Technical Note TN144

Paint Systems for MRTS88

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1 Introduction

This Technical Note provides a selection of paint systems that have been assessed in the context of Queensland's climate. The state's high heat and humidity present specific challenges for coatings so specialised formulations are often required.

The systems described in this document have been assessed in according to Appendix A of MRTS88 *Protective Coatings for New Work* and may be used to complete Annexure MRTS88.1.

Paint systems which are not outlined in the technical note are not excluded from use but must be assessed prior to use. If assessment confirms suitability, the system will then be added to this document.

Paint systems for steel and concrete substrate are included.

1.1 Paint Systems

Paint systems should be selected and specified with a mind to suitability for the precise application intended. The paint systems described in this document are recommended for use but are not guaranteed to be universally suitable. It is the Designer's responsibility to consider the project-specific needs when selecting a paint system. The systems are not interchangeable.

The paint systems are presented in this document in a structure that corresponds with the Annexure MRTS88.1.

1.2 Paint Repair Systems

Paint repair systems are required to be nominated by MRTS88 *Protective Coatings for New Work* should repair of the coating be required during initial installation or during future maintenance. These repair systems are specific to the paint system installed.

2 Definitions

WFT – Wet Film Thickness

DFT – Dry Film Thickness

VS – Volume Solids

3 Summary of Systems

The paint systems in the table below are described in detail in the next sections of this document.

Manufacturer	Substrate	Top Coat	Intermediate Coat	Primer
PPG	Steel	PSX 700	Amerlock 400	SigmaZinc 109HS
International	Steel	Interfine 878	Interplus 356	Interzinc 52
International	Steel	Interfine 878	Interplus 356 Ceolcote 680M	Interzinc 52
International	Steel	Interfine 878	Interplus 356	Interzinc 315
PPG	Steel	SigmaDur 550	SigmaCover 350	SigmaZinc 109HS
International	Steel	Interthane 870	Interplus 356	Interzinc 52
Carboline	Steel	Carbothane 134HG	Carboguard 636XT	Carbozinc 858
International	Steel	Intercure 99	N/A	Interzinc 52
Dulux	Steel	Weathermax HBR	Duremax GPE	Zincanode 402
Zinga	Steel	Zingaceram PU	Zingaceram HS	Zinga
MCU-Coatings	Steel	MCU-Miotopcoat	N/A	MCU-Zinc
MCU-Coatings	Steel	MCU-Topcoat	MCU-Miomastic	MCU-Miozinc
MCU-Coatings	Steel	MCU-Miotopcoat	MCU-Aluprime	MCU-Miozinc
MCU-Coatings	Steel	MCU-Miotopcoat	N/A	MCU-Miozinc
Jotun	Steel	HardTop AX	N/A	Barrier
Jotun	Steel	HardTop Flexi	N/A	Barrier
Jotun	Steel	HardTop Optima	N/A	Barrier
Jotun	Steel	HardTop Optima	Penuard Universal	Barrier
Jotun	Steel	HardTop AX	Penuard Universal	Barrier
International	Concrete	Interfine 878	N/A	Interplus 356
PPG	Concrete	PSX 700	N/A	SigmaCover 350
International	Concrete	Interfine 870	N/A	Interplus 356
PPG	Concrete	SigmaDur 550	N/A	SigmaCover 350
Dulux	Concrete	Weathermax HBR	N/A	Durebilt STE
Klaas	Concrete	Si-Rex03	Si-Rex03	Si-Prime
Jotun	Concrete	HardTop AX	Jotamastic 90	Jotamastic 90
Jotun	Concrete	HardTop Optima	Jotamastic 90	Jotamastic 90

4 Steel Substrates

4.1 Paint Systems

4.1.1 PPG Paint System – Polysiloxane Top Coat

Storage of Paint Requirements and Shelf Life

12 months at 25°C. Subject to re-inspection thereafter. Store in dry, shaded conditions away from sources of heat and ignition.

Substrate Preparation

Abrasive blast corroded steelwork to remove rust and provide Class 2½ finish. If oxidation has occurred between blasting and application of the primer, the surface should be re-blasted to the specified visual standard.

Paint System

Coat	Colour	Product	Binder	Thinners	Application Method	Volume Solids %	WFT (Microns)	DFT (Microns)	Over Coat Interval at 25°C	Pot Life at 25°C
1	Grey	SigmaZinc 109HS	Zinc Rich Epoxy	91-92	Airless Spray, Brush & Air Spray	66	115	75	3 Hours	5 Hours
2	Black	Amerlock 400	MIO High Soilds Epoxy Mastic	#737		85	176	150	16 Hours	6 Hours
3	Final	PSX 700	Epoxy Siloxane	#140		89	140	125	3 Hours	3 Hours
						Total DFT Thickness		**350**		

Etching Process between coats

Clean the down between each coat with thinners to etch the coat before applying the next coat. Allow the thinners to dry before applying the protective coating.

Paint Procedure

1. Abrasive blast corroded steelwork to remove rust and provide Class 2½ finish. If oxidation has occurred between blasting and application of the primer, the surface should be re-blasted to the specified visual standard.
2. Stripe coat all edges, rivets, bolts and intersections with SigmaZinc 109HS.
3. Apply one coat of SigmaZinc 109HS with a dry film thickness of 75 microns.
4. Wait for the SigmaZinc 109HS to achieve the recoat time.
5. Etch previous coat with thinners before applying next coat.
6. Allow the thinners to dry before applying the protective coating.
7. Stripe coat all edges, rivets, bolts and intersections with Amerlock 400.
8. Apply one coat of Amerlock 400 with a dry film thickness of 150 microns.
9. Wait for the Amerlock 400 to achieve the recoat time.
10. Etch previous coat with thinners before applying next coat.
11. Allow the thinners to dry before applying the protective coating.
12. Stripe coat all edges, rivets, bolts and intersections with Ameron PSX 700.
13. Apply one coat of PSX 700 with a dry film thickness of 125 microns.

Paint Application

When applying paint by spray, low pressure and high volume spray systems shall be used, as these systems limit the risk of overspray.

Determination of Wet Film Thickness

The wet film thickness measurements supplied by the paint manufacturer is based on no thinners being added to the paint.

If thinners are added to the paint, then the following formula must be used to determine the wet film thickness.

WFT = DFT x (100 + % thinner added) ÷ % VS

4.1.2 International Paint System – Polysiloxane Top Coat

Storage of Paint Requirements and Shelf Life

12 months at 25°C. Subject to re-inspection thereafter. Store in dry, shaded conditions away from sources of heat and ignition.

Substrate Preparation

Abrasive blast corroded steelwork to remove rust and provide Class 2½ finish. If oxidation has occurred between blasting and application of the primer, the surface should be re-blasted to the specified visual standard.

Paint System

Coat	Colour	Product	Binder	Thinners	Application Method	Volume Solids %	WFT (Microns)	DFT (Microns)	Over Coat Interval at 25°C	Pot Life at 25°C
1	Grey	Interzinc 52	Polyamide cured epoxy	GTA220	Airless Spray, Brush & Air Spray	59	127	75	3 Hours	5 Hours
2	Black	Interplus 356	Polyamide adduct cured epoxy	GTA220		70	143	100	4 Hours – 24 Days	2 Hours
3	Final	Interfine 878	Polysiloxane	GTA007		72	104	75	4 Hours	2 Hours
Total DFT Thickness								**250**		

Etching Process between coats

Clean the paint down between each coat with thinners to etch the coat before applying the next coat. Allow the thinners to dry before applying the protective coating.

Paint Procedure

1. Abrasive blast corroded steelwork to remove rust and provide Class 2½ finish. If oxidation has occurred between blasting and application of the primer, the surface should be re-blasted to the specified visual standard.
2. Stripe coat all edges, rivets, bolts and intersections with Interzinc 52.
3. Apply one coat of Interzinc 52 with a dry film thickness of 75 microns.
4. Wait for the Interzinc 52 to achieve the recoat time.
5. Etch previous coat with thinners before applying next coat.
6. Allow the thinners to dry before applying the protective coating.
7. Stripe coat all edges, rivets, bolts and intersections with Interplus 356.
8. Apply one coat of Interplus 356 with a dry film thickness of 100 microns.
9. Wait for the Interplus 356 to achieve the recoat time.
10. Etch previous coat with thinners before applying next coat.
11. Allow the thinners to dry before applying the protective coating.
12. Stripe coat all edges, rivets, bolts and intersections with Interfine 878.
13. Apply one coat of Interfine 878 with a dry film thickness of 75 microns.

Paint Application

When applying paint by spray, low pressure and high volume spray systems shall be used, as these systems limit the risk of overspray.

Determination of Wet Film Thickness

The wet film thickness measurements supplied by the paint manufacturer is based on no thinners being added to the paint.

If thinners are added to the paint, then the following formula must be used to determine the wet film thickness.

WFT = DFT x (100 + % thinner added) ÷ % VS

4.1.3 International Paint System – Polysiloxane Top Coat with a Seal Coat

Note: The coating System outlined below is for structures which have overlapping connections such as riveted members.

Storage of Paint Requirements and Shelf Life

12 months at 25°C. Subject to re-inspection thereafter. Store in dry, shaded conditions away from sources of heat and ignition.

Substrate Preparation

Abrasive blast corroded steelwork to remove rust and provide Class 2½ finish. If oxidation has occurred between blasting and application of the primer, the surface should be re-blasted to the specified visual standard.

Paint System

Coat	Colour	Product	Binder	Thinners	Application Method	Volume Solids %	WFT (Microns)	DFT (Microns)	Over Coat Interval at 25°C	Pot Life at 25°C
1	Grey	Interzinc 52	Polyamide cured epoxy	GTA220	Airless Spray, Brush & Air Spray	59	127	75	3 Hours	5 Hours
2	Clear	Ceilcote 680M	Polyamide cured epoxy	Ceilcote T-410	Stripe Brush	85	N/A	N/A	5 Hours – 4 Weeks	45 Minutes
3	Black	Interplus 356	Polyamide adduct cured epoxy	GTA220	Airless Spray, Brush & Air Spray	70	143	100	4 Hours 24 Days	2 Hours
4	Final	Interfine 878	Polysiloxane	GTA007	Airless Spray, Brush & Air Spray	72	104	75	4 Hours	2 Hours
							Total DFT Thickness	**250**		

Etching Process between coats

Clean the paint down between each coat with thinners to etch the coat before applying the next coat. Allow the thinners to dry before applying the protective coating.

Paint Procedure

1. Abrasive blast corroded steelwork to remove rust and provide Class 2½ finish. If oxidation has occurred between blasting and application of the primer, the surface should be re-blasted to the specified visual standard.
2. Stripe coat all edges, rivets, bolts and intersections with Interzinc 52.
3. Apply one coat of Interzinc 52 with a dry film thickness of 75 microns.
4. Wait for the Interzinc 52 to achieve the recoat time.
5. Stripe coat all edges, rivets, bolts and intersections with Ceilcote 680M.
6. Wait for the Ceilcote 680M to achieve the recoat time.
7. Etch previous coat with thinners before applying next coat.
8. Allow the thinners to dry before applying the protective coating.
9. Stripe coat all edges, rivets, bolts and intersections with Interplus 356.
10. Apply one coat of Interplus 356 with a dry film thickness of 100 microns.
11. Etch previous coat with thinners before applying next coat.
12. Allow the thinners to dry before applying the protective coating.
13. Stripe coat all edges, rivets, bolts and intersections with Interfine 878.
14. Apply one coat of Interfine 878 with a dry film thickness of 75 microns.

Paint Application

When applying paint by spray, low pressure and high volume spray systems shall be used, as these systems limit the risk of overspray.

Determination of Wet Film Thickness

The wet film thickness measurements supplied by the paint manufacturer is based on no thinners being added to the paint.

If thinners are added to the paint, then the following formula must be used to determine the wet film thickness.

WFT = DFT x (100 + % thinner added) ÷ % VS

4.1.4 International Paint System – Polysiloxane Top Coat

Storage of Paint Requirements and Shelf Life

12 months at 25°C. Subject to re-inspection thereafter. Store in dry, shaded conditions away from sources of heat and ignition.

Substrate Preparation

Abrasive blast corroded steelwork to remove rust and provide Class 2½ finish. If oxidation has occurred between blasting and application of the primer, the surface should be re-blasted to the specified visual standard.

Paint System

Coat	Colour	Product	Binder	Thinners	Application Method	Volume Solids %	WFT (Microns)	DFT (Microns)	Over Coat Interval at 25°C	Pot Life at 25°C
1	Grey	Interzinc 315	Polyamide cured epoxy	GTA220	Airless Spray, Brush & Air Spray	69	109	75	2 – Ext Hours	2 Hours
2	Black	Interplus 356	Polyamide adduct cured epoxy	GTA220		70	143	100	4 Hours – 24 Days	2 Hours
3	Final	Interfine 878	Polysiloxane	GTA007		72	104	75	4 Hours	2 Hours
							Total DFT Thickness	**250**		

Etching Process between coats

Clean down between each coat with thinners to etch the coat before applying the next coat. Allow the thinners to dry before applying the protective coating.

Paint Procedure

1. Abrasive blast corroded steelwork to remove rust and provide Class 2½ finish. If oxidation has occurred between blasting and application of the primer, the surface should be re-blasted to the specified visual standard.
2. Stripe coat all edges, rivets, bolts and intersections with Interzinc 315.
3. Apply one coat of Interzinc 315 with a dry film thickness of 75 microns.
4. Wait for the Interzinc 315 to achieve the recoat time.
5. Etch previous coat with thinners before applying next coat.
6. Allow the thinners to dry before applying the protective coating.
7. Stripe coat all edges, rivets, bolts and intersections with Interplus 356.
8. Apply one coat of Interplus 356 with a dry film thickness of 100 microns.
9. Wait for the Interplus 356 to achieve the recoat time.
10. Etch previous coat with thinners before applying next coat.
11. Allow the thinners to dry before applying the protective coating.
12. Stripe coat all edges, rivets, bolts and intersections with Interfine 878.
13. Apply one coat of Interfine 878 with a dry film thickness of 75 microns.

Paint Application

When applying paint by spray, low pressure and high volume spray systems shall be used as this system limits the risk of overspray.

Determination of Wet Film Thickness

The wet film thickness measurements supplied by the paint manufacture is based on no thinners being added to the paint.

If thinners are added to the paint, then the follow formula must be used to determine the wet film thickness.

WFT = DFT x (100 + % thinner added) ÷ % VS

4.1.5 PPG Paint System – Polyurethane Top Coat

Storage of Paint Requirements and Shelf Life

12 months at 25°C. Subject to re-inspection thereafter. Store in dry, shaded conditions away from sources of heat and ignition.

Substrate Preparation

Abrasive blast corroded steelwork to remove rust and provide Class 2½ finish. If oxidation has occurred between blasting and application of the primer, the surface should be re-blasted to the specified visual standard.

Paint System

Coat	Colour	Product	Binder	Thinners	Application Method	Volume Solids %	WFT (Microns)	DFT (Microns)	Over Coat Interval at 25°C	Pot Life at 25°C
1	Grey	SigmaZinc 109HS	Zinc Rich Epoxy	91-92	Airless Spray, Brush & Air Spray	66	115	75	3 Hours	5 Hours
2	Grey (Various)	SigmaCover 350	HS HB Polyamine cured epoxy	91-92		72	140	100	5 Hours – 14 Days	2.5 Hours
3	Final Colour	SigmaDur 550	Polyurethane	21-06		55	90	50	5 Hours	4 Hours
							Total DFT Thickness	**225**		

Etching Process between coats

Clean the paint down between each coat with thinners to etch the coat before applying the next coat. Allow the thinners to dry before applying the protective coating.

Paint Procedure

1. Abrasive blast corroded steelwork to remove rust and provide Class 2½ finish. If oxidation has occurred between blasting and application of the primer, the surface should be re-blasted to the specified visual standard.
2. Stripe coat all edges, rivets, bolts and intersections with SigmaZinc 109HS.
3. Apply one coat of SigmaZinc 109HS with a dry film thickness of 75 microns.
4. Wait for the Sigmazinc to achieve the recoat time.
5. Etch previous coat with thinners before applying next coat.
6. Allow the thinners to dry before applying the protective coating.
7. Stripe coat all edges, rivets, bolts and intersections with SigmaCover 350
8. Apply one coat of SigmaCover 350 with a dry film thickness of 100 microns.
9. Wait for the SigmaCover 350 to achieve the recoat time.
10. Etch previous coat with thinners before applying next coat.
11. Allow the thinners to dry before applying the protective coating.
12. Stripe coat all edges, rivets, bolts and intersections with SigmaDur 550.
13. Apply one coat of SigmaDur 550 with a dry film thickness of 50 microns.

