

SURFACE PREPARATION FOR MASCOAT

As with any paint or coating application, surface preparation can make the difference between a successful application and a failed application. This is no different when it comes to Mascoat. All surfaces should be clean and free of any type of debris, whether the surface is primed, painted or bare metal. The guidelines below should help to ensure proper surface preparation.

Primed or Painted Substrates

If a surface is already primed or pre-painted, it is essential that the surface is clean before application of Mascoat. Cleaning can be accomplished in many different ways. The following methods can be employed depending on the condition of the surface:

- **Recently primed or painted** — typically a light pressure wash or air sweep can be used if there are no other cleaning issues. Be careful of amine blush when using epoxy-type primers. If the surface has extensive blush, a light mechanical etching (sanding) should be used to remove it, followed by a wash. It is important to make sure the primer or paint is tolerant of at least 30% more heat than before as with the insulation coating applied, temperature will elevate. If the paint or primer is at the limit of temperature already, then there is risk of primer adhesion loss from the surface.
- **Older primed or painted surfaces** — it is good practice to clean these types of surfaces by pressure washing or wiping down with solvents, such as acetone or denatured alcohol. When using solvent cleaners, avoid cleaners like paint thinner or methyl ethyl ketone (MEK), as they can re-blush the surface or soften the primer/paint. Again, note the temperature limitation of the current primed surface before applying Mascoat.
- **Flaking (loose) paint or primer** — these types of surfaces will need to be sanded or blasted to achieve a suitable profile for adhesion. If the substrate is ferrous, this can be accomplished by spot fixes with primers. If the substrate is aluminum or another non-ferrous substrate, bare mechanical etching (sanding) would be the best choice.

For surfaces such as carbon steel (ferrous surfaces)

- **Bare carbon surfaces** — since Mascoat's coatings are water-based, it is necessary to use a surface primer prior to application. This is due to the

possibility of "flash rusting", which can occur during the application of any water-based coating. A surface primer provides a barrier system so that flash rusting will not occur.

- **Recommended primers** — there is no set primer that is recommended by Mascoat. Use a primer specified by the temperatures it will be exposed to during use. The manufacturer determines surface preparation for these primers. It is important to follow the priming instructions as per the manufacturer's recommendation.
- **Cure times of primers** — proper cure time between the application of the primer and the Mascoat product should also be practiced. The primer's manufacturer will establish the cure time. Primer should reach full cure prior to application of the Mascoat product. Please be aware of the cure rate in relation to ambient and surface temperatures, as this may prolong or expedite cure times. Application of Mascoat prior to the primer's full cure may result in adhesion failure due to entrapped solvents.

Non-Ferrous Substrates

Aluminum, stainless and galvanized surfaces need only to be cleaned prior to the application of Mascoat.

- **For cleaning new metal** — typically a light vinegar wash is sufficient. Make sure to rotate/replace the rags frequently while cleaning and implement forced ventilation to help during the dry time. Acetone or denatured alcohol can also be used in areas laden with grease or oil. Clean thoroughly to ensure that no residue exists, as residue may result in failure of the coating to properly adhere to the surface. Make sure that all surfaces are fully dry prior to the application of the Mascoat product.
- **For older metals** — it is important to make sure that scale or deposits are removed from the surface. This can be accomplished by either mechanical means or water blast. Additional cleaning may be needed with the same procedure for new metals.

As with all surface preparations, it is recommended that the cleaning procedure take place as close to the application of our coatings as possible. Prolonged periods may require re-cleaning prior to the application of Mascoat.