



INDUSTRIAL SPECIFICATION
Repair and Maintenance



Standard Maintenance System Sheet - Powder Coated Windows, Frames & Doors (2 pack system)

Project: EXAMPLE	
Environment: ISO C3	Surface: Prefinished Aluminum Powder Coated Window Frames & Doors
Date: 2019	Prepared By: Tim Haythornthwaite
Preparation Summary	<p>Remove all defective mastics and silicone traces left on the powder coated surface. Solvent wash exposed surface to ensure all silicone is removed.</p> <p>Degrease/wash down overall by the use of a suitable water-soluble detergent (Maalipesu Cleaning Agent) and thoroughly fresh water rinse/wash to remove grease / detergent residues, salt deposits and other contamination. Ensure washing & rinsing procedure is thorough and ensures removal of all contamination. Repeat or alternative washing procedure may be required.</p> <p>Remove all poorly adhering powder coatings etc to sound surface.</p> <p>Thoroughly abrade overall including exposed metal to remove oxidation and other contamination back to a sound bright metal surface. Thoroughly abrade overall with fine abrasive to avoid scratching and to produce a smooth surface and 'key' and to remove oxidation. Rough edges to be feathered smooth to a firm edge.</p> <p>All areas to be clean, sound, dry, free of all corrosion, zinc oxidation and dust free prior to painting.</p>

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System Summary

No of coats	Product	Colour	DFT	Theo Spread Rate	Volume Solids	Thinner
1 x Full Coat	Temadur 20 2 pack polyurethane semi-matt primer/finish	To match finish or suitable U/C Shade	60um per coat	9m/litre	56%	1048
1 or 2 x Full Coats dependant on colour	Temadur 50 2 pack polyurethane semi-gloss finish OR Temadur 20 2 pack polyurethane semi-matt finish 50 = 50% Gloss semi-gloss	TBC	50um per coat	9m/litre	56%/57%	1048
		Total DFT	160um			

Notes:

- Do not overpaint rubber window seals. These must be 'cut into' or removed and replaced once the painting operation is complete. Painting over rubber seals will result in loss of adhesion, cracking and general early deterioration
- Certain finish colours may require additional coats to ensure opacity.
- Spread rates are theoretical and do not allow for wastage etc.
- Ensure coatings are well ventilated during curing and sufficiently cured before overcoating.
- Products to be used in accordance with relevant TDS.
- Dry film thicknesses must be in accordance with ISO19840
- Reinstate all mastics to create a watertight seal
- Total Soluble Salt content on the steel should not exceed 40mg/m²(4ug/cm²) using the Bresle method to ISO8502-6/9 (DSM acceptable)

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STANDARD IMPORTANT NOTES:

Full risk and Health & Safety assessment must be carried out to satisfy method statement and products are suitable prior to application.

Observe all data sheet instructions.

All good painting practices apply as described in BS 6150:1982 & ISO 12944, BS 5493 and all other relevant standards.

Thorough preparation is essential.

Do not apply products during damp, wet or frosty conditions.

During application and curing Surface should dry. Relative humidity should not exceed 80%. Surfaces must be 3°C above the dew point. Do not apply when rain, sleet, snow or mists are imminent.

All products must be applied in strict accordance with all relevant technical data sheets.

All corrosion salts must be removed and steel chemically clean prior to painting. Testing for salts is desirable and allowances made for repeat washing made as appropriate.

All oil, grease, contamination etc. must be identified and removed prior to painting. Where cleaning has not successfully removed these deposits advice must be sought from appropriate technical services department.

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Environmental conditions, temperature, humidity, ventilation must be carefully controlled and or monitored both during application and curing as required.

Shop applied primers must be over coated as soon as possible after application taking note of maximum exposure times and over coating limits.

Regular inspection is recommended and repairs carried out as appropriate. i.e. Mechanical damage etc. This will help prevent premature deterioration.

Regular periodic washing will also help extend the life of the applied paint systems.

Dependant on colour choice additional coats may be necessary to produce a fully uniform colour/finish.

Application by brush may result in lower film thicknesses and additional coats may be required to achieve required film thickness.

Mastics and fillers – All defective mastics and fillers must be replaced or installed where required with appropriate mastic/filler/silicone sealant

Dependant on degree of corrosion additional primer may be required.

Any specification provided is our best recommendation from the information supplied and is given in good faith but without warranty or liability. We recommend a trial area is coated to ensure the product meets your requirements.

Annual maintenance of the proposed coating system is recommended which must include thorough washing and touch up of damaged areas. This will help ensure the durability of the coating system is realised.

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