Paint Application

When applying paint by spray, low pressure and high volume spray systems shall be used, as these systems limit the risk of overspray.

Determination of Wet Film Thickness

The wet film thickness measurements supplied by the paint manufacturer is based on no thinners being added to the paint.

If thinners are added to the paint, then the following formula must be used to determine the wet film thickness.

WFT = DFT x (100 + % thinner added) ÷ % VS

4.1.6 International Paint System – Polyurethane Top Coat

Storage of Paint Requirements and Shelf Life

12 months at 25°C. Subject to re-inspection thereafter. Store in dry, shaded conditions away from sources of heat and ignition.

Substrate Preparation

Abrasive blast corroded steelwork to remove rust and provide Class 2½ finish. If oxidation has occurred between blasting and application of the primer, the surface should be re-blasted to the specified visual standard.

Paint System

Coat	Colour	Product	Binder	Thinners	Application Method	Volume Solids %	WFT (Microns)	DFT (Microns)	Over Coat Interval at 25°C	Pot Life at 25°C
1	Grey	Interzinc 52	Polyamide cured epoxy	GTA220	Airless Spray, Brush & Air Spray	59	127	75	3 Hours	5 Hours
2	Black	Interplus 356	Polyamide adduct cured epoxy	GTA220		70	143	100	4 Hours – 24 Days	2 Hours
3	Final	Interthane 870	Polyurethane	GTA713		56	180	100	4 Hours	2 Hours
							Total DFT Thickness	**275**		

Etching Process between coats

Clean the paint down between each coat with thinners to etch the coat before applying the next coat. Allow the thinners to dry before applying the protective coating.

Paint Procedure

1. Abrasive blast corroded steelwork to remove rust and provide Class 2½ finish. If oxidation has occurred between blasting and application of the primer, the surface should be re-blasted to the specified visual standard.
2. Stripe coat all edges, rivets, bolts and intersections with Interzinc 52.
3. Apply one coat of Interzinc 52 with a dry film thickness of 75 microns.
4. Wait for the Interzinc 52 to achieve the recoat time.
5. Etch previous coat with thinners before applying next coat.
6. Allow the thinners to dry before applying the protective coating.
7. Stripe coat all edges, rivets, bolts and intersections with Interplus 356.
8. Apply one coat of Interplus 356 with a dry film thickness of 100 microns.
9. Etch previous coat with thinners before applying next coat.
10. Wait for the Interplus 356 to achieve the recoat time.
11. Allow the thinners to dry before applying the protective coating.
12. Stripe coat all edges, rivets, bolts and intersections with Interthane 870.
13. Apply one coat of Interthane 870 with a dry film thickness of 75 microns.

Paint Application

When applying paint by spray, low pressure and high volume spray systems shall be used, as these systems limit the risk of overspray.

Determination of Wet Film Thickness

The wet film thickness measurements supplied by the paint manufacturer is based on no thinners being added to the paint.

If thinners are added to the paint, then the following formula must be used to determine the wet film thickness.

WFT = DFT x (100 + % thinner added) ÷ % VS

4.1.7 Carboline Paint System – Polyurethane Top Coat

Storage of Paint Requirements and Shelf Life

12 months at 25°C. Subject to re-inspection thereafter. Store in dry, shaded conditions away from sources of heat and ignition.

Substrate Preparation

Abrasive blast corroded steelwork to remove rust and provide Class 2½ finish. If oxidation has occurred between blasting and application of the primer, the surface should be re-blasted to the specified visual standard.

Paint System

Coat	Colour	Product	Binder	Thinners	Application Method	Volume Solids %	WFT (Microns)	DFT (Microns	Over Coat Interval at 25°C	Pot Life at 25°C
1	Grey	Carbozinc 858	Zinc Rich Epoxy	#2	Brush & Spray	64	117	75	2 h	4 Hours
2	Miox	Carboguard 636XT	Cross Linked Pure Miox Epoxy	#12	Airless Spray, Brush & Air Spray	81	247	200	6 Hours – 5 Days	
3	Final Colour	Carbothane 134HG	Acrylic epoxy Polyurethane	#25		70	100	70	4 Hours	3 Hours
							Total DFT Thickness	**345**		

Etching Process between coats

Clean the paint down between each coat with thinners to etch the coat before applying the next coat. Allow the thinners to dry before applying the protective coating.

Paint Procedure

1. Degrease in accordance with MRTS88 to remove all soluble contamination.
2. Abrasive blast corroded steelwork to remove rust and provide Class 2½ finish. Blast profile should be between 35 µm to 50 µm. If oxidation has occurred between blasting and application of the primer, the surface should be re-blasted to the specified visual standard.
3. Stripe coat all edges, rivets, bolts and intersections with Carbozinc 858.
4. Apply one coat of Carbozinc 858 with a dry film thickness of 75 microns.
5. Wait for the Carbozinc 858 to achieve the recoat time.
6. Clean the coat down with thinners to etch the coating before applying the next coat.
7. Allow the thinners to dry before applying the protective coating.
8. Stripe coat all edges, rivets, bolts and intersections with Carbomastic 615.
9. Apply one coat of Carbomastic 615 with a dry film thickness of 200 microns.
10. Wait for the Carbomastic 615 to achieve the recoat time.
11. Clean the coat down with thinners to etch the coating before applying the next coat.
12. Allow the thinners to dry before applying the protective coating.
13. Stripe coat all edges, rivets, bolts and intersections with Carbothane 134HG
14. Apply one coat of Carbothane 134HG with a dry film thickness of 70 microns.
15. Wait for the Carbothane 134HG to achieve the recoat time.
16. Clean the coat down with thinners to etch the coating before applying the next coat.
17. Allow the thinners to dry before applying the protective coating.
18. Apply part coat of Carbothane 134HG to areas where the coating thickness is low.

Paint Application

When applying paint by spray, low pressure and high volume spray systems shall be used, as these systems limit the risk of overspray.

Determination of Wet Film Thickness

The wet film thickness measurements supplied by the paint manufacturer is based on no thinners being added to the paint.

If thinners are added to the paint, then the following formula must be used to determine the wet film thickness.

WFT = DFT x (100 + % thinner added) ÷ % VS

4.1.8 International Paint System – Polyaspartic Top Coat

Storage of Paint Requirements and Shelf Life

12 months at 25°C. Subject to re-inspection thereafter. Store in dry, shaded conditions away from sources of heat and ignition.

Substrate Preparation

Abrasive blast corroded steelwork to remove rust and provide Class 2½ finish. If oxidation has occurred between blasting and application of the primer, the surface should be re-blasted to the specified visual standard.

Paint System

Coat	Colour	Product	Binder	Thinners	Application Method	Volume Solids %	WFT (Microns)	DFT (Microns)	Over Coat Interval at 25°C	Pot Life at 25°C
1	Grey	Interzinc 52	Polyamide cured epoxy	GTA220	Airless Spray, Brush & Air Spray	59	127	75	3 Hours	5 Hours
2	Final Colour	Intercure 99	Polyaspartic	GTA713		80	250	225	1.5 Hours	45 Minutes
							Total DFT Thickness	**300**		

Etching Process between coats

Clean the paint with thinners to etch each coat before applying the next coat. Allow the thinners to dry before applying the protective coating.

Paint Procedure

1. Degrease in accordance with MRTS88 to remove all soluble contamination.
2. Abrasive blast corroded steelwork to remove rust and provide Class 2½ finish. Blast profile should be between 40 µm and 70 µm. If oxidation has occurred between blasting and application of the primer, the surface should be re-blasted to the specified visual standard.
3. Stripe coat all edges, rivets, bolts and intersections with Interzinc 52
4. Apply 1 coat of Interzinc 52 with a dry film thickness of 75 microns.
5. Wait for the Interzinc 52 to achieve the recoat time.
6. Clean the coat down with thinners to etch the coating before applying the next coat.
7. Stripe coat all edges, rivets, bolts and intersections with Intercure 99.
8. Apply 1 coat of Intercure 99 with a dry film thickness of 225 microns.

Paint Application

When applying paint by spray, low pressure and high volume spray systems shall be used, as these systems limit the risk of overspray.

Determination of Wet Film Thickness

The wet film thickness measurements supplied by the paint manufacturer is based on no thinners being added to the paint.

If thinners are added to the paint, then the following formula must be used to determine the wet film thickness.

WFT = DFT x (100 + % thinner added) ÷ % VS

4.1.9 Dulux Paint System – Polyurethane Top Coat

Storage of Paint Requirements and Shelf Life

12 months at 25°C. Subject to re-inspection thereafter. Store in dry, shaded conditions away from sources of heat and ignition.

Substrate Preparation

Abrasive blast corroded steelwork to remove rust and provide Class 2½ finish. If oxidation has occurred between blasting and application of the primer, the surface should be re-blasted to the specified visual standard.

Paint System

Coat	Colour	Product	Binder	Thinners	Application Method	Volume Solids %	WFT (Microns)	DFT (Microns)	Over Coat Interval at 25°C	Pot Life at 25°C
1	Green / Grey	Zincanode 402	Zinc-rich epoxy	Dulux Epoxy Thinner	Airless Spray, Brush & Air Spray	48	155	75	5 Hours	8 Hours
2	Grey	Duremax GPE	Polyamine adduct cured epoxy	Dulux Epoxy Thinner		72	280	200	3 Hours – 4 Weeks	90 Minutes
3	Final Colour	Weathermax HBR	Polyurethane	Duthin 040		70	110	75	10 Hours	2 Hours
							Total DFT Thickness	**350**		

Etching Process between coats

Clean the paint with thinners to etch each coat before applying the next coat. Allow the thinners to dry before applying the protective coating.

Paint Procedure

1. Abrasive blast corroded steelwork to remove rust and provide Class 2½ finish. If oxidation has occurred between blasting and application of the primer, the surface should be re-blasted to the specified visual standard.
2. Stripe coat all edges, rivets, bolts and intersections with Zincanode 402.
3. Apply one coat of Zincanode 402 with a dry film thickness of 75 microns.
4. Wait for the Zincanode 402 to achieve the recoat time.
5. Etch previous coat with thinners before applying next coat.
6. Allow the thinners to dry before applying the protective coating.
7. Stripe coat all edges, rivets, bolts and intersections with Duremax GPE.
8. Apply one coat of Duremax GPE with a dry film thickness of 200 microns.
9. Wait for the Duremax GPE to achieve the recoat time.
10. Etch previous coat with thinners before applying next coat.
11. Allow the thinners to dry before applying the protective coating.
12. Stripe coat all edges, rivets, bolts and intersections with Weathermax HBR.
13. Apply one coat of Weathermax HBR with a dry film thickness of 75 microns.

Paint Application

When applying paint by spray, low pressure and high volume spray systems shall be used, as these systems limit the risk of overspray.

Determination of Wet Film Thickness

The wet film thickness measurements supplied by the paint manufacturer is based on no thinners being added to the paint.

If thinners are added to the paint, then the following formula must be used to determine the wet film thickness.

WFT = DFT x (100 + % thinner added) ÷ % VS

4.1.10 Zinga Paint System – Polyurethane Top Coat

Storage of Paint Requirements and Shelf Life

12 months at 25°C. Subject to re-inspection thereafter. Store in dry, shaded conditions away from sources of heat and ignition.

Substrate Preparation

Round off all sharp edges and corners leaving a 2 mm radius. All areas to be cleaned thoroughly, as required, to remove oil, grease, salts and contamination etc. in accordance to AS 1627.1-2003. All areas to be abrasive blast cleaned to AS 1627.4 Class Sa 2½. (Jagged angular profile of 50 – 70 µm is required). Commence application before the surface preparation quality deteriorates and in any event within 4 hours. If any rust back has occurred between blasting and application of the primer, the surface should be re-blasted to the specified visual standard.

Paint System

Coat	Colour	Product	Binder	Thinners	Application Method	Volume Solids %	WFT (Microns)	DFT (Microns)	Over Coat Interval at 25°C	Pot Life at 25°C
1	Grey	Zinga	Type 2A thermoplastic	ZingaSolv	Airless, Brush, or Air spray	58	103	60	6 Hours	N/A
2	Grey	Zingaceram HS	Epoxy	HS Thinner	Airless, Brush, Roller or Air spray	78	154	120	8 Hours	2.5 hours
3	Final Colour	Zingaceram PU	Hydroxylated acrylic resins combined with aliphatic polyisocyanate	PU Thinner	Airless, Brush, Roller or Air spray	55	145	80	11 Hours	2.5 hours
							Total DFT Thickness	**260**		

Etching Process between coats

Inter-coat etching is not required. Pressure washing is necessary if contamination has occurred.

Paint Procedure

1. After preliminary cleaning has been completed abrasive blast steelwork to provide Class Sa 2½ finish.
2. Surfaces shall be clean, dedusted according to the standard ISO 8502-3 (Class 2) and completely free of surface contamination, with no visible surface moisture before painting.
3. Allowable chloride levels must not exceed 40 mg/m².
4. All crevices, welds, bolts, rivets, holes and edges shall be stripe coated by brush.
5. Apply one coat of Zinga with a dry film thickness of 60 µm.
6. Ensure surface is free of contamination before application of intermediate coat. Respect minimum recoat time and ensure all areas have dried to a consistent light grey before application.
7. Apply one coat of Zingaceram HS using mist coat / full coat technique with a total dry film thickness of 120 µm.
8. Ensure surface is free of contamination before application of top coat. Respect minimum recoat time.
9. Apply one coat of Zingaceram PU with a dry film thickness of 80 µm.

The above must be read in conjunction with the Zinga and Zingaceram HS and PU Technical Data Sheets.

Paint Application

Brush, roller, airless or airspray. Refer to Zinga, Zingaceram HS and PU Technical Data Sheets for details.

Determination of Wet Film Thickness

The wet film thickness measurements supplied by the paint manufacturer is based on no thinners being added to the paint.

If thinners are added to the paint, then the following formula must be used to determine the wet film thickness.

WFT = DFT x (100 + % thinner added) ÷ % VS

4.1.11 MCU Coatings Paint System – Aliphatic Polyurea Top Coat

Storage of Paint Requirements and Shelf Life

15 months from date of manufacture if stored unopened between -5 C & 30°C in a cool, dry place.

Substrate Preparation

Abrasive blast corroded steelwork to remove rust and provide a Class Sa 2½ surface finish. If oxidation has occurred between blasting and application of the primer, the surface should be re-blasted to the specified visual standard.

Paint System

Coat	Colour	Product	Binder	Thinners	Application Method	Volume Solids %	WFT (Microns)	DFT (Microns)	Over Coat Interval at 25°C	Pot Life at 25°C
1	Grey	MCU-Zinc	Aromatic polyurea	MCU-Thinner	Airless, Brush, Roller or Air spray	70	253	170	3 Hours	N/A
2	Final Colour	MCU-Miotopcoat	Aliphatic polyurea	MCU-Thinner	Airless, Brush, Roller or Air spray	63	143	90	5 Hours	N/A
							Total DFT Thickness	**260**		

Shorter overcoat intervals possible with MCU-Quickcure

Etching Process between coats

Ensure the surface is free of contamination before application of subsequent coats.

Paint Procedure

1. After preliminary cleaning has been completed abrasive blast steelwork to provide Class Sa 2½ finish.
2. Surfaces shall be clean, dedusted according to the standard ISO 8502-3 (Class 2), and completely free of surface contamination, with no visible surface moisture before painting.
3. All crevices, welds, bolts, rivets, holes, and edges shall be stripe coated by brush with MCU-Zinc.
4. Apply one coat of MCU-Zinc with a dry film thickness of 170 µm.
5. Ensure the surface is free of contamination before application of the top coat. Respect the minimum recoat time and ensure all areas have dried to a consistent colour before application.
6. Apply one coat of MCU-Miotopcoat with a dry film thickness of 90 µm.

MCU-Coatings are single component and as such do not require mixing of 2 components, or a 10 minute induction time.

The dry film thickness specified can easily be achieved by roller or spray technique.

The above must be read in conjunction with the relevant MCU-Coatings Technical Data Sheets and application guide.

Paint Application

When applying paint by spray, low pressure and high volume spray systems shall be used, as these systems limit the risk of overspray.

Determination of Wet Film Thickness

The wet film thickness measurements supplied by the paint manufacturer is based on no thinners being added to the paint.

If thinners are added to the paint, then the following formula must be used to determine the wet film thickness.

WFT = DFT x (100 + % thinner added) ÷ % VS

4.1.12 MCU Coatings Paint System – Aliphatic Polyurea Top Coat

Storage of Paint Requirements and Shelf Life

15 months from date of manufacture if stored unopened between -5 C & 30°C in a cool, dry place.

