

SANDY™ Handling Instructions
(Please read and follow all directions carefully)
For Professional Use Only

This product is a 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.

Over thirty years in development and testing by THE CLAUSEN COMPANY, this product is by design, a different product from those currently marketed. The primary characteristics of this product are:

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| 1) 100% Solids | 5) Wet sandable and waterproof |
| 2) Non-shrinking | 6) Self-etching |
| 3) Easy sanding | 7) 2.01 V.O.C. |
| 4) Excellent hold-out properties | 8) Isocyanate - Free |

Unlike lacquer or epoxy type primers, sealers, and surfacers, this cured product has very good resistance to heat, solvent attack, water, and salt. It has better adhesion and more strength because of its self-etching characteristics. The zinc phosphate additive and solvents in this product react during curing and become part of the total solid binder. This replaces the "corrosion protection system" and improves strength and sealing properties. 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

Surface must be clean and dry. Clean surface with ivory dishwashing detergent and clean water. Wipe surface with clean lint free wipes and blow off with compressed air. When performing 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 our product. The presence of metal preparation products at any level could inhibit this product from bonding to the surface. Apply over clean, dry, bare metal, body filler, plastic, wood, aluminum, fiberglass, carbon fiber, stainless steel, zinc, copper, brass, galvanize and chrome. **Do not clean 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 the product into the spray cup of a primer-type spray gun. Best applied with a HVLP 2.0 or 2.50 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 months, when temperature exceed 80° a polyester reducer should be added to this product, 1 ounce per quart reduction is needed 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. (10 cc per quart). Do not mix a gallon at one time. The 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° heat lamps or heated paint booths are recommended. **DO NOT BAKE THIS PRODUCT.** It will cause the product to skin over and curing will stop. We offer four temperature range reducers 75, 85, 95, and 105 degree polyester reducers 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.

SANDY can be sprayed, brushed, rolled, or poured on

APPLICATION WHEN YOU SPRAY

Avoid spraying coatings when humidity is high. Optimal humidity is 30% to 50%. First spray a medium wet coat and allow to totally cure before applying any more product. Then spray additional coats as needed, allowing each coat to flash-off for 2-3 minutes between coats to prevent runs and sags. Shake spray gun cup before each application. Avoid spraying excessive amounts. SANDY can be successfully built to a thickness of 8 mils. 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 100% solid material of Clausen's primers. If reductions are needed, a 75, 85, 95 and 105 degree polyester reducers are available. **Time to recoat is unlimited. This product 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). This product 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, this product 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 jelling, immerse in acetone or lacquer thinner, let soak and brush clean. Store 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 732-738-1165. All calls are answered by 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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