

SPECIFICATION NO: **RD281**

NEW WORK/REPAINT: REPAINT – INTERIOR / EXTERIOR

SUBSTRATE: Metals - Mild Steel

PAINT FINISH: Plascon Plascothane Polyurethane Enamel (Smooth finish – solvent based, tough, fast drying 2-pack polyurethane-acrylic gloss) **PRODUCT CODE: UP/KAT 518**

COLOUR: White.

ENVIRONMENT: The Maintenance Cycle is a guide but can vary due to micro-climate changes identified on the site which will affect the longevity of the coating system

As per ISO 12944-2:1998 Maintenance Cycle (Years)

| | | |
|------|------------------|---|
| C1 - | Inland | 8 |
| C3 - | Industrial | 7 |
| C5 - | Coastal / Marine | 6 |

Optimal performance requires a minimum topcoat DFT of 30µm per coat.

| Plascon Coating System | Application Method | Spreading Rate m ² /ℓ | WFT/DFT µm (min & max) | Reducer/Cleaner | Overcoating time h @ 23 °C | Technical Data Sheet No | TVOC g/ℓ |
|---|--------------------|----------------------------------|--------------------------|--|----------------------------|-------------------------|-----------------------------------|
| Spot Primer Plascon Plascoguard 75 Zinc Phosphate Epoxy Primer (PEX 75/PEH 75) Mixing ratio 4:1 by volume | B or S | @ 75 µm Theo: 8 Prac: 5.4 | WFT 83-208 DFT 50-125 | EPT 2 | 4 4 weeks max | PEX 75 | 411 |
| 1st Finishing Coat Plascothane 9:1 Polyurethane Enamel (UP/KAT 518) Mixing ratio 9:1 by volume | S | @ 30 µm Theo: 14 Prac: 7.7 | WFT 60-119 DFT 25-50 | Polyurethane Acrylic Thinner (AW 260) | 30 mins min 48 max | UP | 523 white 610 colours & toners |
| 2nd Finishing Coat Plascothane 9:1 Polyurethane Enamel (UP/KAT 518) Mixing ratio 9:1 by volume | S | @ 30 µm Theo: 14 Prac: 7.7 | WFT 60-119 DFT 25-50 | Polyurethane Acrylic Thinner (AW 260) | 30 mins min 48 max | UP | 523 white 610 colours & toners |

SURFACE PREPARATION:

- ^ After a full site assessment has been conducted, select the appropriate surface preparation required from Surface Preparation clauses for remedial procedure.
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APPLICATION:

Primer Coat

- ^ Premix base and hardener to form a homogenous mix prior to use.
 - ^ Spot prime bare and repaired areas with Plascon Plascoguard 75 Zinc Phosphate Epoxy Primer (PEX 75). Allow 4 hours to dry.
 - ^ Apply two full coats of Plascon Plascothane 9:1 Polyurethane Enamel (UP) to achieve complete obliteration, allowing 2 hours drying between coats.
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TABLE REFERENCES:

- ^ Technical Data Sheet (TDS): User must always ensure that latest issue is used.
- ^ B = Brush (ready for use), R = Roller (synthetic, min. 10mm pile) (ready for use), S = Airless spray (ready for use).
- ^ Theoretical spreading rate quoted is for smooth non-porous substrates and does not include allowance for surface profile, porosity, wastage and uneven film application. Suitable allowance should be made according to type of work, method and skill of applicator. Practical spreading rate quoted is an average guide only - actual must be determined by user.
- ^ Overcoating times are at 23 °C and 75 % relative humidity. Longer times must be allowed under cooler and moist conditions. DO NOT paint during inclement weather and when temperature is below 10 °C.
- ^ Fading and chalking will occur to a greater or lesser degree depending on pigmentation and generic binder type.
- ^ NB: Life expectancy may vary, depending on environmental conditions and stresses, within the macro/micro climate of the project.

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