Substrate Preparation

Abrasive blast corroded steelwork to remove rust and provide a Class Sa 2½ surface finish. If oxidation has occurred between blasting and application of the primer, the surface should be re-blasted to the specified visual standard.

Paint System

Coat	Colour	Product	Binder	Thinners	Application Method	Volume Solids %	WFT (Microns)	DFT (Microns)	Over Coat Interval at 25°C	Pot Life at 25°C
1	Grey	MCU-Miozinc	Aromatic polyurea	MCU-Thinner	Airless, Brush, Roller or Air spray	72	104	75	3 Hours	N/A
2	light & dark grey	MCU-Miomastic	Aromatic polyurea	MCU-Thinner	Airless, Brush, Roller or Air spray	72	104	75	3 Hours	N/A
3	Final Colour	MCU-Topcoat	Aliphatic polyurea	MCU-Thinner	Airless, Brush, Roller or Air spray	64	117	75	5 Hours	N/A
							Total DFT Thickness	**225**		

Shorter overcoat intervals possible with MCU-Quickcure

Etching Process between coats

Ensure the surface is free of contamination before application of subsequent coats.

Paint Procedure

1. After preliminary cleaning has been completed abrasive blast steelwork to provide Class Sa 2½ finish.
2. Surfaces shall be clean, dedusted according to the standard ISO 8502-3 (Class 2), and completely free of surface contamination, with no visible surface moisture before painting.
3. All crevices, welds, bolts, rivets, holes, and edges shall be stripe coated by brush with MCU-Zinc.
4. Apply one coat of MCU-Zinc with a dry film thickness of 75 µm.
5. Ensure the surface is free of contamination before application of the intermediate coat. Respect the minimum recoat time and ensure all areas have dried to a consistent colour before application.
6. All crevices, welds, bolts, rivets, holes, and edges shall be stripe coated by brush with MCU-Miomastic.
7. Apply one coat of MCU-Miomastic using mist coat / full coat technique with a dry film thickness of 75 µm.
8. Ensure surface is free of contamination before application of topcoat. Respect the minimum recoat time.
9. Apply one coat of MCU-Topcoat with a dry film thickness of 75 µm.

MCU-Coatings are single component and as such do not require mixing of 2 components, or a 10 minute induction time.

The dry film thickness specified can easily be achieved by roller or spray technique.

The above must be read in conjunction with the relevant MCU-Coatings Technical Data Sheets and application guide.

Paint Application

When applying paint by spray, low pressure and high volume spray systems shall be used, as these systems limit the risk of overspray.

Determination of Wet Film Thickness

The wet film thickness measurements supplied by the paint manufacturer is based on no thinners being added to the paint.

If thinners are added to the paint, then the following formula must be used to determine the wet film thickness.

WFT = DFT x (100 + % thinner added) ÷ % VS

4.1.13 MCU Coatings Paint System – Aliphatic Polyurea Top Coat

Storage of Paint Requirements and Shelf Life

15 months from date of manufacture if stored unopened between -5°C & 30°C in a cool, dry place.

Substrate Preparation

Abrasive blast corroded steelwork to remove rust and provide a Class Sa 2½ surface finish. If oxidation has occurred between blasting and application of the primer, the surface should be re-blasted to the specified visual standard.

Paint System

Coat	Colour	Product	Binder	Thinners	Application Method	Volume Solids %	WFT (Microns)	DFT (Microns)	Over Coat Interval at 25°C	Pot Life at 25°C
1	Grey	MCU-Miozinc	Aromatic polyurea	MCU-Thinner	Airless, Brush, Roller or Air spray	72	236	170	3 Hours	N/A
2	Aluminium	MCU-Aluprime	Aromatic polyurea	MCU-Thinner	Brush	76	N/A	N/A	5 Hours	N/A
3	Final Colour	MCU-Miotopcoat	Aliphatic polyurea	MCU-Thinner	Airless, Brush, Roller or Air spray	63	143	90	5 Hours	N/A
							Total DFT Thickness	**260**		

Shorter overcoat intervals possible with MCU-Quickcure

Etching Process between coats

Ensure the surface is free of contamination before application of subsequent coats**.**

Paint Procedure

1. After preliminary cleaning has been completed abrasive blast steelwork to provide Class Sa 2½ finish.
2. Surfaces shall be clean, dedusted according to the standard ISO 8502-3 (Class 2), and completely free of surface contamination, with no visible surface moisture before painting.
3. All crevices, welds, bolts, rivets, holes, and edges shall be stripe coated by brush with MCU-Miozinc.
4. Apply one coat of MCU-Miozinc with a dry film thickness of 170 µm.
5. All crevices, welds, bolts, rivets, holes, and edges shall be stripe coated by brush with MCU-Aluprime.
6. Ensure the surface is free of contamination before application of the top coat. Respect the minimum recoat time and ensure all areas have dried to a consistent colour before application.
7. Apply one coat of MCU-Miotopcoat with a dry film thickness of 90 µm.

MCU-Coatings are single component and as such do not require mixing of 2 components, or a 10 minute induction time.

The dry film thickness specified can easily be achieved by roller or spray technique.

The above must be read in conjunction with the relevant MCU-Coatings Technical Data Sheets and application guide.

Paint Application

When applying paint by spray, low pressure and high volume spray systems shall be used, as these systems limit the risk of overspray.

Determination of Wet Film Thickness

The wet film thickness measurements supplied by the paint manufacturer is based on no thinners being added to the paint.

If thinners are added to the paint, then the following formula must be used to determine the wet film thickness.

WFT = DFT x (100 + % thinner added) ÷ % VS

4.1.14 MCU Coatings Paint System – Aliphatic Polyurea Top Coat

Storage of Paint Requirements and Shelf Life

15 months from date of manufacture if stored unopened between -5°C & 30°C in a cool, dry place.

Substrate Preparation

Abrasive blast corroded steelwork to remove rust and provide a Class Sa 2½ surface finish. If oxidation has occurred between blasting and application of the primer, the surface should be re-blasted to the specified visual standard.

Paint System

Coat	Colour	Product	Binder	Thinners	Application Method	Volume Solids %	WFT (Microns)	DFT (Microns)	Over Coat Interval at 25°C	Pot Life at 25°C
1	Grey	MCU-Miozinc	Aromatic polyurea	MCU-Thinner	Airless, Brush, Roller or Air spray	72	263	170	3 Hours	N/A
2	Final Colour	MCU-Miotopcoat	Aliphatic polyurea	MCU-Thinner	Airless, Brush, Roller or Air spray	63	143	90	5 Hours	N/A
							Total DFT Thickness	**260**		

Shorter overcoat intervals possible with MCU-Quickcure

Etching Process between coats

Ensure the surface is free of contamination before application of subsequent coats.

Paint Procedure

1. After preliminary cleaning has been completed abrasive blast steelwork to provide Class Sa 2½ finish.
2. Surfaces shall be clean, dedusted according to the standard ISO 8502-3 (Class 2), and completely free of surface contamination, with no visible surface moisture before painting.
3. All crevices, welds, bolts, rivets, holes, and edges shall be stripe coated by brush with MCU-Zinc.
4. Apply one coat of MCU-Miozinc with a dry film thickness of 170 µm.
5. Ensure the surface is free of contamination before application of the final coat. Respect the minimum recoat time and ensure all areas have dried to a consistent colour before application.
6. Apply one coat of MCU-Miotopcoat with a dry film thickness of 90 µm.

MCU-Coatings are single component and as such do not require mixing of 2 components, or a 10 minute induction time.

The dry film thickness specified can easily be achieved by roller or spray technique.

The above must be read in conjunction with the relevant MCU-Coatings Technical Data Sheets and application guide.

Paint Application

When applying paint by spray, low pressure and high volume spray systems shall be used, as these systems limit the risk of overspray.

Determination of Wet Film Thickness

The wet film thickness measurements supplied by the paint manufacturer is based on no thinners being added to the paint.

If thinners are added to the paint, then the following formula must be used to determine the wet film thickness.

WFT = DFT x (100 + % thinner added) ÷ % VS

4.1.15 Jotun Paint System – Polyurethane Top Coat

Storage of Paint Requirements and Shelf Life

12 months at 25°C. Subject to re-inspection thereafter. Store in dry, shaded conditions away from sources of heat and ignition.

Substrate Preparation

Surfaces to be coated shall be degreased to ISO 12944-4, Part 6.1.4 *Alkaline Cleaning*, and abrasive blast cleaned to Sa 2½ (ISO 8501-1) with a minimum surface profile 45 µm, grade Fine to Medium G, Ry5 (ISO 8503-2).

Paint System

Coat	Colour	Product	Binder	Thinners	Application Method	Volume Solids %	WFT (Microns)	DFT (Microns)	Over Coat Interval at 25°C	Pot Life at 25°C
1	Grey	Barrier	Zinc Rich Epoxy	#17	Airless Spray, Brush & Air Spray	53	142	75	1.5 Hours	24 Hours
2	Final	HardTop AX	Polyurethane	#26, #10		63	127	80	5 Hours	2 Hours
Total DFT Thickness								**155**		

Etching Process between coats

Clean the paint with thinners to etch each coat before applying the next coat. Allow the thinners to dry before applying the protective coating.

Paint Procedure

1. Abrasive blast corroded steelwork to remove rust and provide Class 2½ finish minimum surface profile 45µm. If oxidation has occurred between blasting and application of the primer, the surface should be re-blasted to the specified visual standard.
2. Before every full coat; a stripe coat; should be applied by brush on all edges; corners; welding seams and other areas difficult to reach; in order to build up the dry film thickness on these areas. Brush should be used on welding seams; edges and corners. Rollers must only be used for scallops and ratholes.
3. Apply one coat of Barrier with a dry film thickness of 75 microns.
4. Wait for the Barrier to achieve the recoat time.
5. Etch previous coat with thinners before applying next coat if applicable.
6. Apply one coat of Hardtop AX with a dry film thickness of 80 microns.

Paint Application

When applying paint by spray, low pressure and high volume spray systems shall be used, as these systems limit the risk of overspray.

Determination of Wet Film Thickness

The wet film thickness measurements supplied by the paint manufacturer is based on no thinners being added to the paint.

If thinners are added to the paint, then the following formula must be used to determine the wet film thickness.

WFT = DFT x (100 + % thinner added) ÷ % VS

4.1.16 Jotun Paint System – Polyurethane Top Coat

Storage of Paint Requirements and Shelf Life

12 months at 25°C. Subject to re-inspection thereafter. Store in dry, shaded conditions away from sources of heat and ignition.

Substrate Preparation

Surfaces to be coated shall be degreased to ISO 12944-4, Part 6.1.4 *Alkaline Cleaning*, and abrasive blast cleaned to Sa 2½ (ISO 8501-1) with a minimum surface profile 45 µm, grade Fine to Medium G, Ry5 (ISO 8503-2).

Paint System

Coat	Colour	Product	Binder	Thinners	Application Method	Volume Solids %	WFT (Microns)	DFT (Microns)	Over Coat Interval at 25°C	Pot Life at 25°C
1	Grey	Barrier	Zinc Rich Epoxy	#17	Airless Spray, Brush & Air Spray	53	142	75	1.5 Hours	24 Hours
2	Final	HardTop Flexi	Polyurethane	#10		64	125	80	3 Hours	1 Hours
Total DFT Thickness								**155**		

Etching Process between coats

Clean the paint with thinners to etch each coat before applying the next coat. Allow the thinners to dry before applying the protective coating.

Paint Procedure

1. Abrasive blast corroded steelwork to remove rust and provide Class 2½ finish minimum surface profile 45µm. If oxidation has occurred between blasting and application of the primer, the surface should be re-blasted to the specified visual standard.
2. Before every full coat; a stripe coat; should be applied by brush on all edges; corners; welding seams and other areas difficult to reach; in order to build up the dry film thickness on these areas. Brush should be used on welding seams; edges and corners. Rollers must only be used for scallops and ratholes.
3. Apply one coat of Barrier with a dry film thickness of 75 microns.
4. Wait for the Barrier to achieve the recoat time.
5. Etch previous coat with thinners before applying next coat if applicable.
6. Allow the thinners to dry before applying the protective coating.
7. Apply one coat of Hardtop Flexi with a dry film thickness of 80 microns.

Paint Application

When applying paint by spray, low pressure and high volume spray systems shall be used, as these systems limit the risk of overspray.

Determination of Wet Film Thickness

The wet film thickness measurements supplied by the paint manufacturer is based on no thinners being added to the paint.

If thinners are added to the paint, then the following formula must be used to determine the wet film thickness.

WFT = DFT x (100 + % thinner added) ÷ % VS

4.1.17 Jotun Paint System – Polysiloxane Top Coat

Storage of Paint Requirements and Shelf Life

12 months at 25°C. Subject to re-inspection thereafter. Store in dry, shaded conditions away from sources of heat and ignition.

Substrate Preparation

Surfaces to be coated shall be degreased to ISO 12944-4, Part 6.1.4 *Alkaline Cleaning*, and abrasive blast cleaned to Sa 2½ (ISO 8501-1) with a minimum surface profile 45 µm, grade Fine to Medium G, Ry5 (ISO 8503-2).

Paint System

Coat	Colour	Product	Binder	Thinners	Application Method	Volume Solids %	WFT (Microns)	DFT (Microns)	Over Coat Interval at 25°C	Pot Life at 25°C
1	Grey	Barrier	Zinc Rich Epoxy	#17	Airless Spray, Brush & Air Spray	53	142	75	1.5 Hours	24 Hours
2	Final	HardTop Optima	Polysiloxane	#7, #17, #10		76	130	100	4 Hours	6 Hours
Total DFT Thickness								**175**		

Etching Process between coats

Clean the paint with thinners to etch each coat before applying the next coat. Allow the thinners to dry before applying the protective coating.

Paint Procedure

1. Abrasive blast corroded steelwork to remove rust and provide Class 2½ finish minimum surface profile 45µm. If oxidation has occurred between blasting and application of the primer, the surface should be re-blasted to the specified visual standard.
2. Before every full coat; a stripe coat; should be applied by brush on all edges; corners; welding seams and other areas difficult to reach; in order to build up the dry film thickness on these areas. Brush should be used on welding seams; edges and corners. Rollers must only be used for scallops and ratholes.
3. Apply one coat of Barrier with a dry film thickness of 75 microns.
4. Wait for the Barrier to achieve the recoat time.
5. Etch previous coat with thinners before applying next coat if applicable.
6. Allow the thinners to dry before applying the protective coating.
7. Apply one coat of Penguard Universal with a dry film thickness of 175 microns.

Paint Application

When applying paint by spray, low pressure and high volume spray systems shall be used, as these systems limit the risk of overspray.

Determination of Wet Film Thickness

The wet film thickness measurements supplied by the paint manufacturer is based on no thinners being added to the paint.

If thinners are added to the paint, then the following formula must be used to determine the wet film thickness.

WFT = DFT x (100 + % thinner added) ÷ % VS

4.1.18 Jotun Paint System – Polysiloxane Top Coat

Storage of Paint Requirements and Shelf Life

12 months at 25°C. Subject to re-inspection thereafter. Store in dry, shaded conditions away from sources of heat and ignition.

Substrate Preparation

Surfaces to be coated shall be degreased to ISO 12944-4, Part 6.1.4 *Alkaline Cleaning*, and abrasive blast cleaned to Sa 2½ (ISO 8501-1) with a minimum surface profile 45 µm, grade Fine to Medium G, Ry5 (ISO 8503-2).

Paint System

Coat	Colour	Product	Binder	Thinners	Application Method	Volume Solids %	WFT (Microns)	DFT (Microns)	Over Coat Interval at 25°C	Pot Life at 25°C
1	Grey	Barrier	Zinc Rich Epoxy	#17	Airless Spray, Brush & Air Spray	53	142	75	1.5 Hours	24 Hours
2	Grey/ White	Penuard Universal	Polyamide Cured Epoxy	#17		72	243	175	4 Hours	2 Hours
3	Final	HardTop Optima	Polysiloxane	#7, #17, #10		76	130	100	4 Hours	6 Hours
Total DFT Thickness								**350**		

Etching Process between coats

Clean the paint with thinners to etch each coat before applying the next coat. Allow the thinners to dry before applying the protective coating.

Paint Procedure

1. Abrasive blast corroded steelwork to remove rust and provide Class 2½ finish minimum surface profile 45µm. If oxidation has occurred between blasting and application of the primer, the surface should be re-blasted to the specified visual standard.
2. Before every full coat; a stripe coat; should be applied by brush on all edges; corners; welding seams and other areas difficult to reach; in order to build up the dry film thickness on these areas. Brush should be used on welding seams; edges and corners. Rollers must only be used for scallops and ratholes.
3. Apply one coat of Barrier with a dry film thickness of 75 microns.
4. Wait for the Barrier to achieve the recoat time.
5. Etch previous coat with thinners before applying next coat if applicable.
6. Allow the thinners to dry before applying the protective coating.
7. Apply one coat of Penguard Universal with a dry film thickness of 175 microns.

