

COATING SPECIFICATION: MT/ PC / 2261A

 6th May 2016

AREA: Weathered Cladding (10 year)

CUSTOMER: Various

PROJECT: Cladding (10 Year)

SURFACE PREPARATION: Existing Sound Coating : Thoroughly clean and degrease using water rinseable degreaser and fresh water. Ensure that the surface is dry, clean and free from any contamination immediately prior to application. A test patch is recommended to check adhesion to the existing substrate.
Bare metal edges etc : Mechanically prepare to achieve ISO 8501-1 :St 3 standard of cleanliness and stripe coat with AquaCover 80 at 100 um dft.

COAT NR	DATA SHEET NR & PRODUCT NAME	COLOUR	VOC G/LTR	DRY FILM THICKNESS MICROMETER	WET FILM THICKNESS MICROMETER	SOLIDS VOLUME	THEORETICAL SPREADING RATE M ² /LTR	PACK SIZE LTR
1	PPG AquaCover 80 [7152]	Range	35	150	333	45	3.0	20
2	PPG Aquacover 80 [7152]	Range	35	150	333	45	3.0	20
3	PPG AquaCover 40 [7251]	Full range	14	50	119	42	8.4	5/20

COAT NR	DATA SHEET NR & PRODUCT NAME	THINNER	APPLICATION METHOD B/R/A	TOUCH DRY TIME AT 20°C	RECOATING INTERVAL AT 20°C		REMARKS
					Max	Min	
1	PPG AquaCover 80 [7152]	Water	B/R/A	1 hour	**	4 hours	**Unlimited provided that surface is clean, dry and free from any contamination.
2	PPG AquaCover 80 [7152]	Water	B/R/A	1 hour	**	4 hours	
3	PPG AquaCover 40 [7251]	Water	B/R/A	30 mins	**	4 hours	

B = BRUSH R = ROLLER A = AIRLESS SPRAY
Application by Brush or Roller may require more than one coat to achieve required d.f.t.
Certain colours are low in opacity and therefore additional coats may be required

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---This Working Procedure has been prepared to the best of our knowledge to ensure good workmanship. However, the responsibility for executing the work stays with the yard/(sub) contractor. The role of our Technical Service Representative is to provide onsite technical assistance/advise. The presence and/or the technical advise of our technical representatives shall not relieve the yard/ (sub) contractor and owners of their responsibility for correct execution and quality assurance of the coating work and the Paint Manufacturer (PPG) shall at all times be held harmless and indemnified against all third party claims---



GENERAL APPLICATION ASPECTS: SYSTEMS FOR ATMOSPHERIC EXPOSURE

- 1 The life of any protective system is determined by the dry film thickness of the anticorrosive coating system present on weld seams, sharp edges, bolts and nuts, these being the critical 20% of the surface area where breakdown begins.

All critical areas should be given extra stripe coats with the same material as the consecutive coat of the system to achieve the specified dry film thickness.

Giving more attention to these areas will extend the life of the coating system.

The following parameters can be used:

For hand laid welds: Beads with a surface irregularity exceeding 3mm or with sharp crests having a radius under 2mm should be ground.

For sharp edges: All edges to be rounded off with a grinder to a radius of 2mm or more.

For pitting: Pitting in excess of 2mm in depth and under 5mm in diameter should be filled by welding or an epoxy filler.

- 2 For technical reasons, some colours are low in opacity and therefore additional coats may be required.
- 3 The correct grade of thinner should be used. Using the wrong thinner can result in various problems.
- 4 Observe the information given on product data and safety sheets.

GENERAL APPLICATION ASPECTS: TANK COATING SYSTEMS OR ANY SYSTEM IN ENCLOSED SPACE

Refer to paragraphs 1, 3 and 4 above.

1 Ventilation and Curing

Forced ventilation and extraction should be employed during and after application. This is required to ensure a safe working environment during application and solvent removal after application to assist curing. Solvent levels must be maintained below the threshold limit value (TLV) and below 10% of the lower explosive limit (LEL). Data sheets 1430 and 1431 should be referred to for more details of health and safety. Ventilation ducts should be sensibly positioned to ensure a good throughput of fresh air and to minimise pockets of still air with high concentrations of solvent vapours. (Refer data sheet 1434). Dehumidification and/or heating may be required if the ambient conditions are not suitable for painting to commence. Ventilation should be continued for several days after application to assist solvent removal and full cure. The coating should be allowed to cure thoroughly before putting the tank into service. Details on curing times can be obtained from the relevant product data sheet.

If in doubt please ring our Technical Service Department for further information: (Tel: 01525 375234 or 01773 837300).

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