

TYPICAL PAINT SPECIFICATION

SYSTEM: A

EXTERNAL/INTERNAL STEELWORK – AGGRESSIVE ENVIRONMENTS

PREPARATION

Thoroughly wash down overall to remove all accumulated contamination, production deposits, dirt, grease, salt, oil and all other contamination etc so as to present a clean surface.

Rinse well with clean water and allow to thoroughly dry.

NB: The use of high pressure water blasting and steam cleaning equipment are recommended for cleaning these surfaces.

'Caked' on deposits may need to be manually scraped off or otherwise removed prior to the cleaning process.

Completely remove all loose, suspect poorly adhering, flaking or otherwise defective coatings back to a firm sound base.

NB: The use of power tools are recommended to assist with the preparation. E.g. Needle guns, rotary wire brushes, grinders etc.

Dust off well.

All corrosion, scale etc must be removed using most appropriate power/manual tools to achieve a minimum surface standard ISO St2.

All prepared corroded areas must be washed with clean water to remove all corrosion salts prior to priming. Re prepare to achieve ISO St2.

Dust off well.

Prime all exposed bare steel within 4 hours of preparation or before any deterioration takes place.

It is important to ensure that the surfaces are perfectly clean sound and dry at the time of painting.

SYSTEMS

1 - PAINTING – HIGH SOLIDS EPOXY/POLYURETHANE OPTION

Primer – Apply to all bare steel. Temabond ST 200/WG200. High solids surface tolerant aluminum primer. DFT 100 Microns/coat.

Stripe coat all vulnerable areas/areas of serious corrosion with additional coat of Temabond ST 200/WG200. High solids epoxy aluminium primer. DFT 100 Microns.

1st Coat – Apply overall. Temabond WG500. Colour to match finish. High solids surface tolerant winter grade undercoat/finish. DFT 100 Microns.

Finish – Apply overall. Temathane PLV or Temathane PLS (HS). Two-pack recoatable polyurethane gloss or semi gloss finish DFT 50 Microns.

NB: All products must be used in strict accordance with all relevant technical data sheets and attached important notes.



TYPICAL PAINT SPECIFICATION

INTERNAL GENERAL STEELWORK

PREPARATION

Thoroughly wash/clean down overall with Tikkurila Cleaning Agent to remove all accumulated contamination dirt, grease, salt, oil and all other contamination etc so as to present a clean surface.

Rinse well with clean water and allow to thoroughly dry.

Completely remove all loose, suspect poorly adhering, flaking or otherwise defective coatings back to a firm sound base.

NB: Power tools are recommended to assist with the preparation where required.
E.g. Needle guns, rotary wire brushes, grinders etc.

Dust off well.

All corrosion, scale etc must be removed using most appropriate power/manual tools to achieve a minimum surface standard ISO St2.

Dust off well.

Prime all exposed bare steel within 4 hours of preparation or before any deterioration takes place.

It is important to ensure that the surfaces are perfectly clean sound and dry at the time of painting.

PAINTING – GENERAL STEEL

SYSTEM – 1 HIGH BUILD EPOXY PRIMER AND FAST SET UNDERCOAT AND GLOSS

Patch Prime – All bare areas/steel. Temabond ST 200/WG 200. High solids epoxy aluminium primer. DFT 100 Microns.

1st Coat – Apply overall. Temaprime MPH 700. High Build Alkyd Primer/Undercoat. DFT 75 Microns. Colour to match finish

Finish – Apply overall. Temalac ABV. High build QD alkyd gloss finish DFT 40 Microns.

SYSTEM – 2 MARINE ENAMAL FINISH

Patch Prime (As required) – Prime all vulnerable areas sharp edges bolt heads and corroded (prepared) areas with 2 coats. Tikkurila Valtti Super Metal Primer. Single pack anti corrosion primer. DFT 40 Microns/coat.

2nd Coat – Apply overall. Tikkurila Unica Adhesion Primer/Undercoat (Formerly Otex Metal Primer). Single pack primer/undercoat. Colour to match finish. DFT 35 Microns

Finish – Apply overall Tikkurila Miranol. Single pack universal high performance alkyd gloss enamel. DFT 40 Microns.

NB: All products must be used in strict accordance with all relevant technical data sheets and attached general notes.

Washing between coats is recommended if required

NB: All products must be used in strict accordance with all relevant technical data sheets and attached general notes.



TYPICAL PAINT SPECIFICATION

GENERAL GALVANISED STEEL UNTREATED

PREPARATION

Thoroughly wash down overall with Tikkurila Cleaning Agent to remove all accumulated contamination, production deposits, dirt, grease, salt, oil and all other contamination etc so as to present a clean surface.

Rinse well with clean water and allow to thoroughly dry.

NB: The use of high pressure water blasting and steam cleaning equipment are recommended where possible for cleaning these surfaces.

'Caked' on deposits may need to be manually scraped off or otherwise removed prior to the cleaning process.

Rinse well with clean water and allow to thoroughly dry.

Thoroughly abrade as required to remove all zinc salts, oxidation, pitting etc.

Dust off.

All corrosion, scale etc must be removed using most appropriate power/manual tools to achieve a minimum surface standard ISO St2.

It is of the utmost importance to ensure that the surfaces are perfectly clean and dry at the time of painting.

PAINTING

SYSTEMS

1 – AGGRESSIVE ENVIRONMENTS

Patch Prime all corrosion. Temabond ST 200/WG 200. High solids epoxy aluminium primer. DFT 100 Microns.

1st Coat – Apply overall. Temaclad Bonding Coat. Two pack etch primer. DFT 15 Microns.

2nd Coat – Apply overall. Temabond WG 500. Colour to match finish. High solids surface tolerant winter grade undercoat/finish. DFT 100 Microns.

Finish – Apply overall. Temathane PLV or Temathane PLS (HS). Two-pack recoatable polyurethane gloss or semi gloss finish DFT 50 Microns.

NB: All products must be used in strict accordance with all relevant technical data sheets and attached important notes.

2 – GENERAL ENVIRONMENTS

Patch Prime all corrosion. Temabond ST 200/WG 200. High solids epoxy aluminium primer. DFT 100 Microns.

1st Coat – Apply overall. Temaclad Bonding Coat. Two pack etch primer. DFT 15 Microns.

1st Coat – Apply overall. Temaprime MPH 700. High Build Alkyd Primer/Undercoat. DFT 75 Microns. Colour to match finish

Finish – Apply overall. Temalac ABV. High build QD alkyd gloss finish DFT 40 Microns.



SYSTEM – 2 MARINE ENAMAL FINISH

Patch Prime all corrosion. Temabond ST 200/WG 200. High solids epoxy aluminium primer. DFT 100 Microns.

1st Coat – Apply overall. Temeclad Bonding Coat. Two pack etch primer. DFT 15 Microns.

2nd Coat – Apply overall. Tikkurila Unica Adhesion Primer/Undercoat (Formerly Otex Metal Primer). Single pack primer/undercoat. Colour to match finish. DFT 35 Microns

Finish – Apply overall Tikkurila Miranol. Single pack universal high performance alkyd gloss enamel. DFT 40 Microns.

NB: All products must be used in strict accordance with all relevant technical data sheets and attached general notes.

Washing between coats is recommended if required

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