Paint Application

When applying paint by spray, low pressure and high volume spray systems shall be used, as these systems limit the risk of overspray.

Determination of Wet Film Thickness

The wet film thickness measurements supplied by the paint manufacturer is based on no thinners being added to the paint.

If thinners are added to the paint, then the following formula must be used to determine the wet film thickness.

WFT = DFT x (100 + % thinner added) ÷ % VS

4.1.19 Jotun Paint System – Polyurethane Top Coat

Storage of Paint Requirements and Shelf Life

12 months at 25°C. Subject to re-inspection thereafter. Store in dry, shaded conditions away from sources of heat and ignition.

Substrate Preparation

Surfaces to be coated shall be degreased to ISO 12944-4, Part 6.1.4 *Alkaline Cleaning*, and abrasive blast cleaned to Sa 2½ (ISO 8501-1) with a minimum surface profile 45 µm, grade Fine to Medium G, Ry5 (ISO 8503-2).

Paint System

Coat	Colour	Product	Binder	Thinners	Application Method	Volume Solids %	WFT (Microns)	DFT (Microns)	Over Coat Interval at 25°C	Pot Life at 25°C
1	Grey	Barrier	Zinc Rich Epoxy	#17	Airless Spray, Brush & Air Spray	53	142	75	1.5 Hours	24 Hours
2	Grey/ White	Penuard Universal	Polyamide Cured Epoxy	#17		72	243	175	4 Hours	2 Hours
3	Final	HardTop AX	Polyurethane	#26, #10		63	127	80	5 Hours	2 Hours
							Total DFT Thickness	**330**		

Etching Process between coats

Clean the paint with thinners to etch each coat before applying the next coat. Allow the thinners to dry before applying the protective coating.

Paint Procedure

1. Abrasive blast corroded steelwork to remove rust and provide Class 2½ finish minimum surface profile 45µm. If oxidation has occurred between blasting and application of the primer, the surface should be re-blasted to the specified visual standard.
2. Before every full coat; a stripe coat; should be applied by brush on all edges; corners; welding seams and other areas difficult to reach; in order to build up the dry film thickness on these areas. Brush should be used on welding seams; edges and corners. Rollers must only be used for scallops and ratholes.
3. Apply one coat of Barrier with a dry film thickness of 75 microns.
4. Wait for the Barrier to achieve the recoat time.
5. Etch previous coat with thinners before applying next coat if applicable.
6. Allow the thinners to dry before applying the protective coating.
7. Apply one coat of Penguard Universal with a dry film thickness of 175 microns.

Paint Application

When applying paint by spray, low pressure and high volume spray systems shall be used, as these systems limit the risk of overspray.

Determination of Wet Film Thickness

The wet film thickness measurements supplied by the paint manufacturer is based on no thinners being added to the paint.

If thinners are added to the paint, then the following formula must be used to determine the wet film thickness.
WFT = DFT x (100 + % thinner added) ÷ % VS

4.2 Paint Repair Systems

4.2.1 PPG Paint Repair System – Polysiloxane Top Coat

Storage of Paint Requirements and Shelf Life

12 months at 25°C. Subject to re-inspection thereafter. Store in dry, shaded conditions away from sources of heat and ignition.

Substrate Preparation

Abrasive blast corroded steelwork to remove rust and provide Class 2½ finish. If oxidation has occurred between blasting and application of the primer, the surface should be re-blasted to the specified visual standard.

Paint System

Coat	Colour	Product	Binder	Thinners	Application Method	Volume Solids %	WFT (Microns)	DFT (Microns)	Over Coat Interval at 25°C	Pot Life at 25°C
1	Grey	SigmaZinc 109HS	Zinc Rich Epoxy	91-92	Airless Spray, Brush & Air Spray	66	115	75	3 Hours	5 Hours
2	Final	PSX 700	Epoxy Siloxane	#140		89	140	125	3 Hours	3 Hours
							Total DFT Thickness	**200**		

Etching Process between coats

Clean the paint down between each coat with thinners to etch the coat before applying the next coat. Allow the thinners to dry before applying the protective coating.

Paint Procedure

Method 1. Minor damage to topcoat, (that is, no primer required)

1. All surfaces to be painted shall be cleaned by a degreasing or washing procedure (as per AS 1627.1) to remove all oils, salts, acids or any other contamination that may be present.
2. Sand the entire area smooth with 240 grit paper.
3. Remove sanding dust and then solvent wipe again with 140 Thinner.
4. Mix PSX 700 in accordance with the Product Data Sheet and allow to stand for 10 minutes before use.
5. Apply PSX 700 to achieve the specified dry film thickness using brush, roller or spray.

Method 2. Damage to topcoat and primer with bare metal exposed, (that is, primer required)

1. All surfaces to be painted shall be cleaned by a degreasing or washing procedure (as per AS 1627.1) to remove all oils, salts, acids or any other contamination that may be present.
2. Corroded or damaged areas: Power Tool Clean in accordance with AS 1627.2 St 3 (min).
3. Any sharp edges shall have a radius of 2 mm diameter minimum. Weld spatter, weld irregularities, burr marks, laminations etc. must be removed.
4. Existing coating to be coated: abrade the entire surface to provide a roughened uniform matt appearance.
5. Feather all edges. Remove all preparation residue. Prepared surfaces shall be primed as soon as practical after preparation and before the surface deteriorates or becomes contaminated.
6. Spot prime prepared corroded areas with the specified primer overlapping existing sound coating by a minimum of 50 mm.
7. Prime and topcoat the total prepared area in accordance with the specification and the respective Product Data Sheets.

Note: Brush / roller application will require multiple coats to achieve the specified DFT requirements.

Paint Application

When applying paint by spray, low pressure and high volume spray systems shall be used, as these systems limit the risk of overspray.

Determination of Wet Film Thickness

The wet film thickness measurements supplied by the paint manufacturer is based on no thinners being added to the paint.

If thinners are added to the paint, then the following formula must be used to determine the wet film thickness.

WFT = DFT x (100 + % thinner added) ÷ % VS

4.2.2 International Paint Repair System – Polysiloxane Top Coat

Storage of Paint Requirements and Shelf Life

12 months at 25°C. Subject to re-inspection thereafter. Store in dry, shaded conditions away from sources of heat and ignition.

Substrate Preparation

Abrasive blast corroded steelwork to remove rust and provide Class 2½ finish. If oxidation has occurred between blasting and application of the primer, the surface should be re-blasted to the specified visual standard.

Paint System

Coat	Colour	Product	Binder	Thinners	Application Method	Volume Solids %	WFT (Microns)	DFT (Microns	Over Coat Interval at 25°C	Pot Life at 25°C
1	Black	Interplus 356	Polyamide adduct cured epoxy	GTA 220	Airless Spray, Brush & Air Spray	70	150	100	4 Hours – 24 Days	2 Hours
2	Final	Interfine 878	Polysiloxane	GTA 007		72	104	75	4 Hours	2 Hours
							Total DFT Thickness	**175**		

Etching Process between coats

Clean the paint down between each coat with thinners to etch the coat before applying the next coat. Allow the thinners to dry before applying the protective coating.

Paint Procedure

1. All surfaces to be painted shall be cleaned by a degreasing or washing procedure (as per AS 1627.1) to remove all oils, salts, acids or any other contamination that may be present.
2. Sand the entire area smooth with 240 grit paper.
3. Remove sanding dust and then solvent wipe again with GTA220 Thinner.
4. Mix Interplus 356 in accordance with the Product Data Sheet and allow to stand for 10 minutes before use.
5. Apply Interplus 356 to achieve the specified dry film thickness using brush, roller or spray.
6. Mix Interfine 878 in accordance with the Product Data Sheet and allow to stand for 10 minutes before use.
7. Apply Interfine 878 to achieve the specified dry film thickness using brush, roller or spray.

Paint Application

When applying paint by spray, low pressure and high volume spray systems shall be used, as these systems limit the risk of overspray.

Determination of Wet Film Thickness

The wet film thickness measurements supplied by the paint manufacturer is based on no thinners being added to the paint.

If thinners are added to the paint, then the following formula must be used to determine the wet film thickness.

WFT = DFT x (100 + % thinner added) ÷ % VS

4.2.3 PPG Paint Repair System – Polyurethane Top Coat

Storage of Paint Requirements and Shelf Life

12 months at 25°C. Subject to re-inspection thereafter. Store in dry, shaded conditions away from sources of heat and ignition.

Substrate Preparation

Abrasive blast corroded steelwork to remove rust and provide Class 2½ finish. If oxidation has occurred between blasting and application of the primer, the surface should be re-blasted to the specified visual standard.

Where this is not practical, corroded or damaged areas must be Power Tool Cleaned in accordance with AS 1627.2 St 3 (min).

Paint System

Coat	Colour	Product	Binder	Thinners	Application Method	Volume Solids %	WFT (Microns)	DFT (Microns	Over Coat Interval at 25°C	Pot Life at 25°C
1	Grey (various)	SigmaCover 350	HS HB Polyamine cured epoxy	91-92	Airless Spray, Brush & Air Spray	72	140	100	5 Hours – 14 Days	2.5 Hours
2	Final	SigmaDur 550	Polyurethane	21-06		55	90	50	5 Hours	4 Hours
							Total DFT Thickness	**150**		

Etching Process between coats

Clean the paint down between each coat with thinners to etch the coat before applying the next coat. Allow the thinners to dry before applying the protective coating.

Paint Procedure

Method 1. Minor damage to topcoat (that is, no primer required)

1. All surfaces to be painted shall be cleaned by a degreasing or washing procedure (as per AS 1627.1) to remove all oils, salts, acids or any other contamination that may be present.
2. Sand the entire area smooth with 240 grit paper.
3. Remove sanding dust and then solvent wipe again with 140 Thinner.
4. Mix SigmaDur 550 in accordance with the Product Data Sheet and allow to stand for ten minutes before use.
5. Apply SigmaDur 550 to achieve the specified dry film thickness using brush, roller or spray.

Method 2. Damage to topcoat and primer with bare metal exposed (that is, primer required)

1. All surfaces to be painted shall be cleaned by a degreasing or washing procedure (as per AS 1627.1) to remove all oils, salts, acids or any other contamination that may be present.
2. Corroded or damaged areas: Power Tool Clean in accordance with AS 1627.2 St 3 (min).
3. Existing coating to be coated: Abrade the entire surface to provide a roughened uniform matt appearance.
4. Feather all edges. Remove all preparation residue. Prepared surfaces shall be primed as soon as practical after preparation and before the surface deteriorates or becomes contaminated.
5. Mix SigmaCover 350 in accordance with the Product Data Sheet and allow to stand for ten minutes before use.
6. Spot prime prepared corroded areas with SigmaCover 350 to achieve the specified dry film thickness using brush, roller or spray overlapping existing sound coating by a minimum of 50 mm.
7. Mix SigmaDur 550 in accordance with the Product Data Sheet and allow to stand for ten minutes before use.
8. Apply SigmaDur 550 to achieve the specified dry film thickness using brush, roller or spray to the total prepared area in accordance with the specification and the respective Product Data Sheets.

Note: Brush / roller application will require multiple coats to achieve the specified DFT requirements.

Paint Application

When applying paint by spray, low pressure and high volume spray systems shall be used, as these systems limit the risk of overspray.

Determination of Wet Film Thickness

The wet film thickness measurements supplied by the paint manufacturer is based on no thinners being added to the paint.

If thinners are added to the paint, then the following formula must be used to determine the wet film thickness.

WFT = DFT x (100 + % thinner added) ÷ % VS

4.2.4 International Paint Repair System – Polyurethane Top Coat

Storage of Paint Requirements and Shelf Life

12 months at 25°C. Subject to re-inspection thereafter. Store in dry, shaded conditions away from sources of heat and ignition.

Substrate Preparation

Abrasive blast corroded steelwork to remove rust and provide Class 2½ finish. If oxidation has occurred between blasting and application of the primer, the surface should be re-blasted to the specified visual standard.

Paint System

Coat	Colour	Product	Binder	Thinners	Application Method	Volume Solids %	WFT (Microns)	DFT (Microns)	Over Coat Interval at 25°C	Pot Life at 25°C
1	Black	Interplus 356	Polyamide adduct cured epoxy	GTA 220	Airless Spray, Brush & Air Spray	70	150	100	4 Hours – 24 Days	2 Hours
2	Final	Interthane 870	Polyurethane	GTA 713		56	180	100	4 Hours	2 Hours
							Total DFT Thickness	**200**		

Etching Process between coats

Clean the paint down between each coat with thinners to etch the coat before applying the next coat. Allow the thinners to dry before applying the protective coating.

Paint Procedure

1. All surfaces to be painted shall be cleaned by a degreasing or washing procedure (as per AS 1627.1) to remove all oils, salts, acids or any other contamination that may be present.
2. Sand the entire area smooth with 240 grit paper.
3. Remove sanding dust and then solvent wipe again with GTA220 Thinner.
4. Mix Interplus 356 in accordance with the Product Data Sheet and allow to stand for ten minutes before use.
5. Apply Interplus 356 to achieve the specified dry film thickness using brush, roller or spray.
6. Mix Interthane 870 in accordance with the Product Data Sheet and allow to stand for ten minutes before use.
7. Apply Interthane 870 to achieve the specified dry film thickness using brush, roller or spray.

Paint Application

When applying paint by spray, low pressure and high volume spray systems shall be used, as these systems limit the risk of overspray.

Determination of Wet Film Thickness

The wet film thickness measurements supplied by the paint manufacturer is based on no thinners being added to the paint.

If thinners are added to the paint, then the following formula must be used to determine the wet film thickness.

WFT = DFT x (100 + % thinner added) ÷ % VS

4.2.5 Carboline Paint Repair System – Polyurethane Top Coat

Storage of Paint Requirements and Shelf Life

12 months at 25°C. Subject to re-inspection thereafter. Store in dry, shaded conditions away from sources of heat and ignition.

Substrate Preparation

Abrasive blast corroded steelwork to remove rust and provide Class 3 finish. If oxidation has occurred between blasting and application of the primer, the surface should be re-blasted to the specified visual standard.

Paint System

Coat	Colour	Product	Binder	Thinners	Application Method	Volume Solids %	WFT (Microns)	DFT (Microns)	Over Coat Interval at 25°C	Pot Life at 25°C
1	Grey	Carbozinc 858	Zinc rich epoxy	#2	Brush & Spray	64	118	75	2 Hours	3 Hours
2	Miox	Carboguard 636XT	Cross Linked Pure Miox Epoxy	#12 Thinner	Airless Spray, Brush & Air Spray	81	247	200	6 Hours - 5 Days	4 Hours
3	Final	Carbothane 134HG	Acrylic epoxy polyurethane	#25		70	100	70	4 Hours	3 Hours
							Total DFT Thickness	**345**		

Etching Process between coats

Clean the paint down between each coat with thinners to etch the coat before applying the next coat. Allow the thinners to dry before applying the protective coating.

Paint Procedure

1. Degrease in accordance with MRTS88 to remove all soluble contamination.
2. Power tool clean the corroded or damaged area to provide Class 3 finish.
3. Feather back the edges to existing sound paint.
4. Spot prime with Carbozinc 858 with a dry film thickness of 75 microns.
5. Clean the coat down with thinners to etch the coating before applying the next coat.
6. Allow the thinners to dry before applying the protective coating.
7. Spot prime with Carboguard 636XT with a dry film thickness of 200 microns progressively lapping over original paint.
8. Clean the coat down with thinners to etch the coating before applying the next coat.
9. Allow the thinners to dry before applying the protective coating.

Paint Application

When applying paint by spray, low pressure and high volume spray systems shall be used, as these systems limit the risk of overspray.

Determination of Wet Film Thickness

The wet film thickness measurements supplied by the paint manufacturer is based on no thinners being added to the paint.

If thinners are added to the paint, then the following formula must be used to determine the wet film thickness.

WFT = DFT x (100 + % thinner added) ÷ % VS

4.2.6 International Paint Repair System – Polyaspartic Top Coat

Storage of Paint Requirements and Shelf Life

12 months at 25°C. Subject to re-inspection thereafter. Store in dry, shaded conditions away from sources of heat and ignition.

Substrate Preparation

Abrasive blast corroded steelwork to remove rust and provide Class 2½ finish. If oxidation has occurred between blasting and application of the primer, the surface should be re-blasted to the specified visual standard.

