

## Rustoleum Noxyde 10 Year Plus Tape

**Construction: Brick built warehouse with metal cladded roof and verticals**

**Substrate type: Metal cladding**

**Existing coating: Plastisol cladding**

**Current condition: The roof and vertical panels are in reasonable condition, however there are some areas of complete failure and rusting.**

**Stated requirements from coating system:- The client has requested that this coating system application be endorsed via a Rust-Oleum 10 Year Product Warranty Certificate.**

**Exposure** The building will be exposed to typical UK weathering the exposure is estimated as being C5M environment as detailed within ISO 12944

### **Surface treatment**

**Any areas of complete failure of the metal sheets or edge laps or where the metal has completely rusted through, these are to be replaced with new metal sheets and panels.**

To minimise any sheet movement during this work, the end laps should be fixed via use of rivets at intervals of every other profile, and at a distance of approximately 50-75 mm from the cut edge.

All surfaces to be painted are to be thoroughly washed and degreased via high pressure washing at a pressure of 3000 - 3500 psi. (approximately 210 -250 bar). This water jetting operation to incorporate a 5% solution of Rust-Oleum ND14 Cleaner Degreaser to remove all oils, grease and other soluble surface contaminants. *This cleaning solution must not be allowed to dry on the surface;* whilst still wet, ensure that the cleaning solution and all resulting loosened contamination is removed via rinsing with copious amounts of fresh clean water.

Any areas which have been noted to exhibit vegetative contamination are to be treated with Rust-Oleum AMW. This should be liberally applied to the affected surface and allowed to act for 24 hours. After this period, the residue of the vegetative contamination is to be removed via dry brushing or water jetting depending upon site conditions and contractor preference.

All rusted areas are to be mechanically de-rusted (with disc sander or mechanical wire brush) to achieve a cleanliness standard of **St3** according to ISO 8501 i.e. no brown rusting to remain visible. Where this leaves a "leading edge" of existing coating, this should be feathered to a firm edge.

This cleaning / de-rusting should be conducted to a distance of at least 100 mm (4 inches) either side of the overlap edge

## **Priming**

All treated de-rusted areas must be primed on the same day. These areas are to be primed with one coat of Noxyde (shade No. 10 English Red) at an approximate theoretical coverage rate of 400 gms per square metre, sufficient to provide a dry film build of 175 microns (= approximately 320 microns wet film).

Allow to dry for a minimum period of 24 hours at 20°C.



### **Tape Application - Where Required**

Apply Noxyde Tape centrally over the joint detail, pressing firmly into the profile of the panel avoiding stretching, tenting or creation of any air pockets. Ensure that the Noxyde Tape is well adhered to both surfaces.

Ensure all applied Noxyde Tape is coated within the same working day with one coat of Noxyde (standard "grey" shade) at an approximate theoretical coverage rate of 400 gms per square metre, sufficient to provide a dry film build of 175 microns (= approximately 320 microns wet film).

Allow to dry for a minimum period of 24 hours at 20°C before applying any subsequent coatings

## **Paint system – Pitched metal roofs (1,200m<sup>2</sup> inc 30% profile)**

### **Coat 1**

Using a variable or slow speed drill and mixing paddle, mechanically mix the contents of each unit of Noxyde (standard "grey" shade to suit, ensuring a contrasting shade to finish coat appearance) for a minimum period of 3 minutes until a homogenous mix and colour is achieved, with no unmixed material remaining on the bottom or sides of the can.

Apply by airless spray, one coat of Noxyde at an approximate theoretical coverage rate of 400 gms per square metre, sufficient to provide a dry film thickness of 175 µm (= approximately 320 µm wet film with undiluted product)

Allow to dry for a minimum period of 24 hours at 20°C before applying any subsequent coatings.

### **Coat 2**

Using a variable or slow speed drill and mixing paddle, mechanically mix the contents of each unit of Noxyde (shade to customer requirements) for a minimum period of 3 minutes until a homogenous mix and colour is achieved, with no unmixed material remaining on the bottom or sides of the can.

Apply by airless spray, one coat of Noxyde at an approximate theoretical coverage rate of 400 gms per square metre, sufficient to provide a dry film thickness of 175 µm (= approximately 320 µm wet film with undiluted product).

