

Practical tips for airless spraying of Noxyde

- * Follow always the maintenance instructions of the airless machinery.
- * Each thorough pre-treatment of a metal surface implies a high pressure cleaning with at least 200 bar pressure. This high pressure cleaning is done by wet sandblasting until a degree of derusting Sa2 or by spraying off with water (with rotating spray head) of a mechanically derusted surface (degree of derusting St2). The distance between the cleaning gun and the metal must be sufficiently short during cleaning in order to be sure that all non adhering rust particles are being removed adequately. Loose sheets must be removed and loose bolts be fastened.
- * After drying of the (wet) metal surface, apply Noxyde as soon as possible in order to eliminate or reduce the risk of beginning rust formation.
- * In normal conditions, do **not** dilute Noxyde; at temperatures over 25°C dilute with maximum 3 % water.
- * Lay the Murfill mesh on small holes, cracks and leaking bolts and cover with Noxyde (by brush) before spraying the first coat of Noxyde; treat larger holes with the Dakfill bridging mesh.
- * Mix up the Noxyde before use; put the supply hose in the can and let some water standing on the paint in order to prevent skin formation.

During airless application, protect the Noxyde can against dirt.

When spraying is interrupted for some minutes, plunge the gun always in water; clean the airless always with water at noon; during a long inactivity period rinse the airless with mineral spirit or an adequate synthetic thinner.

- * In order to avoid or to reduce overlappings:
 - spray always in the wind-direction
 - spray from seam to seam, where possible
 - do never spray Noxyde in bright sun on vertical walls
- * Adjust airless pressure according to the hose length (light colour by preference); if possible, use a hose diameter that is as large as possible.
- * Adjust the spray nozzle and spray angle according to the surface shape, the structure of the Noxyde surface and the surface to be covered per hour.

The minimum spray nozzle is 15 mills (about 375 micron), and the spray angle varies from 10° to 40°; the smaller the spray nozzle, the finer the paint structure, but the lower the efficiency.

A typical adjustment for treating large roof surfaces is a spray nozzle of 23 mills (about 575 micron) and a spray angle of 40°.

- * Apply Noxyde in 2 coats in contrasting colours.
- * Check the consumption of Noxyde, i.e. 400 g/m² per coat by marking the number of square meters per can: a 25 kg packing allows to treat 60 m²; if corrugated sheets are to be sprayed, it is necessary to foresee 25% additional paint for the measured surface.
- * Check the wet film thickness with a wet film thickness gauge: about 300 micron for a consumption of 400 g/m².
- * Keep a drying time of at least 12 hours between the application of the first and second coat, especially on roof surfaces; when applying the second coat protect shoes with plastic in order to avoid that paint rests beneath the shoe would stick into the first coat.
- * After hardening check the dry film thickness: minimum 350 micron for a consumption of about 800 g/m².