Paint System

Coat	Colour	Product	Binder	Thinners	Application Method	Volume Solids %	WFT (Microns)	DFT (Microns)	Over Coat Interval at 25°C	Pot Life at 25°C
1	Grey	Interzinc 52	Zinc rich epoxy	GTA 220	Airless Spray, Brush & Air Spray	59	127	75	3 Hours	5 Hours
2	Final	Intercure 99	Polyaspartic epoxy	GTA 713	Airless Spray & Air Spray	80	250	225	1.5 Hours	45 Minutes
							Total DFT Thickness	**300**		

Etching Process between coats

Clean the paint with thinners to etch each coat before applying the next coat. Allow the thinners to dry before applying the protective coating.

Paint Procedure

1. Degrease in accordance with MRTS88 to remove all soluble contamination.
2. Power tool clean the corroded or damaged area to provide Class 3 finish.
3. Feather back the edges to existing sound paint.
4. Spot prime with Interzinc 52 with a dry film thickness of 75 microns.
5. Clean the coat down with thinners to etch the coating before applying the next coat.
6. Spot repair with Intercure 99 with a dry film thickness of 225 microns progressively lapping over original paint.

Paint Application

When applying paint by spray, low pressure and high volume spray systems shall be used, as these systems limit the risk of overspray.

Determination of Wet Film Thickness

The wet film thickness measurements supplied by the paint manufacturer is based on no thinners being added to the paint.

If thinners are added to the paint, then the following formula must be used to determine the wet film thickness.

WFT = DFT x (100 + % thinner added) ÷ % VS

4.2.7 Dulux Paint Repair System – Polyurethane Top Coat

Storage of Paint Requirements and Shelf Life

12 months at 25°C. Subject to re-inspection thereafter. Store in dry, shaded conditions away from sources of heat and ignition.

Substrate Preparation

Abrasive blast corroded steelwork to remove rust and provide Class 2½ finish. If oxidation has occurred between blasting and application of the primer, the surface should be re-blasted to the specified visual standard.

Paint System

Coat	Colour	Product	Binder	Thinners	Application Method	Volume Solids %	WFT (Microns)	DFT (Microns)	Over Coat Interval at 25°C	Pot Life at 25°C
1	Green / Grey	Zincanode 402	Zinc-rich epoxy	Dulux Epoxy Thinner	Airless Spray, Brush & Air Spray	48	155	75	5 Hours	8 Hours
2	Grey	Duremax GPE	Polyamine adduct cured epoxy	Dulux Epoxy Thinner		72	280	200	3 Hours – 4 Weeks	90 Minutes
3	Final Colour	Weathermax HBR	Polyurethane	Duthin 040		70	110	75	10 Hours	2 Hours
							Total DFT Thickness	**350**		

Etching Process between coats

Clean the paint with thinners to etch each coat before applying the next coat. Allow the thinners to dry before applying the protective coating.

Paint Procedure

Method 1. Minor damage to topcoat (that is, no primer required)

1. All surfaces to be painted shall be cleaned by a degreasing or washing procedure (as per AS 1627.1) to remove all oils, salts, acids or any other contamination that may be present.
2. Sand the entire area smooth with 240 grit paper.
3. Remove sanding dust and then solvent wipe again with Dulux Polyurethane Thinner.
4. Apply Weathermax HBR to achieve the specified dry film thickness using brush, roller or spray.

Method 2. Damage to topcoat and primer with bare metal exposed (that is, primer required)

1. All surfaces to be painted shall be cleaned by a degreasing or washing procedure (as per AS 1627.1) to remove all oils, salts, acids or any other contamination that may be present.
2. Corroded or damaged areas: Power Tool Clean in accordance with AS 1627.2 St 3 (min).
3. Remove sanding dust and then solvent wipe again with Dulux Epoxy Thinner.
4. Apply Zincanode 402 to bare substrate to achieve the specified dry film thickness of 75 microns using brush roller or spray.
5. Apply Duremax GPE to achieve the specified dry film thickness of 200 microns using brush roller or spray.
6. Apply Weathermax HBR to achieve the specified dry film thickness of 75 microns using brush roller or spray.

Note: Brush / roller application may require multiple coats to achieve the specified DFT requirements.

Paint Application

When applying paint by spray, low pressure and high volume spray systems shall be used, as these systems limit the risk of overspray.

Determination of Wet Film Thickness

The wet film thickness measurements supplied by the paint manufacturer is based on no thinners being added to the paint.

If thinners are added to the paint, then the following formula must be used to determine the wet film thickness.

WFT = DFT x (100 + % thinner added) ÷ % VS

4.2.8 Zinga Paint Repair System – Polyurethane Top Coat

Storage of Paint Requirements and Shelf Life

12 months at 25°C. Subject to re-inspection thereafter. Store in dry, shaded conditions away from sources of heat and ignition.

Substrate Preparation

Refer to step-by-step procedure below.

Paint System

Coat	Colour	Product	Binder	Thinners	Application Method	Volume Solids %	WFT (Microns)	DFT (Microns)	Over Coat Interval at 25°C	Pot Life at 25°C
1	Grey	Zinga	Type 2A thermoplastic	ZingaSolv	Airless, Brush, or Air spray	58	103	60	6 Hours	N/A
2	Grey	Zingaceram HS	Epoxy	HS Thinner	Airless, Brush, Roller or Air spray	78	154	120	8 Hours	2.5 Hours
3	Final Colour	Zingaceram PU	Hydroxylated acrylic resins combined with aliphatic polyisocyanate	PU Thinner	Airless, Brush, Roller or Air spray	55	145	80	11 Hours	2.5 Hours
							Total DFT Thickness	**260**		

Etching Process between coats

Inter-coat etching is not required. Pressure washing is necessary if contamination has occurred.

Paint Procedure

Method 1. Minor damage to topcoat, (that is, no primer or intermediate coats required)

1. All surfaces to be painted shall be cleaned by degreasing or washing procedure (as per AS 1627.1) to remove all oils, grease, salts and any other contamination that may be present. This shall include an overlap area onto the sound existing coating. 50 mm is desirable.
2. Feather back any edges if present with 240 grit paper.
3. Remove sanding dust.
4. Apply Zingaceram PU to achieve the specified dry film thickness.

Method 2. Damage to topcoats with bare metal exposed, (that is, primer required)

1. All surfaces to be painted shall be cleaned by a degreasing or washing procedure (as per AS 1627.1) to remove all oils, grease, salts or any other contamination that may be present.
2. Corroded or damaged areas: Power Tool Clean in accordance with AS 1627.2 St 3 (min).
3. Any edges shall have a radius of 2 mm minimum. Weld spatter, weld irregularities, burr marks, laminations etc. must be removed.
4. Surfaces shall be clean, dedusted according to the standard ISO 8502-3 (Class 2) and completely free of surface contamination, with no visible surface moisture before painting. Allowable chloride levels must not exceed 40 mg/m².
5. Commence primer application before the surface preparation quality deteriorates and in any event within 4 hours.
6. Apply one coat of Zinga with a dry film thickness of 60 µm to prepared areas overlapping existing sound primer coat by a minimum of 50 mm.
7. Ensure surface is free of contamination before application of intermediate coat. Respect minimum recoat time and ensure all areas have dried to a consistent light grey before application.
8. Apply one coat of Zingaceram HS using mist coat / full coat technique with a total dry film thickness of 120 µm to primed areas overlapping existing sound top coat by a minimum of 50 mm.

9. Ensure surface is free of contamination before application of top coat. Respect minimum recoat time.
10. Apply one coat of Zingaceram PU with a total dry film thickness of 80 µm to primed areas overlapping existing sound top coat by a minimum of 50 mm.

The above must be read in conjunction with the Zinga and Zingaceram HS and PU Technical Data Sheets.

Paint Application

Brush, roller, airless or airspray. Refer to Zinga, Zingaceram HS and PU Technical Data Sheets for details.

Determination of Wet Film Thickness

The wet film thickness measurements supplied by the paint manufacturer is based on no thinners being added to the paint.

If thinners are added to the paint, then the following formula must be used to determine the wet film thickness.

WFT = DFT x (100 + % thinner added) ÷ % VS

4.2.9 MCU Coatings Paint Repair System – Aliphatic Polyurea Top Coat

Storage of Paint Requirements and Shelf Life

15 months from date of manufacture if stored unopened between -5°C & 30°C in a cool, dry place.

Substrate Preparation

Spot abrasive blast damaged coatings and corroded steelwork to provide a Class Sa 2½ surface finish. Where this is not practical, Power Tool Cleaning in accordance with AS 1627.2 St 3 (min)**Paint System**

Coat	Colour	Product	Binder	Thinners	Application Method	Volume Solids %	WFT (Microns)	DFT (Microns)	Over Coat Interval at 25°C	Pot Life at 25°C
1	Grey	MCU-Zinc	Aromatic polyurea	MCU-Thinner	Airless, Brush, Roller or Air spray	70	253	170	3 Hours	N/A
2	Final Colour	MCU-Miotopcoat	Aliphatic polyurea	MCU-Thinner	Airless, Brush, Roller or Air spray	63	143	90	5 Hours	N/A
							Total DFT Thickness	**260**		

Shorter overcoat intervals possible with MCU-Quickcure

Etching Process between coats

Ensure the surface is free of contamination before application of subsequent coats.

Paint Procedure

Damage to coating system with bare steel exposed.

1. Wash and degrease all surfaces as per AS 1627.1
2. Spot abrasive blast damaged coatings and corroded steelwork to provide a Class Sa 2½ surface finish. Where this is not practical, Power Tool Cleaning in accordance with AS1627.2 St 3 (min)
3. Abrade the entire remaining surface with 240 grit paper.
4. Feather all edges. Remove sanding dust and ensure the surface is free of contamination. Prime the prepared surfaces as soon as practical and before the surface deteriorates or becomes contaminated.
5. Spot prime the corroded areas that have been prepared as above with MCU-Zinc, to achieve the 170 µm dry film thickness using brush, roller or spray overlapping existing sound coating by a minimum of 50 mm.
6. Apply MCU-Miotopcoat to the entire prepared area to achieve 90 µm dry film thickness using brush, roller or spray.

MCU-Coatings are single component and as such do not require mixing of 2 components, or a 10 minute induction time.

The dry film thickness specified can easily be achieved by roller or spray technique.

The above must be read in conjunction with the relevant MCU-Coatings Technical Data Sheets and Application Guide

Paint Application

When applying paint by spray, low pressure and high volume spray systems shall be used, as these systems limit the risk of overspray.

Determination of Wet Film Thickness

The wet film thickness measurements supplied by the paint manufacturer is based on no thinners being added to the paint.

If thinners are added to the paint, then the following formula must be used to determine the wet film thickness.

WFT = DFT x (100 + % thinner added) ÷ % VS

4.2.10 MCU Coatings Paint Repair System – Aliphatic Polyurea Top Coat

Storage of Paint Requirements and Shelf Life

15 months from date of manufacture if stored unopened between -5°C & 30°C in a cool, dry place.

Substrate Preparation

Spot abrasive blast damaged coatings and corroded steelwork to provide a Class Sa 2½ surface finish. Where this is not practical, Power Tool Cleaning in accordance with AS 1627.2 St 3 (min)

Paint System

Coat	Colour	Product	Binder	Thinners	Application Method	Volume Solids %	WFT (Microns)	DFT (Microns)	Over Coat Interval at 25°C	Pot Life at 25°C
1	Grey	MCU-Miozinc	Aromatic polyurea	MCU-Thinner	Airless, Brush, Roller or Air spray	72	104	75	3 Hours	N/A
2	light & dark grey	MCU-Miomastic	Aromatic polyurea	MCU-Thinner	Airless, Brush, Roller or Air spray	72	104	75	3 Hours	N/A
3	Final Colour	MCU-Topcoat	Aliphatic polyurea	MCU-Thinner	Airless, Brush, Roller or Air spray	64	117	75	5 Hours	N/A
							Total DFT Thickness	**225**		

Shorter overcoat intervals possible with MCU-Quickcure

Etching Process between coats

Ensure the surface is free of contamination before application of subsequent coats**.**

Paint Procedure

Damage to coating system with bare steel exposed.

1. Wash and degrease all surfaces as per AS 1627.1
2. Spot abrasive blast damaged coatings and corroded steelwork to provide a Class Sa 2½ surface finish. Where this is not practical, Power Tool Cleaning in accordance with AS 1627.2 St 3 (min)
3. Abrade the entire remaining surface with 240 grit paper.
4. Feather all edges. Remove sanding dust and ensure the surface is free of contamination. Prime the prepared surfaces as soon as practical and before the surface deteriorates or becomes contaminated.
5. Spot prime the corroded areas that have been prepared as above with MCU-Miozinc, to achieve the 75 µm dry film thickness using brush, roller or spray overlapping existing sound coating by a minimum of 50 mm.
6. Apply MCU-Miomastic to the spot areas above to achieve 75 µm dry film thickness using brush, roller or spray.
7. Apply MCU-Topcoat to the entire prepared area to achieve 75 µm dry film thickness using brush, roller or spray.

MCU-Coatings are single component and as such do not require mixing of 2 components, or a 10 minute induction time.

The dry film thickness specified can easily be achieved by roller or spray technique.

The above must be read in conjunction with the relevant MCU-Coatings Technical Data Sheets and Application Guide

Paint Application

When applying paint by spray, low pressure and high volume spray systems shall be used, as these systems limit the risk of overspray.

Determination of Wet Film Thickness

The wet film thickness measurements supplied by the paint manufacturer is based on no thinners being added to the paint.

If thinners are added to the paint, then the following formula must be used to determine the wet film thickness.

WFT = DFT x (100 + % thinner added) ÷ % VS

4.2.11 MCU Coatings Paint Repair System – Aliphatic Polyurea Top Coat

Storage of Paint Requirements and Shelf Life

15 months from date of manufacture if stored unopened between -5°C & 30°C in a cool, dry place.

Substrate Preparation

Spot abrasive blast damaged coatings and corroded steelwork to provide a Class Sa 2½ surface finish. Where this is not practical, Power Tool Cleaning in accordance with AS 1627.2 St 3 (min)

Paint System

Coat	Colour	Product	Binder	Thinners	Application Method	Volume Solids %	WFT (Microns)	DFT (Microns)	Over Coat Interval at 25°C	Pot Life at 25°C
1	Grey	MCU-Miozinc	Aromatic polyurea	MCU-Thinner	Airless, Brush, Roller or Air spray	72	236	170	3 Hours	N/A
2	Aluminium	MCU-Aluprime	Aromatic polyurea	MCU-Thinner	Brush	76	N/A	N/A	5 Hours	N/A
3	Final Colour	MCU-Miotopcoat	Aliphatic polyurea	MCU-Thinner	Airless, Brush, Roller or Air spray	63	143	90	5 Hours	N/A
							Total DFT Thickness	**260**		

Shorter overcoat intervals possible with MCU-Quickcure

Etching Process between coats

Ensure the surface is free of contamination before application of subsequent coats.

Paint Procedure

Damage to coating system with bare steel exposed.

1. Wash and degrease all surfaces as per AS 1627.1
2. Spot abrasive blast damaged coatings and corroded steelwork to provide a Class Sa 2½ surface finish. Where this is not practical, Power Tool Cleaning in accordance with AS 1627.2 St 3 (min)
3. Abrade the entire remaining surface with 240 grit paper.
4. Feather all edges. Remove sanding dust and ensure the surface is free of contamination. Prime the prepared surfaces as soon as practical and before the surface deteriorates or becomes contaminated.
5. Spot prime the corroded areas that have been prepared as above with MCU-Miozinc, to achieve the 170 µm dry film thickness using brush, roller or spray overlapping existing sound coating by a minimum of 50 mm.
6. All crevices, welds, bolts, rivets, holes, and edges shall be stripe coated by brush with MCU-Aluprime.
7. Apply MCU-Miotpcoat to the entire prepared area to achieve 90 µm dry film thickness using brush, roller or spray.

MCU-Coatings are single component and as such do not require mixing of 2 components, or a 10 minute induction time.

The dry film thickness specified can easily be achieved by roller or spray technique.

The above must be read in conjunction with the relevant MCU-Coatings Technical Data Sheets and Application Guide

Paint Application

When applying paint by spray, low pressure and high volume spray systems shall be used, as these systems limit the risk of overspray.

Determination of Wet Film Thickness

The wet film thickness measurements supplied by the paint manufacturer is based on no thinners being added to the paint.

If thinners are added to the paint, then the following formula must be used to determine the wet film thickness.

WFT = DFT x (100 + % thinner added) ÷ % VS

4.2.12 MCU Coatings Paint Repair System – Aliphatic Polyurea Top Coat

Storage of Paint Requirements and Shelf Life

15 months from date of manufacture if stored unopened between -5°C & 30°C in a cool, dry place.

