Finish Touch-Up and Repair

⚠ CAUTION

In all cases, established safe work practices shall be followed and all required personal protective equipment (PPE) utilized as determined by the end user. If no procedures have been established, the recommendations from the paint manufacturer should be followed, Ensure proper ventilation during all surface preparation and painting activities.

⚠ NOTICE

In the cleaning and preparation procedure that follows, if the damage has not penetrated to bare metal, DO NOT sand the finish to bare metal.

1) Remove all loose paint, rust and debris, using heavy grit sandpaper or, if the surface is badly damaged, with a wire brush, or equivalent.

If using power tools, take care not to damage the base metal.

2) Surface preparation – this is the most critical step. The best paint in the world will not adhere correctly to a surface that has not been properly cleaned.

a. Preferred Method ("Hi-Lite" 4110 Paint Prep cleaner, or equivalent **residue-free** cleaner).
   - Follow manufacturer's instructions on the container.
   - This type of product is designed to be a "wipe-on, wipe-off" cleaning system.
   - Rinsing is not required or recommended with this paint prep cleaner.

b. Alternate Method (using generic water-based cleaner)
   - Clean surface with a mild water-based detergent as needed.
   - Rinse with clean water to remove all detergent and other residue.
   - Dry the surface completely before proceeding.

3) Sand the area to be painted thoroughly with 100 - 120 grit sandpaper, ensuring that all visible rust and corrosion are removed.

- The sanding should be "feathered" to blend into the surrounding paint surface.
- Remove all sanding dust and residue with a dry cloth.

4) Clean the damaged area as in Step 2 on "Surface Preparation" to remove any remaining dust and debris from the surface.

5) Apply primer only to exposed bare metal portions in the damaged surface area in accordance with the instructions provided by the primer-finish manufacturer.

a. Preferred Primer – Sherwin-Williams Chem Bond HS Universal Metal Primer (or approved alternate from below)
b. Alternate Primers
   - For small areas, Dupli-Color CP199 - Adhesion Promotor Clear Primer, or equivalent, may be used.
   - Krylon "Rust Tough" primers are other good spray finish alternatives.
   - For larger areas, where brush or (preferably) roller application is warranted, the use of a high quality red-oxide primer, such as Krylon R00691 Red Oxide Primer, is the recommended alternative.

6) Allow the primer to fully dry and cure as recommended by the primer finish manufacturer before applying the top coat.

7) Apply the top coat to the previously primed surface in accordance with the instructions provided by the top-coat finish paint manufacturer.

a. Preferred top coat – Sherwin-Williams Industrial Urethane Alkyd Enamel, Bell Green (or approved alternative from below).
b. The preferred alternative for areas with more stringent VOC restrictions is Sherwin-Williams Sher-Cryl HPA (High Performance Acrylic).
c. In the above cases, the use of a roller, as opposed to a brush, is preferred.
d. Alternative top coats for small areas - Sherwin Williams Aerosol, - 595-0514 - Bell Green, or equivalent, may be used.
e. Generic acrylic enamel or enamel aerosol, "Bell Green", may be used if none of the preferred choices listed above are available, but this may not be as close in color as the preferred products.