

NEW WORK/REPAINT: NEW WORK – INTERIOR / EXTERIOR

SUBSTRATE: Metals - Mild Steel

PAINT FINISH: Plascon Velvaglo Non – Drip Waterbased Satin (Water based finish enamel) **PRODUCT CODE: VLW**

COLOUR: White and Standard colours as per colour card, plus Plascon colour system and other fan decks.

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	5
C3 -	Industrial	4
C5 -	Coastal / Marine	3

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
Primer Plascon Metalcare Metal WB Primer (MWP 1)	B, R or S	@ 55 μm Theo: 6.7 Prac: 4.4	WFT 135- 162 DFT 50-60	Water	WB topcoat: 8 SB topcoat: 16	MWP 1	26
1st Finishing Coat Plascon Waterbased Velvaglo (VLW/TVW)	B, R or S	@ 35 μm Theo: 9.7 Prac: 5.5	WFT 88-118 DFT 30-40	Water	4	VLW	46-50 white, pastel tinted < 53-60 deep & transparent bases tinted
2nd Finishing Coat Plascon Waterbased Velvaglo (VLW/TVW)	B, R or S	@ 35 μm Theo: 9.7 Prac: 5.5	WFT 88-118 DFT 30-40	Water	4	VLW	46-50 white, pastel tinted < 53-60 deep & transparent bases tinted

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.
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APPLICATION:

Primer

- ^ Apply one coat of Plascon Metalcare Metal WB Primer (MWP 1) to achieve a continuous film. Allow 8 hours to dry before overcoating with a waterbased topcoat or allow 16 hours when overcoating with a solvent based topcoat.

Finishing Coats

- ^ Apply two full coats of Plascon Waterbased Velvaglo (VLW/TVW) to achieve complete obliteration, allowing 4 hours drying between coats.
NB: if white is used, three coats might be necessary to achieve obliteration.
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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.

