

Safety Steps and Procedures To Follow Prior To Applying Sur-Prep® 5677:

Always refer to the **safety data sheet (SDS)**, **technical data sheet (TDS)**, and **label** prior to applying the **Sur-Prep® 5677** if you have any questions about the product.

Always wear gloves, protective clothing, and protective eyewear to prevent **Sur-Prep® 5677** from contacting the skin and eyes.

Make sure there is proper airflow in the area where the **Sur-Prep® 5677** will be applied and wear a proper mask to prevent the inhalation of fumes from **Sur-Prep® 5677**.

Make sure there are no sparks, open flames, or other combustion sources around **Sur-Prep® 5677**.

Always have adequate lighting to see where **Sur-Prep® 5677** will be applied and to inspect areas for contamination and rework prior to applying **Sur-Prep® 5677**.

Sur-Prep® 5677 Features and Benefits:

Sur-Prep® 5677 a fast evaporating solvent blend degreaser and contact cleaner that works on oil and oil-bonded contaminants, penetrates to remove soils and greases, dries quickly and completely, contains no chlorinated solvents, contains a spray-any-way spray valve, and leaves no residue behind.

Sur-Prep® 5677 helps coatings and sealants adhere to aircraft substrates and solvates a broad range of contaminants from substrate surface.

Procedures For Applying The Sur-Prep® 5677 and Areas Where It Can Be Applied:

Sur-Prep® 5677 should be used on critical surface areas, electrical contacts, non-activated circuits, and aircraft substrates as well as preparing critical surface areas prior to painting or bonding.

Sur-Prep® 5677 can also be used for the contact cleaning on non-activated circuits as well as general degreasing.

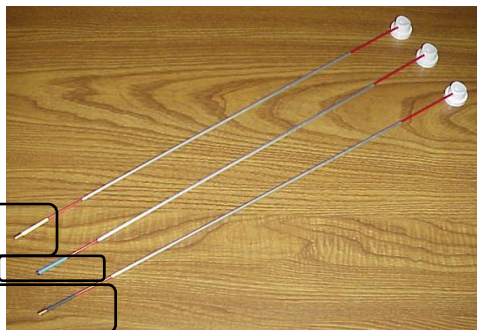
Apply **Sur-Prep® 5677** to the surface to be cleaned.

Spray Applying Sur-Prep® 5677:

The **Sur-Prep® 5677** aerosol can be used with the **Formit®** extension wands that are for use with all **Zip-Chem®** aerosols to reach difficult to access areas including spray equipment and the **Zip-Chem® Aerosol Trigger Sprayer** that is designed for use with any **Zip-Chem®** aerosol can.

Please reach out to a **Zip-Chem®** application expert for tips on how to properly apply **Sur-Prep® 5677**

- *Formit® 360° Spray (White Tube) Wand
- *Formit® Fan Spray Spray (Blue Tube) Wand
- *Formit® 180° Spray (Black Tube) Wands



Spray Applying Sur-Prep® 5677 (Continued From Page 1):

Formit® 360° Spray Demonstration Video



Formit® Fan Spray Demonstration Video



Formit® 180° Spray Demonstration Video



Zip-Chem® Aerosol Trigger Sprayer



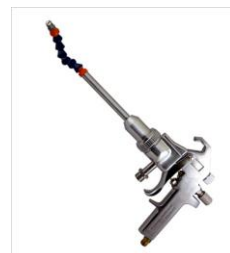
1.) HVLP Spray Gun Setup

- A.) Determine the tip size for the gun. The recommended tip size for the gun should be **1.0 mm to 1.5 mm**.
- B.) Set the **air pressure**. This is very important because **Sur-Prep® 5677** is applied **thin** so **too much pressure** will result in a **dry spray** and texture of **Sur-Prep® 5677** while **too little pressure** will result in a **poor atomization** and **orange peeling** of **Sur-Prep® 5677**.
- C.) If you see texture in the spray of **Sur-Prep® 5677**, then increase the **air pressure** of your **HVLP gun**. If you see an **overspray cloud** of **Sur-Prep® 5677**, then decrease the **air pressure** slightly. The proper spray pattern for **Sur-Prep® 5677** should be a **slightly wet pass** with **no flooding or sagging** because **thinly applied products** like **Sur-Prep® 5677** can run very fast.
- D.) One pattern that should be used when using the **HVLP gun** to apply **Sur-Prep® 5677** is the **fan pattern** because it uses a **full wide fan spray** which provides better consistency and leveling when applying **Sur-Prep® 5677** with the **HVLP spray guns**.
- E.) The **air pressure** when the trigger is pulled for the gun should be **20–30 PSI** even though most guns specify **10 PSI** at the **air cap**.
- F.) Always set the pressure with the **trigger fully pulled** because the **pressure drops under flow**.
- G.) Close off the **air** and **fluid adjustment knobs**.
- H.) Slowly open the **air adjustment knob** with the **trigger** pulled.
- I.) Open the **fluid adjustment knob** slowly until you see a **fine mist** from the **air cap**.
- J.) Continue to fine tune the settings until the desired spray pattern is achieved.

