

SANDY™ Handling Instructions

(Please read and follow all directions carefully)

For Professional Use Only

This product is a Hi-build polyester primer designed to eliminate the multiple steps required by 2K primers to achieve a paintable surface one step finishing material from bare metal, body filler, wood, aluminum, or fiberglass to a surface ready to accept any type of paint without concern about penetration of solvents or moisture.

Since 1975, this product is, by design, a different product from those currently marketed. The primary functions of this product are:

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| 1) 86% Solids | 5) Wet sandable and waterproof |
| 2) Non-shrinking | 6) Self-etching |
| 3) Easy sanding | 7) 2.01 V.O.C. |
| 4) Excellent hold-put properties | 8) Isocyanate – Free |

Unlike lacquer or epoxy type primers, sealers, and surfacers, SANDY cured has very good resistance to heat, solvent attack, water, and salt. Unlike 2K primer, SANDY is a 100% pure high build polyester primer that will cure in 45 minutes at 78 degrees. Major paint companies require two hours of cure time for their priming systems. Unlike 2K primers, it is recommended to be sprayed over bare metal. It has better adhesion and more strength because of its self-etching characteristics. This product provides an excellent barrier between cured body filler and top coats. Clear Coat/color Coat paint systems are protected from the body filler when using this product. This product is **guaranteed** to prevent this problem when applied properly.

PREPARATION BEFORE YOU SPRAY

CAUTION should be taken when spraying Clausen's polyester primer over unknown surfaces as lacquers and synthetic enamels may cause lifting or wrinkling. Please spray a small test area before attempting larger areas. **Surface must be clean and dry.** (Aluminum should be cleaned with phosphoric acid to deoxidize the surfaces.) Clean surface with ivory dishwashing detergent and clean water. Wipe surface with clean lint free wipes and blow off with compressed air. When doing all over applications or spot repairing old finishes, sand with 80-100 grit paper, then sand 2-4 inches into blend area with 240-320 grit paper. This product does not require pre-preparation products such as metal cleaner or conditioner. **Do not use it.** If you use metal preparation products, you must completely remove that product before applying this product. The presence of metal preparation products at any level could inhibit this product bonding to the surface. Apply over clean, dry, bare metal, body filler, plastic, wood, aluminum or fiberglass. **Do not wipe metal or surface with solvents.**

TO PREPARE THIS PRODUCT FOR SPRAYING

Loosen solids with a metal paint paddle, then mix or shake contents of can thoroughly just before use. (Some settling of the filler material occurs as a natural part of this type of material. By placing material on a paint shaker for 2-5 minutes per quart and 5-10 minutes per gallon, the filler portion will adequately re-disperse. Pour the desired amount of SANDY into the spray cup of a primer-type spray gun. Best applied with a HVLP 2.0 or 2.15 head spray gun with 3/8 couplers and hoses. The gun should deliver a full wet coat, using 35-40 PSI of air, at 6-8 inches from the work surface. During the hot summer months, when temperature exceeds 80° a polyurethane reducer should be applied to this product, up to 3% to 5% reduction to slow the drying process.

MIXING OF HARDENER

Only **CLAUSEN'S** primer hardener must be used with this product. Mix this product in a cup with a proportionate amount of primer hardener supplied. (100 grams of SANDY to 1 gram of Primer Hardener) Gallon size hardener bottle is graduated. Do not mix more than you are going to spray. Stir until mixed completely. It is important to use the proper amount of hardener. Do not attempt to over-catalyze or under-catalyze to offset temperature variances. The Isocyanate-free liquid hardener supplied with this product is a special formulation different from other liquid hardeners.

TEMPERATURE OF APPLICATION

To compensate for temperatures lower than 70 degrees heat lamps or heated paint booths are recommended. DO NOT BAKE AT TEMPERATURES OVER 90 DEGREES, which will cause the product to skin over and curing will stop. If temperature exceeds 90 degrees a retardant of 3% butyl acetate or a 105-degree polyurethane reducer can be added.

NOTE: All of the components, the air, the primer, and the priming surfaces must be above 70 degrees. SANDY Polyester Primer will not cure at temperatures less than 70 degrees.

APPLICATION WHEN YOU SPRAY – SANDY CAN BE SPRAYED, BRUSHED, ROLLED OR Poured ON

Avoid spraying coatings when humidity is high. Optimal humidity is 30% to 50%. First spray a medium wet coat and allow to totally cure. Then spray additional coats as needed, allowing each coat to flash-off for 2-3 minutes between coats to prevent runs and snags. Shake spray gun cup before each application. Avoid spraying excessive amounts. Sandy can be successfully built to a thickness of 8 mils. Best Applied with an AccuSpray 10G gun with a 2.0 fluid nozzle. The AccuSpray 10G gun atomizes with 3.5 PSI at the fluid nozzle eliminating 70% of the over spray.

One medium wet coat will produce 5 mils of build. One medium wet coat equals to 3 slow passes of your spray gun. WET COAT. The 5-mil build will cover 36 grit sanding marks in metal, aluminum, fiberglass, body filler and wood. If orange peeling or dry spraying occurs, your spray gun is not atomizing the 86% solid material of SANDY. Reduction of this product with acetone or a polyurethane reducer will help material flow. If reductions are needed, 3% is minimum and 5% is maximum. For temperatures 70 to 80 degrees use acetone, 80 to 100 degrees use a polyurethane reducer. Time to recoat is unlimited. **SANDY DOES NOT HAVE A WINDOW.**

Do Not overbuild. Remember 5 mils is one medium wet coat, 5 to 8 mils of build is recommended for a paintable surface.

BEFORE YOU SAND

Curing time (surface, material and air temperature) is between 30 to 60 minutes at 70° (21° C) and fewer than 20 minutes at 90° F (32° C). SANDY can be wet or dry sanded. Total thickness could be 10 to 12 mils if needed. Average mil thickness is usually 5 mils. **Sanding is not required to recoat.**

WHEN YOU SAND

Finish sand with 400 to 600 grit papers for desired smoothness for proper adhesion of paint.

AFTER YOU SAND

When the surface has been prepared with 400 to 600 grit paper, any type of automotive or marine topcoat can be applied. There is no further requirement for use of primers surfacers or sealers. As in most applications, it is recommended that the finish coat be applied as soon as possible after final sanding. Contamination in the form of dust, grease or foreign materials may have the opportunity to come in contact with the prepared surface if the topcoat is not applied within a reasonable amount of time. When selecting a one step polyester Primer-Surfacer-Sealer to cut cost in both materials and labor, SANDY becomes the choice of quality-oriented shops.

CLEAN UP OF EQUIPMENT

Wash spray gun and cup immediately after use with acetone or lacquer thinner. If gun becomes clogged due to product gelatin, immerse in acetone or lacquer thinner, let soak and brush clean. Store SANDY primer at 70 – 90 degrees and primer hardener in your shop refrigerator.

Further information or additional suggested uses for THE CLAUSEN COMPANY'S products can be obtained by calling our "Hot Line" 800-223-0893. All calls are answered the next business day. THE **CLAUSEN COMPANY** values the opinion of the users of our products. Any comments on new or unusual uses for our products should be directed to:

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