

Several sealer, paint and tape manufacturers have provided their recommendations for finishing materials suitable for use on EXTIRA. JELD-WEN, inc. provides this information, to prospective users who must independently determine the suitability of such materials for its purpose. It is the user's responsibility to test and qualify all materials the user intends to use on EXTIRA. JELD-WEN, inc. does not guarantee the performance or compatibility of the materials listed in this document, or any other materials, nor does JELD-WEN, inc. bear any liability associated with the secondary treatment of EXTIRA. Samples of EXTIRA are available upon request for your testing purposes. Please contact leahH@jeld-wen.com for samples.

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JELD-WEN, inc. welcomes information from you about your experience with the use of these materials or any other in the secondary treatment of EXTIRA.

### FINISHING:

For signs that require extremely high primer/surface adhesion, such as when using sand mask agents, use an exterior grade surface sealer before applying the prime coat. We suggest an oil-based polyurethane. For maximum surface strength results, use a high quality, solvent or oil-based primer with a surface sealer. Epoxy primers may also perform well. High quality water-based primers will provide long term performance, but are not recommended for applications requiring high primer-to-surface adhesion. If the creation of your sign requires the use of sand masking agents, use a low tack product with a rating around 2.2 lb/inch or less.

Be sure to follow the instructions that the sealer manufacturer provides for use. In general, we suggest that you do not let the sealer cure on the surface. It is important to have good surface penetration to achieve the best result. If there are areas of build-up, they should be lightly sanded before applying the primer application.

SEALER MANUFACTURER	SEALER SYSTEM
ZAR	203 Gloss 267 Satin
Harrison Paints	Dura Guard Alkyd Surface Sealer
Smith and Co. Epoxy Products	Multi Prime, Clear Penetrating Epoxy
Cargill Inc.	Dilulin (requires addition of metallic driers)

### PRIMERS:

Contact the paint manufacturer for final topcoat compatibility with the selected primer system. Be sure to follow the paint manufacturer's instructions for use.

PAINT MANUFACTURER	PRIMER SYSTEM
One Shot, LLC	4411010 High Build Waterborne Primer
Matthews Paints	274 908SP White Epoxy Primer 274 228SP E-Primer (low VOC)
Ronan Paints	Prime All — Waterborne Acrylic Primer/Stain Kill (2 coats recommended, water based)
Zinsser Co., Inc.	Cover-Stain Primer Sealer (oil based)
Harrison Paints	Versa-Seal Primer 249-88 (oil based) Versa-Seal Primer 248-88 (water based)



Matthews Paint has provided the following instructions for specific sign finishes:

NON-SANDING SYSTEM	SANDING SYSTEM
<p><b>CONVENTIONAL:</b></p> <ol style="list-style-type: none"> <li>Tack off Extira with a clean tack cloth. Avoid using harsh solvents to clean Extira as the solvents may cause the substrate to swell.</li> <li>Apply one to two coats of the 274 908SP White Epoxy Primer mixed per directions. See MPC125 Technical Bulletin for mixing and spraying instructions.</li> <li>Topcoat with conventional Satin MAP or conventional Gloss MAP per directions. See MPC102 Technical Bulletin for Satin MAP, or MPC100 for Gloss MAP.</li> </ol> <p><b>LOW VOC:</b></p> <ol style="list-style-type: none"> <li>Tack off Extira with a clean tack cloth. Avoid using harsh solvents to clean Extira as the solvents may cause the substrate to swell.</li> <li>Apply one to two coats of the 274 228SP E-Prime mixed per directions. See MPC126 Technical Bulletin for mixing and spraying instructions.</li> <li>Topcoat with Low VOC Satin MAP or Low VOC Gloss MAP per directions. See MPC107 Technical Bulletin for Low VOC Satin MAP, or MPC106 for Low VOC Gloss MAP.</li> </ol>	<p><b>CONVENTIONAL:</b></p> <ol style="list-style-type: none"> <li>Tack off Extira with a clean tack cloth. Avoid using harsh solvents to clean Extira as the solvents may cause the substrate to swell.</li> <li>Apply one to two coats of the 274 908SP White Epoxy Primer mixed per directions. See MPC125 Technical Bulletin for mixing and spraying instructions.</li> <li>Apply two to three coats of 6001SP Polyester Primer Surfacer mixed per directions. See MPC169 Technical Bulletin for mixing and spraying instructions.</li> <li>Sand the 6001SP to leveling. Final sand with a grit no coarser than 600 before applying a topcoat.</li> <li>Topcoat with conventional Satin MAP or conventional Gloss MAP per directions. See MPC102 Technical Bulletin for Satin MAP, or MPC100 for Gloss MAP.</li> </ol> <p><b>LOW VOC:</b></p> <ol style="list-style-type: none"> <li>Tack off Extira with a clean tack cloth. Avoid using harsh solvents to clean Extira as the solvents may cause the substrate to swell.</li> <li>Apply one to two coats of the 274 228SP E-Prime mixed per directions. See MPC126 Technical Bulletin for mixing and spraying instructions.</li> <li>Apply two to three coats of 6001SP Polyester Primer Surfacer mixed per directions. See MPC169 Technical Bulletin for mixing and spraying instructions.</li> <li>Sand the 6001SP to leveling. Final sand with a grit no coarser than 600 before applying a topcoat.</li> <li>Topcoat with Low VOC Satin MAP or Low VOC Gloss MAP per directions. See MPC107 Technical Bulletin for Low VOC Satin MAP, or MPC106 for Low VOC Gloss MAP.</li> </ol>

### SANDMASK TAPES:

In general, use a tape with a low grip adhesive, such as a rating of 2.2 lb/inch. The following tapes have produced acceptable results. Test or qualify the tapes with Extira before making a sign. Final qualification is the responsibility of the end user.

TAPE MANUFACTURER	PRODUCT
Avery Dennison	SF 100-128-S White Paint Mask SF 100-231-S Yellow Paint Mask

### CONTACT INFORMATION

One Shot, LLC.  
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Technical Support  
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Phone: 219.949.1684  
Email: yatest@spraylat.com

3M  
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Industrial Tape and Specialties Div.  
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St. Paul, MN 55144-1000  
Phone: 800.362.3550  
Email: www.3M.com/industrialtape

Avery Dennison Graphics &  
Reflective Products Division NA  
Contact: Answerline  
250 Chester Street 6M  
Painesville, OH 44077  
Phone: 800.443.9380 option 1

Cargill, Inc.  
Contact: Diane Smith  
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Minneapolis, MN 55440-5693  
Phone: 800.842.3631

HartCo. Inc.  
Contact: Customer Support  
1280 Glendale-Milford Road  
Cincinnati, OH 45215  
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Email: info@harcoservice.com

Harrison Paints  
Contact: Guy Braun x 139  
Gary Bickel x 133  
1329 Harrison Ave. SW  
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Phone: 800.321.0680  
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Matthews Paint  
Customer Service Group  
LakeView Corporate Park  
8201 – 100th Street  
Pleasant Prairie, WI 53158  
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matthewspaint

Ronan's Paint Corp  
Contact: Dennis Doran  
749 East 135th Street  
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