

# TECHNISPRAY PAINTS LTD.

Linton House, Catherine Street, Aston, Birmingham B6 5RS U.K.

Tel: ++44 (0) 121 326 8020 Fax: ++44 (0) 121 327 1507

Email: enquiries@kolorbond.co.uk

www: kolorbond.co.uk

## Application instructions for Kolorbond Paint

**Kolorbond is suitable for coating PVCu, hard plastics (not GRP) and powder-coated metals**

Before starting to prepare window frames for painting, blow swarf and dust from the profile with your compressed air line.

1. Mask the frames covering all surfaces which do not require painting.
2. Clean the substrate using **Vinylkleen**. This will remove all water soluble contaminants together with most oils.
3. Thoroughly clean the surface again using **Windowprep** on a clean white cloth which should be regularly turned.
4. Lightly abrade the surfaces to be painted with red Scotchbrite and blow off any debris.
5. Check that the paint colour and gloss level are correct, then thoroughly mix the Kolorbond paint making sure that any colourants on the base of the can are mixed in. The sprayer must wear a spray mask with the appropriate filters.
6. Use a tack rag, if necessary, to remove any dust or swarf remaining on the surface of the profiles.
7. Spray the profile with a dust coat and check for any contamination before proceeding. This dust coat is important.
8. Spray a medium coat, allow to flash off (approx. 6 minutes). Inspect for inclusions and remove with 320 grade fre-cut paper. Apply a further medium coat.
9. Allow all solvents to leave the paint before protecting the painted surface with a low tack protective tape. This can vary from overnight at 45°C to 4 days at winter ambient temperatures(8°C). If you wish to dispatch sooner than this, wrap in paper or thin foam for protection.
10. Before applying protective tape, check the paint finish for inclusions, light edges and application faults. Re-work if necessary to ensure that the finish is correct and to the customers specification.

N.B. Please check adhesion on small plastic parts used in the window industry. These are sometimes made from mixed plastics (not pure PVCu) or polypropylene. If adhesion is poor, spray with a mist coat of **Polyprep** immediately prior to applying Kolorbond