Substrate Preparation

Abrasive blast corroded steelwork to remove rust and provide a Class Sa 2½ surface finish. If oxidation has occurred between blasting and application of the primer, the surface should be re-blasted to the specified visual standard.

Paint System

Coat	Colour	Product	Binder	Thinners	Application Method	Volume Solids %	WFT (Microns)	DFT (Microns)	Over Coat Interval at 25°C	Pot Life at 25°C
1	Grey	MCU-Miozinc	Aromatic polyurea	MCU-Thinner	Airless, Brush, Roller or Air spray	72	263	170	3 Hours	N/A
2	Final Colour	MCU-Miotopcoat	Aliphatic polyurea	MCU-Thinner	Airless, Brush, Roller or Air spray	63	143	90	5 Hours	N/A
							Total DFT Thickness	**260**		

Shorter overcoat intervals possible with MCU-Quickcure

Etching Process between coats

Ensure the surface is free of contamination before application of subsequent coats.

Paint Procedure

Damage to coating system with bare steel exposed.

1. Wash and degrease all surfaces as per AS 1627.1
2. Spot abrasive blast damaged coatings and corroded steelwork to provide a Class Sa 2½ surface finish. Where this is not practical, Power Tool Cleaning in accordance with AS 1627.2 St 3 (min)
3. Abrade the entire remaining surface with 240 grit paper.
4. Feather all edges. Remove sanding dust and ensure the surface is free of contamination. Prime the prepared surfaces as soon as practical and before the surface deteriorates or becomes contaminated.
5. Spot prime the corroded areas that have been prepared as above with MCU-Miozinc, to achieve the 170 µm dry film thickness using brush, roller or spray overlapping existing sound coating by a minimum of 50 mm.
6. Apply MCU-Miotopcoat to the entire prepared area to achieve 90 µm dry film thickness using brush, roller or spray.

MCU-Coatings are single component and as such do not require mixing of 2 components, or a 10 minute induction time.

The dry film thickness specified can easily be achieved by roller or spray technique.

The above must be read in conjunction with the relevant MCU-Coatings Technical Data Sheets and Application Guide

Paint Application

When applying paint by spray, low pressure and high volume spray systems shall be used, as these systems limit the risk of overspray.

Determination of Wet Film Thickness

The wet film thickness measurements supplied by the paint manufacturer is based on no thinners being added to the paint.

If thinners are added to the paint, then the following formula must be used to determine the wet film thickness.

WFT = DFT x (100 + % thinner added) ÷ % VS

4.2.13 Jotun Paint Repair System – Polyurethane Top Coat

Storage of Paint Requirements and Shelf Life

12 months at 25°C. Subject to re-inspection thereafter. Store in dry, shaded conditions away from sources of heat and ignition.

Substrate Preparation

Surfaces to be coated shall be degreased to ISO 12944-4, Part 6.1.4 *Alkaline Cleaning*, and abrasive blast cleaned to Sa 2½ (ISO 8501-1) with a minimum surface profile 45 µm, grade Fine to Medium G, Ry5 (ISO 8503-2).

Paint System

Coat	Colour	Product	Binder	Thinners	Application Method	Volume Solids %	WFT (Microns)	DFT (Microns)	Over Coat Interval at 25°C	Pot Life at 25°C
1	Grey	Barrier	Zinc Rich Epoxy	#17	Airless Spray, Brush & Air Spray	53	142	75	1.5 Hours	24 Hours
2	Final	HardTop AX	Polyurethane	#26, #10		63	127	80	5 Hours	2 Hours
Total DFT Thickness								**155**		

Etching Process between coats

Clean the paint with thinners to etch each coat before applying the next coat. Allow the thinners to dry before applying the protective coating.

Paint Procedure

Method 1. Minor damage to topcoat, (i.e., no primer required)

1. All surfaces to be painted shall be cleaned by a degreasing or washing procedure (as per AS 1627.1) to remove all oils, salts, acids or any other contamination that may be present.
2. Sand the entire area smooth with 240 grit paper.

3. Remove sanding dust and then solvent wipe again with #7 Thinner.
4. Mix Hardtop AX in accordance with the Product Data Sheet.
5. Apply Hardtop AX to achieve the specified dry film thickness using brush, roller or spray.

Method 2. Damage to topcoat and primer with bare metal exposed, (i.e., primer required)

1. All surfaces to be painted shall be cleaned by a degreasing or washing procedure (as per AS 1627.1) to remove all oils, salts, acids or any other contamination that may be present.
2. Corroded or damaged areas: Power Tool Clean in accordance with AS 1627.2 St 3 (min).
3. Any sharp edges shall have a radius of 2 mm diameter minimum. Weld spatter, weld irregularities, burr marks, laminations etc. must be removed.
4. Existing coating to be coated: abrade the entire surface to provide a roughened uniform matt appearance.
5. Feather all edges. Remove all preparation residue. Prepared surfaces shall be primed as soon as practical after preparation and before the surface deteriorates or becomes contaminated.
6. Spot prime prepared corroded areas with the specified primer overlapping existing sound coating by a minimum of 50 mm.
7. Prime and topcoat the total prepared area in accordance with the specification and the respective Product Data Sheets.

Note: Brush / roller application will require multiple coats to achieve the specified DFT requirements.

Paint Application

When applying paint by spray, low pressure and high volume spray systems shall be used, as these systems limit the risk of overspray.

Determination of Wet Film Thickness

The wet film thickness measurements supplied by the paint manufacturer is based on no thinners being added to the paint.

If thinners are added to the paint, then the following formula must be used to determine the wet film thickness.

WFT = DFT x (100 + % thinner added) ÷ % VS

4.2.14 Jotun Paint Repair System – Polyurethane Top Coat

Storage of Paint Requirements and Shelf Life

12 months at 25 °C. Subject to re-inspection thereafter. Store in dry, shaded conditions away from sources of heat and ignition.

Substrate Preparation

Surfaces to be coated shall be degreased to ISO 12944-4, Part 6.1.4 *Alkaline Cleaning*, and abrasive blast cleaned to Sa 2½ (ISO 8501-1) with a minimum surface profile 45 µm, grade Fine to Medium G, Ry5 (ISO 8503-2).

Paint System

Coat	Colour	Product	Binder	Thinners	Application Method	Volume Solids %	WFT (Microns)	DFT (Microns)	Over Coat Interval at 25°C	Pot Life at 25°C
1	Grey	Barrier	Zinc Rich Epoxy	#17	Airless Spray, Brush & Air Spray	53	142	75	1.5 Hours	24 Hours
2	Final	HardTop Flexi	Polyurethane	#10		64	125	80	3 Hours	1 Hours
Total DFT Thickness								**155**		

Etching Process between coats

Clean the paint with thinners to etch each coat before applying the next coat. Allow the thinners to dry before applying the protective coating.

Paint Procedure

Method 1. Minor damage to topcoat, (i.e., no primer required)

1. All surfaces to be painted shall be cleaned by a degreasing or washing procedure (as per AS 1627.1) to remove all oils, salts, acids or any other contamination that may be present.
2. Sand the entire area smooth with 240 grit paper.

3. Remove sanding dust and then solvent wipe again with #7 Thinner.
4. Mix Hardtop Flexi in accordance with the Product Data Sheet.
5. Apply Hardtop Flexi to achieve the specified dry film thickness using brush, roller or spray.

Method 2. Damage to topcoat and primer with bare metal exposed, (i.e., primer required)

1. All surfaces to be painted shall be cleaned by a degreasing or washing procedure (as per AS 1627.1) to remove all oils, salts, acids or any other contamination that may be present.
2. Corroded or damaged areas: Power Tool Clean in accordance with AS 1627.2 St 3 (min).
3. Any sharp edges shall have a radius of 2 mm diameter minimum. Weld spatter, weld irregularities, burr marks, laminations etc. must be removed.
4. Existing coating to be coated: abrade the entire surface to provide a roughened uniform matt appearance.
5. Feather all edges. Remove all preparation residue. Prepared surfaces shall be primed as soon as practical after preparation and before the surface deteriorates or becomes contaminated.
6. Spot prime prepared corroded areas with the specified primer overlapping existing sound coating by a minimum of 50 mm.
7. Prime and topcoat the total prepared area in accordance with the specification and the respective Product Data Sheets.

Note: Brush / roller application will require multiple coats to achieve the specified DFT requirements.

Paint Application

When applying paint by spray, low pressure and high volume spray systems shall be used, as these systems limit the risk of overspray.

Determination of Wet Film Thickness

The wet film thickness measurements supplied by the paint manufacturer is based on no thinners being added to the paint.

If thinners are added to the paint, then the following formula must be used to determine the wet film thickness.

WFT = DFT x (100 + % thinner added) ÷ % VS

4.2.15 Jotun Paint Repair System – Polysiloxane Top Coat

Storage of Paint Requirements and Shelf Life

12 months at 25°C. Subject to re-inspection thereafter. Store in dry, shaded conditions away from sources of heat and ignition.

Substrate Preparation

Surfaces to be coated shall be degreased to ISO 12944-4, Part 6.1.4 *Alkaline Cleaning*, and abrasive blast cleaned to Sa 2½ (ISO 8501-1) with a minimum surface profile 45 µm, grade Fine to Medium G, Ry5 (ISO 8503-2).

Paint System

Coat	Colour	Product	Binder	Thinners	Application Method	Volume Solids %	WFT (Microns)	DFT (Microns)	Over Coat Interval at 25°C	Pot Life at 25°C
1	Grey	Barrier	Zinc Rich Epoxy	#17	Airless Spray, Brush & Air Spray	53	142	75	1.5 Hours	24 Hours
2	Final	HardTop Optima	Polysiloxane	#7, #17, #10		76	130	100	4 Hours	6 Hours
							Total DFT Thickness	**175**		

Etching Process between coats

Clean the paint with thinners to etch each coat before applying the next coat. Allow the thinners to dry before applying the protective coating.

Paint Procedure

Method 1. Minor damage to topcoat, (i.e., no primer required)

1. All surfaces to be painted shall be cleaned by a degreasing or washing procedure (as per AS 1627.1) to remove all oils, salts, acids or any other contamination that may be present.
2. Sand the entire area smooth with 240 grit paper.

3. Remove sanding dust and then solvent wipe again with #7 Thinner.
4. Mix Hardtop Optima in accordance with the Product Data Sheet.
5. Apply Hardtop Optima to achieve the specified dry film thickness using brush, roller or spray.

Method 2. Damage to topcoat and primer with bare metal exposed, (i.e., primer required)

1. All surfaces to be painted shall be cleaned by a degreasing or washing procedure (as per AS 1627.1) to remove all oils, salts, acids or any other contamination that may be present.
2. Corroded or damaged areas: Power Tool Clean in accordance with AS 1627.2 St 3 (min).
3. Any sharp edges shall have a radius of 2 mm diameter minimum. Weld spatter, weld irregularities, burr marks, laminations etc. must be removed.
4. Existing coating to be coated: abrade the entire surface to provide a roughened uniform matt appearance.
5. Feather all edges. Remove all preparation residue. Prepared surfaces shall be primed as soon as practical after preparation and before the surface deteriorates or becomes contaminated.
6. Spot prime prepared corroded areas with the specified primer overlapping existing sound coating by a minimum of 50 mm.
7. Prime and topcoat the total prepared area in accordance with the specification and the respective Product Data Sheets.

Note: Brush / roller application will require multiple coats to achieve the specified DFT requirements.

Paint Application

When applying paint by spray, low pressure and high volume spray systems shall be used, as these systems limit the risk of overspray.

Determination of Wet Film Thickness

The wet film thickness measurements supplied by the paint manufacturer is based on no thinners being added to the paint.

If thinners are added to the paint, then the following formula must be used to determine the wet film thickness.

WFT = DFT x (100 + % thinner added) ÷ % VS

4.2.16 Jotun Paint Repair System – Polysiloxane Top Coat

Storage of Paint Requirements and Shelf Life

12 months at 25°C. Subject to re-inspection thereafter. Store in dry, shaded conditions away from sources of heat and ignition.

Substrate Preparation

Surfaces to be coated shall be degreased to ISO 12944-4, Part 6.1.4 *Alkaline Cleaning*, and abrasive blast cleaned to Sa 2½ (ISO 8501-1) with a minimum surface profile 45 µm, grade Fine to Medium G, Ry5 (ISO 8503-2).

Paint System

Coat	Colour	Product	Binder	Thinners	Application Method	Volume Solids %	WFT (Microns)	DFT (Microns)	Over Coat Interval at 25°C	Pot Life at 25°C
2	Grey/White	Penuard Universal	Polyamide Cured Epoxy	#17		72	243	175	4 Hours	2 Hours
3	Final	HardTop Optima	Polysiloxane	#7, #17, #10		76	130	100	4 Hours	6 Hours
							Total DFT Thickness	**275**		

Etching Process between coats

Clean the paint with thinners to etch each coat before applying the next coat. Allow the thinners to dry before applying the protective coating.

Paint Procedure

Method 1. Minor damage to topcoat, (i.e., no primer required)

1. All surfaces to be painted shall be cleaned by a degreasing or washing procedure (as per AS 1627.1) to remove all oils, salts, acids or any other contamination that may be present.
2. Sand the entire area smooth with 240 grit paper.

3. Remove sanding dust and then solvent wipe again with #7 Thinner.
4. Mix Hardtop Optima in accordance with the Product Data Sheet.
5. Apply Hardtop Optima to achieve the specified dry film thickness using brush, roller or spray.

Method 2. Damage to topcoat and primer with bare metal exposed, (i.e., primer required)

1. All surfaces to be painted shall be cleaned by a degreasing or washing procedure (as per AS 1627.1) to remove all oils, salts, acids or any other contamination that may be present.
2. Corroded or damaged areas: Power Tool Clean in accordance with AS 1627.2 St 3 (min).
3. Any sharp edges shall have a radius of 2 mm diameter minimum. Weld spatter, weld irregularities, burr marks, laminations etc. must be removed.
4. Existing coating to be coated: abrade the entire surface to provide a roughened uniform matt appearance.
5. Feather all edges. Remove all preparation residue. Prepared surfaces shall be primed as soon as practical after preparation and before the surface deteriorates or becomes contaminated.
6. Spot prime prepared corroded areas with the specified primer overlapping existing sound coating by a minimum of 50 mm.
7. Prime and topcoat the total prepared area in accordance with the specification and the respective Product Data Sheets.

Note: Brush / roller application will require multiple coats to achieve the specified DFT requirements.

Paint Application

When applying paint by spray, low pressure and high volume spray systems shall be used, as these systems limit the risk of overspray.

Determination of Wet Film Thickness

The wet film thickness measurements supplied by the paint manufacturer is based on no thinners being added to the paint.

If thinners are added to the paint, then the following formula must be used to determine the wet film thickness.

WFT = DFT x (100 + % thinner added) ÷ % VS

4.2.17 Jotun Paint Repair System – Polyurethane Top Coat

Storage of Paint Requirements and Shelf Life

12 months at 25°C. Subject to re-inspection thereafter. Store in dry, shaded conditions away from sources of heat and ignition.

Substrate Preparation

Surfaces to be coated shall be degreased to ISO 12944-4, Part 6.1.4 *Alkaline Cleaning*, and abrasive blast cleaned to Sa 2½ (ISO 8501-1) with a minimum surface profile 45 µm, grade Fine to Medium G, Ry5 (ISO 8503-2).

Paint System

Coat	Colour	Product	Binder	Thinners	Application Method	Volume Solids %	WFT (Microns)	DFT (Microns)	Over Coat Interval at 25°C	Pot Life at 25°C
2	Grey/White	Penuard Universal	Polyamide Cured Epoxy	#17		72	243	175	4 Hours	2 Hours
3	Final	HardTop Optima	Polysiloxane	#7, #17, #10		76	130	100	4 Hours	6 Hours
							Total DFT Thickness	**275**		

Etching Process between coats

Clean the paint with thinners to etch each coat before applying the next coat. Allow the thinners to dry before applying the protective coating.

Paint Procedure

Method 1. Minor damage to topcoat, (i.e., no primer required)

1. All surfaces to be painted shall be cleaned by a degreasing or washing procedure (as per AS 1627.1) to remove all oils, salts, acids or any other contamination that may be present.
2. Sand the entire area smooth with 240 grit paper.

3. Remove sanding dust and then solvent wipe again with #7 Thinner.
4. Mix Hardtop AX in accordance with the Product Data Sheet.
5. Apply Hardtop AX to achieve the specified dry film thickness using brush, roller or spray.