HVLP Spray Gun



Airverter HVLP Spray Gun



Spray Applying Sur-Prep® 5677 (Continued From Page 2):

2.) Air Assisted Spray Gun Setup

- A.) Determine the tip size for the gun. The recommended tip size for the gun should be **1.0 mm to 1.5 mm**.
- B.) For **pressure settings**, use the **lowest pressure** possible so that **Sur-Prep® 5677** can be spray applied as a **clean fan** with the width of the spray being shaped like a **fan**.
- C.) Slowly increase the **pressure** to the gun until the **fan spray pattern** of **Sur-Prep® 5677** is fully developed and even and there are no **fingers** or **tails** on the edges of the spray equipment. If you hear a **harsh hissing noise** or see **fogging** in the spraying of the **Sur-Prep® 5677**, then the **pressure** of the **air assisted spray gun** is **too high**. None of these observations should occur because **thin materials** like **Sur-Prep® 5677** atomize very easily.
- D.) Set the **pump ratio** of the equipment to a range of **60:1 to 30:1**.
- E.) Setup the following parts for the **airless spray equipment** below.
 - *Displacement Pump With A Positive Piston Type
 - *Stainless Steel Filter With A High Pressure With 200-300 mesh element
- F.) Maintain your distance of the gun from the surface as the distances between **air assisted spray guns** and other spray methods can vary. A good distance to follow for **air assisted spray guns** is about **12" or more**. If you spray apply **Sur-Prep® 5677** at a distance closer than **12"**, then there will be a heavy buildup of **Sur-Prep® 5677**, tiger stripping of material from the surface where the **Sur-Prep® 5677** was applied, and a variation in the gloss of the **Sur-Prep® 5677**.
- G.) Consider the passing speed of **Sur-Prep® 5677** because the output of **Sur-Prep® 5677** from **air assisted spray guns** can vary between other spray methods. Therefore, you may need to move faster or slower than other spray methods, such as **HVLP guns**.
- H.) The **Sur-Prep® 5677** should be spray applied as a **smooth continual pass** with a **50% overlap**.



3.) Airless Spray Setup

- A.) Determine the tip size for the gun. The recommended tip size for the gun should be **1.0 mm to 1.5 mm**.
- B.) For **pressure settings**, use the **lowest pressure** possible so that **Sur-Prep® 5677** can be spray applied as a **clean fan** with the width of the spray being shaped like a **fan**. The setup of **airless spray equipment** varies based on the size and type of gun that is being used but a good starting point for the **pressure** of the **airless spray gun** should be around **900-1200 PSI**.
- C.) Slowly increase the **pressure** to the gun until the **fan spray** pattern of **Sur-Prep® 5677** is fully developed and even and there are no **fingers** or **tails** on the edges of the spray equipment. If you hear a **harsh hissing noise** or see **fogging** in the spraying of the **Sur-Prep® 5677**, then the **pressure** of the **airless spray gun** is **too high**. None of these observations should occur because thin materials like **Sur-Prep® 5677** atomize very easily.
- D.) Set the **pump ratio** of the equipment to a range of **60:1 to 30:1**.

Airless Spray Equipment



Spray Applying Sur-Prep® 5677 (Continued From Page 3):

Airless Spray Setup (Continued From Page 3)

E.) Setup the following parts for the **airless spray equipment** below.

***Displacement Pump With A Positive Piston Type**

***Stainless Steel Filter With A High Pressure With 200-300 mesh element**

F.) Maintain your distance of the gun from the surface as the distances between **airless spray guns** and other spray methods can vary. A good distance to follow for **airless spray guns** is about **12" or more**. If you spray apply **Sur-Prep® 5677** at a distance closer than **12"**, then there will be a heavy buildup of **Sur-Prep® 5677**, tiger stripping of material from the surface where the **Sur-Prep® 5677** was applied, and a variation in the gloss of the **Sur-Prep® 5677**.

G.) Consider the passing speed of **Sur-Prep® 5677** because the output of **Sur-Prep® 5677** from **airless spray guns** can vary between other spray methods. Therefore, you may need to move faster or slower than other spray methods, such as **HVLP guns**.

H.) The **Sur-Prep® 5677** should be spray applied as a **smooth continual pass** with a **50% overlap**.

4.) Sur-Prep® 5677 5 Gallon (18.9 Liter) Cart Sprayer Setup

A.) Determine the tip size for the gun. The recommended tip size for the gun should be **1.0 mm to 1.5 mm**.

B.) For **pressure settings**, use the **lowest pressure** possible so that **Sur-Prep® 5677** can be spray applied as a **clean fan** with the width of the spray being shaped like a **fan**.

