once again:</p>	<ul style="list-style-type: none"> ☞ Warm water and soap ☞ BT LV 775 Antistatic Silicon Remover ☞ 3M Scotch Brite ultra fine or ☞ 3M Scotch Brite very fine or ☞ 3M Scotch Brite Purple ☞ BT LV 775 Antistatic Silicon Remover
<p>Ground treatment</p> 	<p>Fill up the pinholes by rubbing the whole panel with a BT LV 775 Antistatic Silicon moistened cloth with Autocoat BT MM 475.</p> <p>Remove the redundant mat paste after drying by degreasing the whole with:</p> <p>or</p> <p>Rougher the whole with:</p> <p>Next you can finish the underground with filler and finishing coat.</p>	<ul style="list-style-type: none"> ☞ BT MM 475 possibly something diluted with LT LV 775 Antistatic Silicon Remover ☞ BT LV 775 Antistatic Silicon Remover ☞ 3M Scotch Brite Purple










2.2 Filling wet in wet system

Underground: polyester		
<p>Pre-processing</p>   	<p>Clean the underground with:</p> <p>Degrease the underground:</p> <p>Rougher the underground:</p> <p>Make the underground dust-free and degrease once again:</p>	<ul style="list-style-type: none"> ☞ Warm water and soap ☞ BT LV 775 Antistatic Silicon Remover ☞ 3M Scotch Brite ultra fine or 3M Scotch Brite very fine or 3M Scotch Brite Paars ☞ BT LV 775 Antistatic Silicon Remover
<p>Ground treatment</p>  	<p>Coat the total underground:</p> <p>You can recoat this sealer with finishing coat after sufficient evaporation time without sand papering.</p>	<ul style="list-style-type: none"> ☞ BT filler 121 or 15 µm ☞ BT LV Filler 721 20 µm
<p>Finishing</p> 	<p>Coat with:</p>	<ul style="list-style-type: none"> ① Autocoat BT 40 µm ② Autocaot BT LV 40 µm ③ Autobase-metallic/pearl 15 µm BT Clearcoat 301 or 40 µm BT LV Clearcoat 701 40 µm ④ Autowave-metallic/pearl 20 µm BT Clearcoat 301 or 40 µm BT LV Clearcoat 701 40 µm
<p>Layer thicknesses</p>	<p>The stated layer thicknesses are minimum layer thicknesses. For detailed processing data see the technical information pages of the mentioned products.</p>	<ul style="list-style-type: none"> ① Total minimum layer thickness 60 µm ② Total minimum layer thickness 60 µm ③ Total minimum layer thickness 75 µm ④ Total minimum layer thickness 95 µm










2.3 Filling system

Underground: polyester		
<p>Pre-processing</p>   	<p>Clean the underground with:</p> <p>Degrease the underground:</p> <p>Rougher the underground:</p> <p>Make the underground dust-free and degrease once again:</p>	<ul style="list-style-type: none"> ☞ Warm water and soap ☞ BT LV 775 Antistatic Silicon Remover ☞ 3M Scotch Brite ultra fine or ☞ 3M Scotch Brite very fine or ☞ 3M Scotch Brite Purple ☞ BT LV 775 Antistatic Silicon Remover
<p>Ground treatment</p>   	<p>Coat the total underground with 2-3 layers:</p> <p>For the correct product combination and mixing ratio see the technical information page.</p> <p>Sand paper this filler after curing:</p> <p>Make the underground dust-free and degrease:</p>	<ul style="list-style-type: none"> ☞ BT filler 121 60 µm ☞ P400 -10 µm ☞ Autowave Degreaser
<p>Finishing</p> 	<p>Coat with:</p>	<ul style="list-style-type: none"> ① Autocoat BT 40 µm ② Autocaot BT LV 40 µm ③ Autobase-metallic/pearl 15 µm BT Clearcoat 301 or 40 µm BT LV Clearcoat 701 40 µm ④ Autowave-metallic/pearl 20 µm BT Clearcoat 301 or 40 µm BT LV Clearcoat 701 40 µm
<p>Layer thicknesses</p>	<p>The stated layer thicknesses are minimum layer thicknesses. For detailed processing data see the technical information pages of the mentioned products.</p>	<ul style="list-style-type: none"> ① Total minimum layer thickness 90 µm ② Total minimum layer thickness 90 µm ③ Total minimum layer thickness 105 µm ④ Total minimum layer thickness 110 µm