Method 2. Damage to topcoat and primer with bare metal exposed, (i.e., primer required)

1. All surfaces to be painted shall be cleaned by a degreasing or washing procedure (as per AS 1627.1) to remove all oils, salts, acids or any other contamination that may be present.
2. Corroded or damaged areas: Power Tool Clean in accordance with AS 1627.2 St 3 (min).
3. Any sharp edges shall have a radius of 2 mm diameter minimum. Weld spatter, weld irregularities, burr marks, laminations etc. must be removed.
4. Existing coating to be coated: abrade the entire surface to provide a roughened uniform matt appearance.
5. Feather all edges. Remove all preparation residue. Prepared surfaces shall be primed as soon as practical after preparation and before the surface deteriorates or becomes contaminated.
6. Spot prime prepared corroded areas with the specified primer overlapping existing sound coating by a minimum of 50 mm.
7. Prime and topcoat the total prepared area in accordance with the specification and the respective Product Data Sheets.

Note: Brush / roller application will require multiple coats to achieve the specified DFT requirements.

Paint Application

When applying paint by spray, low pressure and high volume spray systems shall be used, as these systems limit the risk of overspray.

Determination of Wet Film Thickness

The wet film thickness measurements supplied by the paint manufacturer is based on no thinners being added to the paint.

If thinners are added to the paint, then the following formula must be used to determine the wet film thickness.

WFT = DFT x (100 + % thinner added) ÷ % VS

5 Concrete Substrates

5.1 Paint System

5.1.1 International Paint System – Polysiloxane Top Coat

Storage of Paint Requirements and Shelf Life

12 months at 25°C. Subject to re-inspection thereafter. Store in dry, shaded conditions away from sources of heat and ignition.

Substrate Preparation

Repair the concrete surface and allow concrete repair mortar to cure for three days.

Paint System

Coat	Colour	Product	Binder	Thinners	Application Method	Volume Solids %	WFT (Microns)	DFT (Microns)	Over Coat Interval at 25°C	Pot Life at 25°C
1	Black	Interplus 356	Polyamide adduct cured epoxy	GTA 220	Airless Spray, Brush & Air Spray	70	150	100	4 Hours – 24 Days	2 Hours
2	Final	Interfine 878	Polysiloxane	GTA 007		72	104	75	4 Hours	2 Hours
							Total DFT Thickness	**175**		

Etching Process between coats

Clean the paint down between each coat with thinners to etch the coat before applying the next coat. Allow the thinners to dry before applying the protective coating.

Paint Procedure

1. Repair of damaged concrete areas with Intercrete 4801, as per manufacturer's recommendations.
2. Allow the repair mortar to cure for three days.
3. Apply one coat of Interplus 356 with a dry film thickness of 100 microns.
4. Etch previous coat with thinners before applying next coat.
5. Apply one coat of Interfine 878 with a dry film thickness of 75 microns.

Paint Application

When applying paint by spray, low pressure and high volume spray systems shall be used, as these systems limit the risk of overspray.

Determination of Wet Film Thickness

The wet film thickness measurements supplied by the paint manufacturer is based on no thinners being added to the paint.

If thinners are added to the paint, then the following formula must be used to determine the wet film thickness.

WFT = DFT x (100 + % thinner added) ÷ % VS

5.1.2 PPG Paint System – Polysiloxane Top Coat

Storage of Paint Requirements and Shelf Life

12 months at 25°C. Subject to re-inspection thereafter. Store in dry, shaded conditions away from sources of heat and ignition.

Substrate Preparation

Repair the concrete surface and allow concrete repair mortar to cure for three days.

Paint System

Coat	Colour	Product	Binder	Thinners	Application Method	Volume Solids %	WFT (Microns)	DFT (Microns)	Over Coat Interval at 25°C	Pot Life at 25°C
1	Grey	SigmaCover 350	HS HB Polyamine cured epoxy	91-92	Airless Spray, Brush & Air Spray	72	140	100	5 Hours – 14 Days	2.5 Hours
2	Final	PSX 700	Epoxy Siloxane	#140		89	140	125	3 Hours	3 Hours
							Total DFT Thickness	**225**		

Etching Process between coats

Clean the paint down between each coat with thinners to etch the coat before applying the next coat. Allow the thinners to dry before applying the protective coating.

Paint Procedure

1. Repair of damaged concrete areas with proprietary filler as per manufacturer's recommendations.
2. Allow the repair mortar to cure for three days.
3. Apply one coat of SigmaCover 350 with a dry film thickness of 100 microns.
4. Etch previous coat with thinners before applying next coat.
5. Apply one coat of PSX700 with a dry film thickness of 125 microns.

Paint Application

When applying paint by spray, low pressure and high volume spray systems shall be used, as these systems limit the risk of overspray.

Determination of Wet Film Thickness

The wet film thickness measurements supplied by the paint manufacturer is based on no thinners being added to the paint.

If thinners are added to the paint, then the following formula must be used to determine the wet film thickness.

WFT = DFT x (100 + % thinner added) ÷ % VS

5.1.3 International Paint System – Polyurethane Top Coat

Storage of Paint Requirements and Shelf Life

12 months at 25°C. Subject to re-inspection thereafter. Store in dry, shaded conditions away from sources of heat and ignition.

Substrate Preparation

Repair the concrete surface and allow concrete repair mortar to cure for three days.

Paint System

Coat	Colour	Product	Binder	Thinners	Application Method	Volume Solids %	WFT (Microns)	DFT (Microns)	Over Coat Interval at 25°C	Pot Life at 25°C
1	Black	Interplus 356	Polyamide adduct cured epoxy	GTA 220	Airless Spray, Brush & Air Spray	70	150	100	4 Hours – 24 Days	2 Hours
2	Final	Interthane 870	Polyurethane	GTA 713		56	180	100	4 Hours	2 Hours
							Total DFT Thickness	**200**		

Etching Process between coats

Clean the paint down between each coat with thinners to etch the coat before applying the next coat. Allow the thinners to dry before applying the protective coating.

Paint Procedure

1. Repair of damaged concrete areas with Intercrete 4801, as per manufacturer's recommendations.
2. Allow the repair mortar to cure for three days.
3. Apply one coat of Interplus 356 with a dry film thickness of 100 microns.
4. Etch previous coat with thinners before applying next coat.
5. Apply one coat of Interthane 870 with a dry film thickness of 100 microns.

Paint Application

When applying paint by spray, low pressure and high volume spray systems shall be used, as these systems limit the risk of overspray.

Determination of Wet Film Thickness

The wet film thickness measurements supplied by the paint manufacturer is based on no thinners being added to the paint.

If thinners are added to the paint, then the following formula must be used to determine the wet film thickness.

WFT = DFT x (100 + % thinner added) ÷ % VS

5.1.4 PPG Paint System – Polyurethane Top Coat

Storage of Paint Requirements and Shelf Life

12 months at 25°C. Subject to re-inspection thereafter. Store in dry, shaded conditions away from sources of heat and ignition.

Substrate Preparation

Repair the concrete surface and allow concrete repair mortar to cure for three days.

Paint System

Coat	Colour	Product	Binder	Thinners	Application Method	Volume Solids %	WFT (Microns)	DFT (Microns)	Over Coat Interval at 25°C	Pot Life at 25°C
1	Grey	SigmaCover 350	HS HB Polyamine cured epoxy	91-92	Airless Spray, Brush & Air Spray	72	140	100	5 hours – 14 Days	2.5 Hours
2	Final	SigmaDur 550	Polyurethane	21-06		55	90	50	5 Hours	4 Hours
							Total DFT Thickness	**150**		

Etching Process between coats

Clean the paint down between each coat with thinners to etch the coat before applying the next coat. Allow the thinners to dry before applying the protective coating.

Paint Procedure

1. Repair of damaged concrete areas with proprietary filler as per manufacturer's recommendations.
2. Allow the repair mortar to cure for three days.
3. Apply one coat of SigmaCover 350 with a dry film thickness of 100 microns.
4. Etch previous coat with thinners before applying next coat.
5. Apply one coat of SigmaDur 550 with a dry film thickness of 50 microns.

Paint Application

When applying paint by spray, low pressure and high volume spray systems shall be used, as these systems limit the risk of overspray.

Determination of Wet Film Thickness

The wet film thickness measurements supplied by the paint manufacturer is based on no thinners being added to the paint.

If thinners are added to the paint, then the following formula must be used to determine the wet film thickness.

WFT = DFT x (100 + % thinner added) ÷ % VS

5.1.5 Dulux Paint System – Polyurethane Top Coat

Storage of Paint Requirements and Shelf Life

12 months at 25°C. Subject to re-inspection thereafter. Store in dry, shaded conditions away from sources of heat and ignition.

Substrate Preparation

Repair the concrete surface and allow concrete repair mortar to cure for three days.

Paint System

Coat	Colour	Product	Binder	Thinners	Application Method	Volume Solids %	WFT (Microns)	DFT (Microns)	Over Coat Interval at 25°C	Pot Life at 25°C
1	Grey	Durebild STE	Polyamine cured epoxy	Dulux epoxy thinner	Airless Spray, Brush & Air Spray	84	120	100	9 Hours – 4 Weeks	90 Minutes
2	Final	Weathermax HBR	Polyurethane	Duthin 040		70	110	75	10 Hours	2 Hours
							Total DFT Thickness	**175**		

Etching Process between coats

Clean the paint down between each coat with thinners to etch the coat before applying the next coat. Allow the thinners to dry before applying the protective coating.

Paint Procedure

1. All surfaces to be painted shall be cleaned by a degreasing or washing procedure (as per AS 1627.1) to remove oils, salts, acids or any other contamination that may be present.
2. Mix Durebild STE in accordance with the Product Data Sheet.
3. Apply Durebild STE to achieve the specified dry film thickness of 100 microns using brush, roller or spray.
4. Mix Weathermax HBR in accordance with the Product Data Sheet.
5. Apply Weathermax HBR to achieve the specified dry film thickness of 75 microns using brush, roller or spray.

Paint Application

When applying paint by spray, low pressure and high volume spray systems shall be used, as these systems limit the risk of overspray.

Determination of Wet Film Thickness

The wet film thickness measurements supplied by the paint manufacturer is based on no thinners being added to the paint.

If thinners are added to the paint, then the following formula must be used to determine the wet film thickness.

WFT = DFT x (100 + % thinner added) ÷ % VS

5.1.6 Klaas Coatings Paint System – Silicone Resin Top Coat

Storage of Paint Requirements and Shelf Life

Store in dry, shaded conditions away from sources of heat and ignition. Shelf life is two years.

Substrate Preparation

Pressure wash – remove any form release oil or efflorescence prior to application. Panels must be surface dry. Panel surface must be cohesive, free of dust, oil, grease or other contaminants.

Concrete panels must be older than 14 days. Panels less than 28 days require Si-Prime.

Paint System

Coat	Colour	Product	Binder	Thinners	Application Method	Volume Solids %	WFT (Microns)	DFT (Microns)	Over Coast Interval at 25°C	Pot Life at 25°C
1	Clear	Si-Prime	Silane / Siloxane / Acrylic	Water	Spray / Brush / Roll	10	120	**-**	6 Hours	N/A
2	Final	Si-Rex03	Silicone Resin	Water		36	120	43	touch dry + 1 Hour	N/A
3	Final	Si-Rex03	Silicone Resin	Water		36	120	43	touch dry + 1 Hour	N/A
							Total DFT Thickness	**86**		

Etching Process between coats

Not required.

Paint Procedure

1. Confirm age of panels to receive application*.
2. Thoroughly mix paint.
3. Check colour is correct.
4. Check no rain is expected / forecast on day of application.
5. Confirm surface preparation is complete.
6. Ensure temperature and dew point is within parameters.
7. Determine surface area to required volume calculation.
8. Ensure all water / line preservative is removed from lines / tips (when spraying).
9. Spray / Roll at required rate.
10. Confirm WFT at regular intervals to ensure required application rate.
11. Ensure material is 100% touch dry before second coat. Generally, 15 minutes at 25°C and 50 RH when spraying or 2 hours post touch dry when rolling.
12. Spray in opposite direction to first coat.
13. Confirm WFT at regular intervals to ensure required application rate.
14. Clean up tools with water.

*Where panels are older than 14 days but younger than 28 days Si-Prime is required to be applied according to specification.

Paint Application

Airless spray or roll at 8 m²/L per coat to achieve 120 µm WFT. Two coats required.

Determination of Wet Film Thickness

The wet film thickness measurements supplied by the paint manufacturer is based on no thinners being added to the paint.

If thinners are added to the paint, then the following formula must be used to determine the wet film thickness.

WFT = DFT x (100 + % thinner added) ÷ % VS

5.1.7 Jotun Paint System – Polyurethane Top Coat

Storage of Paint Requirements and Shelf Life

12 months at 25°C. Subject to re-inspection thereafter. Store in dry, shaded conditions away from sources of heat and ignition.

Substrate Preparation

Poured concrete should be cured for a minimum of 28 days at temperatures over 21ºC before coating.

Paint System

Coat	Colour	Product	Binder	Thinners	Application Method	Volume Solids %	WFT (Microns)	DFT (Microns)	Over Coast Interval at 25°C	Pot Life at 25°C
1	Tintable	Jotamastic 90	Polyamide Cured Epoxy	#17	Airless Spray, Brush & Air Spray	80	156	125	3 Hours	2 Hours
2	Tintable	Jotamastic 90	Polyamide Cured Epoxy	#17		80	156	125	3 Hours	2 Hours
3	Final	HardTop AX	Polyurethane	#10		63	127	80	3 Hours	1 Hours
						Total DFT Thickness		**330**		

Etching Process between coats

Clean the paint with thinners to etch each coat before applying the next coat. Allow the thinners to dry before applying the protective coating.

Paint Procedure

1. Repair of damaged concrete areas with proprietary filler as per manufacture's recommendations.
2. Allow the repair mortar to cure for three days.
3. Apply one coat of Jotamastic 90 with a dry film thickness of 125 microns.
4. Apply second coat of Jotamastic 90 with a dry film thickness of 125 microns.
5. Etch previous coat with thinners before applying next coat if applicable.
6. Apply one coat of Hardtop AX with a dry film thickness of 80 microns.

Paint Application

When applying paint by spray, low pressure and high volume spray systems shall be used, as these systems limit the risk of overspray.

Determination of Wet Film Thickness

The wet film thickness measurements supplied by the paint manufacturer is based on no thinners being added to the paint.

If thinners are added to the paint, then the following formula must be used to determine the wet film thickness.

WFT = DFT x (100 + % thinner added) ÷ % VS

5.1.8 Jotun Paint System – Polysiloxane Top Coat

Storage of Paint Requirements and Shelf Life

12 months at 25°C. Subject to re-inspection thereafter. Store in dry, shaded conditions away from sources of heat and ignition.

Substrate Preparation

Poured concrete should be cured for a minimum of 28 days at temperatures over 21ºC before coating.

Paint System

Coat	Colour	Product	Binder	Thinners	Application Method	Volume Solids %	WFT (Microns)	DFT (Microns)	Over Coast Interval at 25°C	Pot Life at 25°C
1	Tintable	Jotamastic 90	Polyamide Cured Epoxy	#17	Airless Spray, Brush & Air Spray	80	156	125	3 Hours	2 Hours
2	Tintable	Jotamastic 90	Polyamide Cured Epoxy	#17		80	156	125	3 Hours	2 Hours
3	Final	HardTop Optima	Polysiloxane	#7, #17, #10		76	130	100	4 Hours	6 Hours
Total DFT Thickness								**350**		

Etching Process between coats

Clean the paint with thinners to etch each coat before applying the next coat. Allow the thinners to dry before applying the protective coating.

Paint Procedure

1. Repair of damaged concrete areas with proprietary filler as per manufacture's recommendations.
2. Allow the repair mortar to cure for three days.
3. Apply one coat of Jotamastic 90 with a dry film thickness of 125 microns.
4. Apply second coat of Jotamastic 90 with a dry film thickness of 125 microns.
5. Etch previous coat with thinners before applying next coat if applicable.
6. Apply one coat of Hardtop Optima with a dry film thickness of 100 microns.

Paint Application

When applying paint by spray, low pressure and high volume spray systems shall be used, as these systems limit the risk of overspray.

Determination of Wet Film Thickness

The wet film thickness measurements supplied by the paint manufacturer is based on no thinners being added to the paint.

If thinners are added to the paint, then the following formula must be used to determine the wet film thickness.

WFT = DFT x (100 + % thinner added) ÷ % VS

5.2 Paint Repair System

5.2.1 International Paint Repair System – Polysiloxane Top Coat

Storage of Paint Requirements and Shelf Life

12 months at 25°C. Subject to re-inspection thereafter. Store in dry, shaded conditions away from sources of heat and ignition.

Substrate Preparation

Repair the concrete surface and allow concrete repair mortar to cure for three days.