C.) Slowly increase the **pressure** to the gun until the **fan spray** pattern of **Sur-Prep® 5677** is fully developed and even and there are no **fingers** or **tails** on the edges of the spray equipment. If you hear a **harsh hissing noise** or see **fogging** in the spraying of the **Sur-Prep® 5677**, then the **pressure** of the **5 Gallon (18.9 Liter) Cart Sprayer** is **too high**. None of these observations should occur because thin materials like **Sur-Prep® 5677** atomize very easily.

D.) Set the **pump ratio** of the equipment to a range of **60:1 to 30:1**.

E.) Setup the following parts for the **5 Gallon (18.9 Liter) Cart Sprayer** below.

***Displacement Pump With A Positive Piston Type**

***Stainless Steel Filter With A High Pressure With 200-300 mesh element**

F.) Maintain your distance of the gun from the surface as the distances between **5 Gallon (18.9 Liter) Cart Sprayer** and other spray methods can vary. A good distance to follow for **5 Gallon (18.9 Liter) Cart Sprayers** is about **12" or more**. If you spray apply **Sur-Prep® 5677** at a distance closer than **12"**, then there will be a heavy buildup of **Sur-Prep® 5677**, tiger stripping of material from the surface where the **Sur-Prep® 5677** was applied, and a variation in the output of **Sur-Prep® 5677**.

G.) Consider the passing speed of **Sur-Prep® 5677** because the output of **Sur-Prep® 5677** from **5 Gallon (18.9 Liter) Cart Sprayers** can vary between other spray methods. Therefore, you may need to move faster or slower than other spray methods, such as **HVLP guns**.

H.) The **Sur-Prep® 5677** should be spray applied as a **smooth continual pass** with a **50% overlap**.



Spray Applying Sur-Prep® 5677 (Continued From Page 4):

5.) Electro-Static Spray Gun Setup

- A.) Minimize the flow of **Sur-Prep® 5677** for the required **coating speed** and **film thickness**.
- B.) Minimizing the target distance of spraying **Sur-Prep® 5677**.
- C.) Ensure that the **Sur-Prep® 5677** to be sprayed has a very high **resistivity** of at least **>1 mega-ohm**.
- D.) Attach charging unit to the gun and object to be sprayed with **Sur-Prep® 5677**.
- E.) Gradually increase in-line **air pressure** so that the spray provides proper **Sur-Prep® 5677** build at the required **coating speed** and ensure that the pressure does not exceed **100 psi**.
- F.) **Fluid pressure** is typically **400-800 psi** so make sure it is set to that **psi range**.
- G.) Turn on **charging unit** and begin spraying **Sur-Prep® 5677**.

Electro-Static Spray Gun



Sur-Prep® 5677 Packaging Pictures and Other Materials To Purchase:

Sur-Prep® 5677

- *16 fl oz (473 mL) Aerosol-**100474**
- *Case of 4 each Gallon (4 each of 3.8 Liter) Cans-**100478**
- *5 Gallon (18.9 Liter) Pails-**100481**
- *55 Gallon (208 Liter) Drums-**100482**
- *Special packaging upon request

Zip-Chem® Aerosol Trigger Sprayer

*010040

Gloves | Protective Clothing | Protective Eyewear

Proper Mask | Ventilation Equipment | Lighting Equipment

Rags, Cloths, Towels, and other proper wiping devices | Spill containment vessels and other proper devices for collecting material

Formit®

- *Formit®-18-Fan-006224
- *Formit®-18-180-006226
- *Formit®-18-360-006227
- *Formit®-18-STD-FOG-008352
- *Formit®-18-90-FOG-008353
- *Formit®-48-Fan-008460
- *Formit®-36-360-009131
- *Formit®-48-360 with metal sleeve-009132
- *Formit®-48-360 without metal sleeve-100424
- *Formit®-29-360-101321
- *Formit® Sample Pack (3 each of Formit®-18-Fan, Formit®-18-180, Formit®-18-360, Formit®-18-STD-FOG-100107)

Formit® NSN's: 4730-01-612-9914, 4730-01-661-8773 (**Formit®-18-Fan**)
6850-01-492-2942 (**Formit®-18-360**)
4730-01-632-0156 (**Formit®-18-STD-FOG**)

1560-01-658-8943 (**with metal sleeve**)
4730-01-659-5461 (**without metal sleeve**) (**Formit®-48-360**)
4730-01-632-0157 (**Formit®-48-Fan**)

Sur-Prep® 5677 NSN: 6850-01-684-6911
16 fl oz (473 mL) Aerosol

Sur-Prep® 5677
1 Gallon
(3.8 Liter) Can

Sur-Prep® 5677 Packaging Pictures and Other Materials To Purchase (Continued From Page 5):



← **Sur-Prep® 5677 NSN: 6850-01-684-6911**
16 fl oz (473 mL) Aerosol

Sur-Prep® 5677 →
1 Gallon
(3.8 Liter) Can



For application questions regarding the **Sur-Prep® 5677**, contact **Zip-Chem® Aviation Products** at (1) 408 782 2335 or zipchem@addevmaterials.com.