2.4 Extra filling sand paper system

Underground: polyester		
<p>Pre-processing</p>   	<p>Clean the underground with:</p> <p>Degrease the underground:</p> <p>Rougher the underground:</p> <p>Make the underground dust-free and degrease once again:</p>	<ul style="list-style-type: none"> ☞ Warm water and soap ☞ BT LV 775 Antistatic Silicon Remover ☞ 3M Scotch Brite ultra fine or ☞ 3M Scotch Brite very fine or ☞ 3M Scotch Brite Purple ☞ BT LV 775 Antistatic Silicon Remover
<p>Ground treatment</p>     	<p>Coat the total underground:</p> <p>Sand paper this surfacer after curing:</p> <p>Make the underground dust-free.</p> <p>Recoat with 2 layers:</p> <p>For the correct product combination and mixing ratio see the technical information page.</p> <p>Sand paper this filler after curing:</p> <p>Make the underground dust-free and degrease:</p>	<ul style="list-style-type: none"> ☞ Polysurfacer 100 µm ☞ P180 - P280 -40 µm ☞ BT Filler 121 60 µm ☞ P400 -10 µm ☞ Autowave Degreaser
<p>Finishing</p> 	<p>Coat with:</p>	<ul style="list-style-type: none"> ① Autocoat BT 40 µm ② Autocaot BT LV 40 µm ③ Autobase-metallic/pearl 15 µm BT Clearcoat 301 or 40 µm BT LV Clearcoat 701 40 µm ④ Autowave-metallic/pearl 20 µm BT Clearcoat 301 or 40 µm BT LV Clearcoat 701 40 µm
<p>Layer thicknesses</p>	<p>The stated layer thicknesses are minimum layer thicknesses. For detailed processing data see the technical information pages of the mentioned products.</p>	<ul style="list-style-type: none"> ① Total minimum layer thickness 150 µm ② Total minimum layer thickness 150 µm ③ Total minimum layer thickness 165 µm ④ Total minimum layer thickness 170 µm

2.5 Filling sand paper system for damaged underground

Underground: polyester		
<p>Pre-processing</p>   	<p>Clean the underground with:</p> <p>Degrease the underground:</p> <p>Rougher the underground:</p> <p>Make the underground dust-free and degrease once again:</p>	<ul style="list-style-type: none"> ☞ Warm water and soap ☞ BT LV 775 Antistatic Silicon Remover ☞ 3M Scotch Brite ultra fine or ☞ 3M Scotch Brite very fine or ☞ 3M Scotch Brite Paars ☞ BT LV 775 Antistatic Silicon Remover
<p>Ground treatment</p>     	<p>It is advisable to coat the surface, which is needed to be filled, before filling with:</p> <p>After drying fill with:</p> <p>Sandpaper the filler tightly after hardening through:</p> <p>Sandpaper the filler afterwards whereby the reducing edge is sand papered well.</p> <p>Sandpaper the repair spots and surroundings.</p> <p>Make the underground dust-free and degrease:</p> <p>Coat the total underground:</p> <p>For the correct product combination and mixing ratio see the technical information page.</p> <p>Sandpaper this filler after curing:</p> <p>Make the underground dust-free and degrease:</p>	<ul style="list-style-type: none"> ☞ BT Filler 321 ☞ Polykit IV ☞ P80 ☞ P180 ☞ P280 ☞ BT LV 775 Antistatic Silicon Remover ☞ Polysurfacer 100 µm ☞ P400 -10 µm ☞ Autowave Degreaser
<p>Finishing</p> 	<p>Coat with:</p>	<ul style="list-style-type: none"> ① Autocoat BT 40 µm ② Autocaot BT LV 40 µm ③ Autobase-metallic/pearl 15 µm BT Clearcoat 301 or 40 µm BT LV Clearcoat 701 40 µm ④ Autowave-metallic/pearl 20 µm BT Clearcoat 301 or 40 µm BT LV Clearcoat 701 40 µm

Layer thicknesses	The stated layer thicknesses are minimum layer thicknesses. For detailed processing data see the technical information pages of the mentioned products.	① Total minimum layer thickness 90 µm ② Total minimum layer thickness 90 µm ③ Total minimum layer thickness 105 µm ④ Total minimum layer thickness 110 µm
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3. General information

Processing circumstances : The in this advice mentioned evaporation times and drying times are based on a temperature of 20°C. Do not process 2 component materials at a temperature lower than 18°C and/or relative moistness higher than 75%.