Paint System

Coat	Colour	Product	Binder	Thinners	Application Method	Volume Solids %	WFT (Microns)	DFT (Microns	Over Coat Interval at 25°C	Pot Life at 25°C
1	Black	Interplus 356	Polyamide adduct cured epoxy	GTA 220	Airless Spray, Brush & Air Spray	70	150	100	4 Hours – 24 Days	2 Hours
2	Final	Interfine 878	Polysiloxane	GTA 007		72	104	75	4 Hours	2 Hours
							Total DFT Thickness	**175**		

Etching Process between coats

Clean the paint down between each coat with thinners to etch the coat before applying the next coat. Allow the thinners to dry before applying the protective coating.

Paint Procedure

1. All surfaces to be painted shall be cleaned by a degreasing or washing procedure (as per AS 1627.1) to remove all oils, salts, acids or any other contamination that may be present.
2. Sand the entire area smooth with 240 grit paper.
3. Remove sanding dust and then solvent wipe again with GTA220 Thinner.
4. Mix Interplus 356 in accordance with the Product Data Sheet and allow to stand for ten minutes before use.
5. Apply Interplus 356 to achieve the specified dry film thickness using brush, roller or spray.
6. Mix Interfine 878 in accordance with the Product Data Sheet and allow to stand for ten minutes before use.
7. Apply Interfine 878 to achieve the specified dry film thickness using brush, roller or spray.

Paint Application

When applying paint by spray, low pressure and high volume spray systems shall be used, as these systems limit the risk of overspray.

Determination of Wet Film Thickness

The wet film thickness measurements supplied by the paint manufacturer is based on no thinners being added to the paint.

If thinners are added to the paint, then the following formula must be used to determine the wet film thickness.

WFT = DFT x (100 + % thinner added) ÷ % VS

5.2.2 PPG Paint Repair System – Polysiloxane Top Coat

Storage of Paint Requirements and Shelf Life

12 months at 25°C. Subject to re-inspection thereafter. Store in dry, shaded conditions away from sources of heat and ignition.

Substrate Preparation

Repair the concrete surface and allow concrete repair mortar to cure for three days.

Paint System

Coat	Colour	Product	Binder	Thinners	Application Method	Volume Solids %	WFT (Microns)	DFT (Microns)	Over Coat Interval at 25°C	Pot Life at 25°C
1	Grey	SigmaCover 350	HS HB Polyamine cured epoxy	91-92	Airless Spray, Brush & Air Spray	72	140	100	5 Hours – 14 Days	2.5 Hours
2	Final	PSX 700	Epoxy Siloxane	#140		89	140	125	3 Hours	3 Hours
							Total DFT Thickness	**225**		

Etching Process between coats

Clean the paint down between each coat with thinners to etch the coat before applying the next coat. Allow the thinners to dry before applying the protective coating.

Paint Procedure

1. All surfaces to be painted shall be cleaned by a degreasing or washing procedure (as per AS 1627.1) to remove all oils, salts, acids or any other contamination that may be present.
2. Sand the entire area smooth with 240 grit paper.
3. Remove sanding dust and then solvent wipe again with 91-92 Thinner.
4. Mix SigmaCover 350 in accordance with the Product Data Sheet and allow to stand for ten minutes before use.
5. Apply SigmaCover 350 to achieve the specified dry film thickness using brush, roller or spray.
6. Mix PSX 700 in accordance with the Product Data Sheet and allow to stand for ten minutes before use.
7. Apply PSX 700 to achieve the specified dry film thickness using brush, roller or spray.

Paint Application

When applying paint by spray, low pressure and high volume spray systems shall be used, as these systems limit the risk of overspray.

Determination of Wet Film Thickness

The wet film thickness measurements supplied by the paint manufacturer is based on no thinners being added to the paint.

If thinners are added to the paint, then the following formula must be used to determine the wet film thickness.

WFT = DFT x (100 + % thinner added) ÷ % VS

5.2.3 International Paint Repair System – Polyurethane Top Coat

Storage of Paint Requirements and Shelf Life

12 months at 25°C. Subject to re-inspection thereafter. Store in dry, shaded conditions away from sources of heat and ignition.

Substrate Preparation

Repair the concrete surface and allow concrete repair mortar to cure for three days.

Paint System

Coat	Colour	Product	Binder	Thinners	Application Method	Volume Solids %	WFT (Microns)	DFT (Microns)	Over Coat Interval at 25°C	Pot Life at 25°C
1	Black	Interplus 356	Polyamide adduct cured epoxy	GTA 220	Airless Spray, Brush & Air Spray	70	150	100	4 Hours – 24 Days	2 Hours
2	Final	Interthane 870	Polyurethane	GTA 713		56	180	100	4 Hours	2 Hours
							Total DFT Thickness	**200**		

Etching Process between coats

Clean the paint down between each coat with thinners to etch the coat before applying the next coat. Allow the thinners to dry before applying the protective coating.

Paint Procedure

1. All surfaces to be painted shall be cleaned by a degreasing or washing procedure (as per AS 1627.1) to remove all oils, salts, acids or any other contamination that may be present.
2. Sand the entire area smooth with 240 grit paper.
3. Remove sanding dust and then solvent wipe again with GTA220 Thinner.
4. Mix Interplus 356 in accordance with the Product Data Sheet and allow to stand for ten minutes before use.
5. Apply Interplus 356 to achieve the specified dry film thickness using brush, roller or spray.
6. Mix Interthane 870 in accordance with the Product Data Sheet and allow to stand for ten minutes before use.
7. Apply Interthane 870 to achieve the specified dry film thickness using brush, roller or spray.

Paint Application

When applying paint by spray, low pressure and high volume spray systems shall be used, as these systems limit the risk of overspray.

Determination of Wet Film Thickness

The wet film thickness measurements supplied by the paint manufacturer is based on no thinners being added to the paint.

If thinners are added to the paint, then the following formula must be used to determine the wet film thickness.

WFT = DFT x (100 + % thinner added) ÷ % VS

5.2.4 PPG Paint Repair System – Polyurethane Top Coat

Storage of Paint Requirements and Shelf Life

12 months at 25°C. Subject to re-inspection thereafter. Store in dry, shaded conditions away from sources of heat and ignition.

Substrate Preparation

Repair the concrete surface and allow concrete repair mortar to cure for three days.

Paint System

Coat	Colour	Product	Binder	Thinners	Application Method	Volume Solids %	WFT (Microns)	DFT (Microns)	Over Coat Interval at 25°C	Pot Life at 25°C
1	Grey	SigmaCover 350	HS HB Polyamine cured epoxy	91-92	Airless Spray, Brush & Air Spray	72	140	100	5 Hours – 14 Days	2.5 Hours
2	Final	SigmaDur 550	Polyurethane	21-06		55	90	50	5 Hours	4 Hours
							Total DFT Thickness	**150**		

Etching Process between coats

Clean the paint down between each coat with thinners to etch the coat before applying the next coat. Allow the thinners to dry before applying the protective coating.

Paint Procedure

1. All surfaces to be painted shall be cleaned by a degreasing or washing procedure (as per AS 1627.1) to remove all oils, salts, acids or any other contamination that may be present.
2. Sand the entire area smooth with s grit paper.
3. Remove sanding dust and then solvent wipe again with 91-92 Thinner.
4. Mix SigmaCover 350 in accordance with the Product Data Sheet and allow to stand for ten minutes before use.
5. Apply SigmaCover 350 to achieve the specified dry film thickness using brush, roller or spray.
6. Mix SigmaDur in accordance with the Product Data Sheet and allow to stand for ten minutes before use.
7. Apply SigmaDur to achieve the specified dry film thickness using brush, roller or spray.

Paint Application

When applying paint by spray, low pressure and high volume spray systems shall be used, as these systems limit the risk of overspray.

Determination of Wet Film Thickness

The wet film thickness measurements supplied by the paint manufacturer is based on no thinners being added to the paint.

If thinners are added to the paint, then the following formula must be used to determine the wet film thickness.

WFT = DFT x (100 + % thinner added) ÷ % VS

5.2.5 Dulux Paint Repair System – Polyurethane Top Coat

Storage of Paint Requirements and Shelf Life

12 months at 25°C. Subject to re-inspection thereafter. Store in dry, shaded conditions away from sources of heat and ignition.

Substrate Preparation

Repair the concrete surface and allow concrete repair mortar to cure for three days.

Paint System

Coat	Colour	Product	Binder	Thinners	Application Method	Volume Solids %	WFT (Microns)	DFT (Microns)	Over Coat Interval at 25°C	Pot Life at 25°C
1	Grey	Durebild STE	Polyamine cured epoxy	Dulux epoxy thinner	Airless Spray, Brush & Air Spray	84	120	100	9 Hours – 4 Weeks	90 Minutes
2	Final	Weathermax HBR	Polyurethane	Duthin 040		70	110	75	10 Hours	2 Hours
							Total DFT Thickness	**175**		

Etching Process between coats

Clean the paint down between each coat with thinners to etch the coat before applying the next coat. Allow the thinners to dry before applying the protective coating.

Paint Procedure

Method 1: Minor damage to topcoat (no primer required)

1. All surfaces to be painted shall be cleaned by a degreasing or washing procedure (as per AS 1627.1) to remove oils, salts, acids or any other contamination that may be present.
2. Sand the entire area smooth with 240 grit paper.
3. Remove sanding dust and then solvent wipe again with Dulux Polyurethane Thinner.
4. Mix Weathermax HBR in accordance with the Product Data Sheet.
5. Apply Weathermax HBR to achieve the specified dry film thickness of 75 microns using brush, roller or spray.

Note: Brush / roller application may require multiple coats to achieve the specified DFT requirements

Method 2: Damage to topcoat and primer with concrete exposed (primer required)

1. Repair damaged concrete areas with Luxepoxy Filler, as per manufacturer's recommendations.
2. Allow Luxepoxy Filler to cure for 13 hours (min) / 24 hours (max) @ 25°C.
3. Apply one coat of Durebild STE with a dry film thickness of 100 microns.
4. Etch previous coat with thinners before applying next coat.
5. Apply one coat of Weathermax HBR with a dry film thickness of 75 microns.

Note: Brush / roller application may require multiple coats to achieve the specified DFT requirements

Paint Application

When applying paint by spray, low pressure and high volume spray systems shall be used, as these systems limit the risk of overspray.

Determination of Wet Film Thickness

The wet film thickness measurements supplied by the paint manufacturer is based on no thinners being added to the paint.

If thinners are added to the paint, then the following formula must be used to determine the wet film thickness.

WFT = DFT x (100 + % thinner added) ÷ % VS

5.2.6 Klaas Coatings Repair System – Silicone Resin Top Coat

Storage of Paint Requirements and Shelf Life

Store in dry, shaded conditions away from sources of heat and ignition. Shelf life is 2 years.

Substrate Preparation

Pressure wash - remove any form release oil or efflorescence prior to application.

If necessary, patch repair concrete as directed, preferably with a polymer modified repair mortar compound. Ensure a similar surface texture to the surrounding area is achieved.

Panels must be surface dry. Panel surface must be cohesive, free of dust, oil, grease or other contaminants.

Paint System

Coat	Colour	Product	Binder	Thinners	Application Method	Volume Solids %	WFT (Microns)	DFT (Microns)	Over Coat Interval at 25°C	Pot Life at 25°C
1	Final	Si-Rex03	Silicone Resin	Water	Spray / Brush / Roll	36	120	43	touch dry + 1 Hour	N/A
2	Final	Si-Rex03	Silicone Resin	Water		36	120	43	touch dry + 1 Hour	N/A
							Total DFT Thickness	**86**		

Etching Process between coats

Not required.

Paint Procedure

1. Thoroughly mix paint.
2. Check colour is correct.
3. Check no rain is expected / forecast on day of application.
4. Confirm surface preparation is complete.
5. Ensure temperature and dew point is within parameters.
6. Determine surface area to required volume calculation.
7. Ensure all water / line preservative is removed from lines / tips (when spraying).
8. Spray / Roll at required rate.
9. Confirm WFT at regular intervals to ensure required application rate.
10. Ensure material is 100% touch dry before second coat. Generally, 15 minutes at 25°C and 50 RH when spraying or 2 hours post touch dry when rolling.
11. Spray in opposite direction to first coat.
12. Confirm WFT at regular intervals to ensure required application rate.
13. Clean up tools with water.

Paint Application

Airless spray or roll at 8 m²/L per coat to achieve 120 µm WFT. Two coats required.

Determination of Wet Film Thickness

The wet film thickness measurements supplied by the paint manufacturer is based on no thinners being added to the paint.

If thinners are added to the paint, then the following formula must be used to determine the wet film thickness.

WFT = DFT x (100 + % thinner added) ÷ % VS

5.2.7 Jotun Paint Repair System – Polyurethane Top Coat

Storage of Paint Requirements and Shelf Life

12 months at 25°C. Subject to re-inspection thereafter. Store in dry, shaded conditions away from sources of heat and ignition.

Substrate Preparation

Poured concrete should be cured for a minimum of 28 days at temperatures over 21ºC before coating.

Paint System

Coat	Colour	Product	Binder	Thinners	Application Method	Volume Solids %	WFT (Microns)	DFT (Microns)	Over Coast Interval at 25°C	Pot Life at 25°C
1	Tintable	Jotamastic 90	Polyamide Cured Epoxy	#17	Airless Spray, Brush & Air Spray	80	156	125	3 Hours	2 Hours
2	Tintable	Jotamastic 90	Polyamide Cured Epoxy	#17		80	156	125	3 Hours	2 Hours
3	Final	HardTop AX	Polyurethane	#10		63	127	80	3 Hours	1 Hours
						Total DFT Thickness		**330**		

Etching Process between coats

Clean the paint with thinners to etch each coat before applying the next coat. Allow the thinners to dry before applying the protective coating.

Paint Procedure

1. Repair of damaged concrete areas with proprietary filler as per manufacture's recommendations.
2. Allow the repair mortar to cure for three days.
3. Apply one coat of Jotamastic 90 with a dry film thickness of 125 microns.
4. Apply second coat of Jotamastic 90 with a dry film thickness of 125 microns.
5. Etch previous coat with thinners before applying next coat if applicable.
6. Apply one coat of Hardtop AX with a dry film thickness of 80 microns.

Paint Application

When applying paint by spray, low pressure and high volume spray systems shall be used, as these systems limit the risk of overspray.

Determination of Wet Film Thickness

The wet film thickness measurements supplied by the paint manufacturer is based on no thinners being added to the paint.

If thinners are added to the paint, then the following formula must be used to determine the wet film thickness.

WFT = DFT x (100 + % thinner added) ÷ % VS

5.2.8 Jotun Paint Repair System – Polysiloxane Top Coat

Storage of Paint Requirements and Shelf Life

12 months at 25°C. Subject to re-inspection thereafter. Store in dry, shaded conditions away from sources of heat and ignition.

Substrate Preparation

Poured concrete should be cured for a minimum of 28 days at temperatures over 21ºC before coating.

Paint System

Coat	Colour	Product	Binder	Thinners	Application Method	Volume Solids %	WFT (Microns)	DFT (Microns)	Over Coast Interval at 25°C	Pot Life at 25°C
1	Tintable	Jotamastic 90	Polyamide Cured Epoxy	#17	Airless Spray, Brush & Air Spray	80	156	125	3 Hours	2 Hours
2	Tintable	Jotamastic 90	Polyamide Cured Epoxy	#17		80	156	125	3 Hours	2 Hours
3	Final	HardTop Optima	Polysiloxane	#7, #17, #10		76	130	100	4 Hours	6 Hours
Total DFT Thickness								**350**		

Etching Process between coats

Clean the paint with thinners to etch each coat before applying the next coat. Allow the thinners to dry before applying the protective coating.

Paint Procedure

1. Repair of damaged concrete areas with proprietary filler as per manufacture's recommendations.
2. Allow the repair mortar to cure for three days.
3. Apply one coat of Jotamastic 90 with a dry film thickness of 125 microns.
4. Apply second coat of Jotamastic 90 with a dry film thickness of 125 microns.
5. Etch previous coat with thinners before applying next coat if applicable.
6. Apply one coat of Hardtop Optima with a dry film thickness of 100 microns.

Paint Application

When applying paint by spray, low pressure and high volume spray systems shall be used, as these systems limit the risk of overspray.

Determination of Wet Film Thickness

The wet film thickness measurements supplied by the paint manufacturer is based on no thinners being added to the paint.

If thinners are added to the paint, then the following formula must be used to determine the wet film thickness.

WFT = DFT x (100 + % thinner added) ÷ % VS

6 Timber Substrates

6.1 Paint System

Paint System will be released with a future Technical Note Update.

6.2 Paint Repair System

Paint Repair System will be released with a future Technical Note Update.

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