Allow to dry for a minimum period of 24 hours at 20°C before applying any subsequent coatings

## **Paint system – Vertical panels (500m2 inc 30% profile)**

### Coat 1

Using a variable or slow speed drill and mixing paddle, mechanically mix the contents of each unit of Noxyde (standard “grey” shade to suit, ensuring a contrasting shade to finish coat appearance) for a minimum period of 3 minutes until a homogenous mix and colour is achieved, with no unmixed material remaining on the bottom or sides of the can.

Apply by airless spray, one coat of Noxyde at an approximate theoretical coverage rate of 300 gms per square metre, sufficient to provide a dry film thickness of 130 µm (= approximately 240 µm wet film with undiluted product)

Allow to dry for a minimum period of 24 hours at 20°C before applying any subsequent coatings.

### Coat 2

Using a variable or slow speed drill and mixing paddle, mechanically mix the contents of each unit of Noxyde (shade to customer requirements) for a minimum period of 3 minutes until a homogenous mix and colour is achieved, with no unmixed material remaining on the bottom or sides of the can.

Apply by airless spray, one coat of Noxyde at an approximate theoretical coverage rate of 300 gms per square metre, sufficient to provide a dry film thickness of 130 µm (= approximately 240 µm wet film with undiluted product).

Allow to dry for a minimum period of 24 hours at 20°C before applying any subsequent coatings

## **Product quantity requirements**

Rust-Oleum have measured the total area of the surface to be painted as being 1,700m<sup>2</sup> (*which is inclusive of the surface profile @ 30%*). An allowance of at least 10% practical loss factor should be assumed, therefore the **MINIMUM** quantities required to comply with this specification are as follows

ND14 Cleaner Degreaser	4 x 5lt
AMW	48 x 5lt
Noxyde 10 English Red	3 x 20kg
1st coat Noxyde SHADE TO BE CONFIRMED HERE	36 x 20kg
Topcoat Noxyde SHADE TO BE CONFIRMED HERE	36 x 20kg

## Remarks

The above Specification specifically mentions constant temperatures of 20°C. Deviations from this temperature during application and curing of the individual coats are possible (within the limits described in the Product Data Sheet) but may have consequences for overcoat periods etc. If in doubt, please refer to the relevant Product Data Sheet or to Rust-Oleum Technical Services Department.

As this work is to be covered by a Product Warranty Certificate, this Specification becomes valid only upon completion of a Warranty Filing Card. This Filing Card **must** be completed in conjunction with a site visit by Rust-Oleum and contractor **prior** to any works starting.

## GENERAL REMARKS

- a) The above mentioned consumption is theoretical and is provided for indicative purposes only. Actual consumption is dependent upon site specific conditions and so can only be determined at the moment of execution of the work.
- b) The above mentioned specification is valid for a period of 6 months. After these 6 months a new visit is mandatory to establish the condition of the substrate.
- c) The support must conform to DTU 59-1 i.e. be free of grease, oil, dust, dirt, etc. so that the adhesion of the coating is not negatively influenced. Old coating layers that are not to be removed must have a good adhesion with the underlying substrate. The painter guarantees a sound support and a correct surface preparation.
- d) The above quotation is made in good faith from the information provided. Any coating failures which are the result of conditions not within the control of Rust-Oleum Mathys are out of the scope of the Specification.
- e) The work **must** always be executed by a competent professional applicator, in full accordance with the Specification and with reference to the current Product Data Sheet as well as the current Material Safety Data Sheet. These are freely available from your supplier or can be downloaded from [www.rust-oleum.eu](http://www.rust-oleum.eu) in order to ensure that the most up-to-date information is at hand.
- f) In case of queries concerning the paint Specification or the execution of the work, please contact your sales representative or the Technical Service Department of Rust-Oleum Mathys\*.
- g) All the above are subject to our general terms and conditions which are freely available on request

Technical Service

\* Rust-Oleum Mathys is the tradename of RUST-OLEUM NETHERLANDS BV Roosendaal, Netherlands and NV MARTIN MATHYS SA, Zelem, Belgium.

**Paint specification – page 4**