

STANDARD OPERATING PROCEDURE

- Storage

1. Keep the product at the temperature between +5°C and 40 °C.
2. Keep the product in the original container in a dry room.

- Preparation of the product before the application

1. Stir very well the bottle with long neck brush till the colour is completely mixed.
2. Avoid to use solvent based cleaner on the edge to remove excess of product.
3. If necessary, you can dilute the Edge Paint with demineralized water or better with our EP Thinner.
4. If necessary, you can use hot iron, pay attention the **temperature has to be lower then 240°C.**

- Method of application

The method of application depends on:

Type of leather where the Edge Paint has to be applied.

Type of Edge finish we want to achieve.

Method of application (machine, hand, spray gun, etc.).

1. **Leather with adhesion problems** (FATLIQUORING or WAXY LEATHER).

- a. *Clean the raw edge with sand paper;*
- b. *Apply the desired colour in EP 2000HC series or EP SEALER diluted with 20-30% of EP Thinner, this is a specific primer to increase the adhesion and uniform the absorption of the raw edge;*
- c. *Let it dry properly: in case you are using an oven drying, not to exceed 45°C;*
- d. *Brush the edge with rotative brush;*
- e. *Apply the first coat of the the primer EP FILLER or EP FULL or the desired colour in EP 2000 HC series, depending on the type of finishing do you want achieve;*
- f. *Let it dry properly;*
- g. *You can repeat the application of the colour till achieve the desired finish.*

2. **Leather with good absorption and thin raw edge** (belts and shoulder belts)

- a. *Clean the raw edge with sand paper;*
- b. *Apply a first coat of EP SEALER or EP FILLER, these are specific primers to increase the adhesion, decrease and uniform the absorption (please check the chemical and physical differences between the two on the TDS);*
- c. *Let it dry properly: in case you are using an oven drying, not to exceed 45°C;*
- d. *You can bush or buff by rotative brushes or glaze with hot iron (pay attention to the temperature of the iron Max: 240°C);*
- e. *Apply the first coat of the desired colour in EP 2000HC series;*
- f. *Let it dry properly;*
- g. *You can repeat the application of the colour till achieve the desired finish.*

3. **Raw edge with high absorption, thick raw edge or when full, round and smooth edge finish requested.**

- a. *Clean the raw edge with sand paper;*
- b. *Apply a first coat of EP FILLER this is a specific primer to increase the adhesion, fill and smooth the edge; The EP FILLER is available in black and white version as well;*
- c. *Let it dry properly (25-30 minutes): in case you are using an oven drying, not to exceed 45°C;*

- d. You can bush or buff by rotative brushes or glaze with hot iron (pay attention to the temperature of the iron Max: 240°C);
- e. Apply the first coat of the desired colour in EP 2000HC series;
- f. Let it dry properly;
- g. You can repeat the application of the colour till achieve the desired finish.

3bis. Raw edge with high absorption, thick raw edge or when full, round and smooth edge finish requested.

- a. Clean the raw edge with sand paper;
- b. Apply a first coat of EP FILLER, this is a specific primer to increase the adhesion, fill and smooth the edge; The EP FILLER is available in black and white version as well;
- c. Let it dry properly (25-30 minutes): in case you are using an oven drying, not to exceed 45°C;
- d. Apply the first coat of the desired colour in EP 2000HC series;
- e. Let it dry properly (15-20 minutes): in case you are using an oven drying, not to exceed 45°C;
- f. You can bush or buff by rotative brushes or glaze with hot iron (pay attention to the temperature of the iron Max: 240°C);
- g. Apply the following coats of the desired colour in EP 2000HC series;
- h. Let it dry properly;
- i. You can repeat the application of the colour till achieve the desired finish.

4. Finish for very full, round and smooth edge finish requested.

- a. Clean the raw edge with sand paper;
- b. Apply one or two coat of EP FULL this is a specific primer to increase smoothness and to make the edge very full and round; the EP FULL is available in black and white version as well;
- c. Let it dry properly (20-25minutes): in case you are using an oven drying, not to exceed 45°C;
- d. You can brush lightly or glaze with hot iron (pay attention to the temperature of the iron Max: 140°C);
- e. Apply the first coat of the desired colour in EP 2000HC series;
- f. Let it dry properly;
- g. You can repeat the application of the colour till achieve the desired finish.