Sandpaper : The in this advice mentioned coarseness's are based on 3M dry sandpaper, type 212. If you wish to use another brand or type of sandpaper, please consult the schedule beneath or contact your representative.

<u>3M 212</u>	<u>3M 245</u>	<u>3M 255 P</u>	<u>Dynamic</u>	<u>Eagle</u>
P80	P80	P120	P80	P80
P180	-	P220	P180	P180
P280	-	P320	P280	P280
P360	-	P400	P360	P360
P400	-	P500	P500	P400

Apply and remove sticky foil : Apply
 On just coated company vehicles advertising expressions are frequently applied with sticky foil. Generally a foil is used which is removed after some time. This is called "semi-permanent" sticky foil.
 Before sticky foil is applied the coating system must be completely cured. According to the technical information page 7 Sikkens 2 component coats are sufficiently cured at a temperature of 20°C or higher.

Remove
 The sticky foil must be removed carefully to prevent the coated layer getting damaged. Please notice the following:

- ☞ Consult the instructions of the manufacturer or supplier of the foil.
- ☞ Heat the foil using a hair dryer.
- ☞ Please see to it that when knives are used no incisions will arise in the coat layer.
- ☞ Tear loose the foil under an angle of 180°.

Cleaning coat layers : Company cars are washed regularly. This is done mostly at a car-wash. To prevent the coated layer being affected by washing frequently, you must avoid aggressive cleaning agents. This is especially important by washing cars which recently have been coated. A fresh coated layer may not be exposed to cleaning agents until completely cured.
 The in this advice mentioned 2 component paints are cured after 7 days at a temperature of 20°C or higher.
 Ask advice at the supplier of the cleaning agent. The mixture of water and cleaning agent must have a pH-value between 3-11. The pH-value indicates how sour or alkaline a substance is (indication: pH 0-2 = strongly sour, pH 12-14 = strongly alkaline). Wash down the coated layer carefully with clean water after cleaning, so no remainders of cleaning agents will be left behind.

4. Product information

Product	Hardener	Thinner	Mixing ratio
Autocoat BT LV 775 Antistatic Silicon Remover	-	-	-
Autowave Degreaser	-	-	-
Polykit IV	Hardener for Sikkens polyester filler	-	100 : 2
Polysurfacer	Polysurfacer Hardener	-	100 : 5
Autocoat BT LV Filler 721	BT LV Hardener 741	BT LV Thinner 764	100 : 20 : 60
Autocoat BT Filler 121 (sandfiller)	BT Hardener 141	BT Thinner 362	3 : 1 : 1
Autocoat BT Filler 121 (wet-in-wet filler)	BT Hardener 142	BT Thinner 362	100 : 50 : 30
Autocoat BT Sealer 123	BT Hardener 142	BT Thinner 362	100 : 50 : 30
Autocoat BT Filler 321	BT Hardener 341	BT Thinner 362	100 : 50 : 30
Autocoat BT Washprimer 521	BT Hardener 541	-	100 : 100
Autocoat BT	BT Hardener 342	BT Thinner 361	100 : 25 : 35-50
Autocoat BT LV	BT LV Hardener 741	BT LV Thinner 764	3 : 1 : 1
Autowave	-	Autowave Activator	100 : 10-20
Autobase (+5% BT Hardener 342)	-	BT Thinner 362	100 : 100
Autocoat BT Clearcoat 301	BT Hardener 342	BT Thinner 361	100 : 25 : 35
Autocoat BT LV Clearcoat 701	BT LV Hardener 741	BT LV Thinner 764	3 : 1 : 1

Please note

Our information is based on Pecocars internal laboratory tests and practical experience. Unfortunately, these do not cover all the parameters that have to be taken into account in the relevant application and therefore they are not binding. The information provided is neither a guarantee in the legal sense nor a guarantee of properties. No legal claims can be derived from this information.