TECH TALK

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Post Paint Compatibility of Dibond®

Overview

On many projects that involve Dibond® material, a small quantity of "custom color" panels is often required. Because of the limited quantity, it is often not practical to obtain the "custom color" from the factory and post painting is necessary. Several of the paint manufacturers have tested their products for use with Dibond® material. Following is a list of the paint suppliers, and the materials needed for post painting.

Painting should be done by qualified persons with experience in this type of application.

Preparation

The first step in the post painting process is an assessment of the substrate concerning the cleaning, pretreating and priming required prior to application of the finish. There are no standard procedures for all possible situations due to the variety and condition of the surface to be painted. Before painting, testing should be done on a small area to determine that the preparation, application, and adhesion of the finish are satisfactory. The coating adhesion between the post paint finish and the original coating must be carefully evaluated using common coating adhesion testing procedures. Also, color and gloss matching needs to be evaluated to provide an acceptable final appearance. If testing indicates poor adhesion, do not proceed. Contact the coating manufacturer for additional recommendations.

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Metallic colors are difficult to repair and special procedures must be followed. Spray applications will not reproduce identical metal flake alignment obtained in the factory-applied finish. This is due to the application differences between coil-coated and post painted finishes.

Application

Before painting, always check the coating manufacturer's application guidelines and follow the specific instructions shown on the product data sheet and application instructions. For specific recommendations or questions, contact your coating representative. The surface to be painted must be clean, dry and free of dust, dirt, oil, grease and foreign contaminants. Clean the surface according to the paint manufacturer application guidelines.

If recommended by the paint manufacturer, the curing of some paints may be accelerated through a moderate increase in temperature. For composite material, the temperature must never exceed 140°F. Where sanding is necessary, do not sand through coating to metal substrate.

Evaluated Post Paint Finishes

Surface Preparation	Primer	Top Coat
Akzo Nobel, 800-233-3301 or 770-662-8464		
Degrease with Grip-Gard® M-600 Wax&Grease Remover. Sand surface with 320-360 grit paper dry		Grip-Gard®
Degrease with Grip-Gard® M-600 Wax&Grease Remover.		Grip-Gard® HS Grip-Gard® Plus Meta-Flex®
Carbit Paint Co., 312-280-2300		
Clean surfaces with a 50/50 blend of Isopropyl Alcohol and water		Carbithane® 11 Series Carbithane® 12 Series

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Surface Preparation	Primer	Top Coat
Dupont Industrial Coatings, 800-338-7668		
Scuff sand with red Scotch Brite pad, clean with H-69 Isopropyl Alcohol		Imron® 333 Line Polyurethane Enamel, Imron® 1.2 Waterborne Copolymer WG
Scuff sand with red Scotch Brite pad, clean with H-69 Isopropyl Alcohol	Imron® 1.5 Waterborne Copolymer Primer WF	Imron® 1.2 Waterborne Copolymer WG
Scuff sand with red Scotch Brite pad, clean with H-69 Isopropyl Alcohol	Corlar® VHS 90P Epoxy Mastic Primer	Imron® 333 Line Polyurethane Enamel
Matthews Paint Co., 800-323-6593 or 262-947-0700		
wipe down with 45330SP Speed Prep Cleaner, abrade with 320/400 grit or red Scotch Brite pad and wipe down with 45330SP Speed Prep Cleaner		MAP® VOC MAP® Satin VOC MAP®
One Shot, LLC, 219-949-1684		
Lightly scuff sand with gray Scotch Brite pad and wipe down with Isopropyl Alcohol	5005 Acrylic Bonding Primer White	1 SHOT® Lettering Enamels, CHROMATIC Bulletin Colors
PPG Industries, 800-441-9695		
Lightly scuff sand and remove all forms of contamination, clean with solvent		PPG Duracryl® Acrylic Lacquer

Surface Preparation	Primer	Top Coat
T.J. Ronan Paint Corp., 800-247-6626 or 718-292-1100		
wipe with isopropyl alcohol (91%)	Metro Vinyl Primer (water borne), Universal Primer, Sticktite White Primer	Bulletin Color, Lettering Enamel, Aquacote® (water borne)
Sherwin-Williams, 700-331-7979		
	DTM Bonding Primer	DTM Acrylic Coating METALATEX semi-gloss coating
Cleaning per SSPC-SP1 (Solvent cleaning)		Bond-Plex® water based acrylic coating
Spraylat Corp., 800-336-1936 or 914-699-3035		
Must be sanded or primed	Series 20/30 Wash Primer	Series 20 Acrylic Lacquer Series 30 Polyurethane
Scuff sand using Scotch Brite pad		Polycryl

This Tech Talk has been developed to transmit information and assist end-users to work with Dibond® material in the most efficient and effective manner. The data contained in this Tech Talk is based on information that is, in our opinion, reliable. However, since skill, judgment, and quality of equipment and materials is involved and is beyond the control of Alcan Composites USA, Inc., the information provided is without guarantee. We recommend that prospective users determine the suitability of the material and suggestions before adopting them on a commercial scale. **Alcan Composites USA, Inc. does not make any warranties, express or implied including merchantability and fitness for purpose, with respect to any said suggestions and product data.** In no event shall Alcan Composites USA, Inc. have any liability in any way related to or arising out of said suggestions and product data for direct, special, consequential or any other damages of any kind regardless whether such liability is based on breach of contract, negligence or other tort, or breach of any warranty, express or implied.

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