

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.

Over twenty years in development and testing by THE CLAUSEN COMPANY, 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) 2.01 V.O.C. |
| 3) Easy sanding | 7) Faster top coat time. |
| 4) Excellent hold-put properties | 8) Isocyanate – Free |

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.

PREPARATION BEFORE YOU SPRAY

This product contains 86% solids, therefore it will cover 80 grit sand scratches easily. All surfaces must be sanded and cleaned. Do not use solvents to prepare the surfaces. This product may be used over etching primers, epoxy primers, old finishes and body fillers. SANDY should not be sprayed on bare metal.

TO PREPARE THIS PRODUCT FOR SPRAYING

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 materials. 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 any of these products into the spray cup of a primer-type spray gun. Best applied with a HVLP 1.7 or 2.0 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 polyester primer reducer should be applied to this product, up 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. 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 urethane or polyester reducer can be added.

IMPORTANT!

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

APPLICATION WHEN YOU SPRAY

First spray a medium wet coat and allow to dry to touch. 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.

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 polyester reducer will help material flow. If reductions are needed, 5% is maximum. For temperatures 70 to 80 degrees use acetone, 80 to 100 degrees use a polyester or urethane reducer. Time to recoat is unlimited.

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). These products 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, any of these products become 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.

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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