

**NEW WORK/REPAINT:** NEW WORK – 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 <sup>2</sup> /ℓ	WFT/DFT µm (min & max)	Reducer/Cleaner	Overcoating time h @ 23 °C	Technical Data Sheet No	TVOC g/ℓ
<b>Primer</b> Plascon Plascoguard 75 Zinc Phosphate Epoxy Primer (PEX 75/PEH 75) <b>Mixing ratio 4:1 by volume</b>	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
<b>1<sup>st</sup> Finishing Coat</b> Plascothane 9:1 Polyurethane Enamel (UP/KAT 518) <b>Mixing ratio 9:1 by volume</b>	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
<b>2<sup>nd</sup> Finishing Coat</b> Plascothane 9:1 Polyurethane Enamel (UP/KAT 518) <b>Mixing ratio 9:1 by volume</b>	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:**

### **Degrease**

- ^ Surfaces must be clean, dry and rust free. Remove surface contaminants using Plascon Aquasolv Degreaser (GR 1), scrubbing with bristle brush or broom, or using Scotch Brite pads.
- ^ Rinse thoroughly with tap water while brushing or hydroblast to remove all traces of Plascon Aquasolv Degreaser (GR 1) to achieve a water break-free surface. Dry surface rapidly to prevent flash rust formation.
- ^ Cleaned surface must be painted within 4 hours.

### **Rusted**

- ^ Rust Grade "B" (Steel surfaces which has begun to rust which the millscale has begun to flake).
- ^ Rust Grade "C" (Steel surfaces where millscale has rusted away)
- ^ Rust Grade "D" (Steel surface where millscale has rusted away and pitting is visible to the naked eye).
- ^ After degreasing sand off rust with coarse emery paper or wire brush to ISO 8501 - 01 : 2007 – St3 to attain a bright metal finish. Remove dust.

### **Millscale**

- ^ Rust Grade "A" steel surface covered completely with adherent millscale and with little or if any rust.
  - ^ Remove millscale and rust by abrasive blast cleaning to ISO 8501 - 01 : 2007 - Sa2½.
  - ^ Remove dust by vacuum cleaning. Prime within 4 hours.
- 

## **APPLICATION:**

- ^ Premix base and hardener to form a homogenous mix prior to use.
  - ^ Apply one coat of Plascon Plascoguard 75 Zinc Phosphate Epoxy Primer (PEX 75) to achieve a continuous film. 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.
- 

## **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.

Copyright ©Kansai Plascon (Pty) Ltd 2013. All rights reserved. No part of this work may in any form or by any means be reproduced without prior written permission of the copyright owner. PLASCON is the registered trade mark of Kansai Plascon (Pty) Ltd,

---