

# **TECHNISPRAY PAINTS LTD.**

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## **KOLORBOND® APPLICATOR METHOD STATEMENT**

### **ON-SITE SURFACE TREATMENT OF PVCu AND POWDER COATED METALS**

1. Make sure the area to be treated with Kolorbond® is safe for other people while the refurbishment work is done.
2. Temperature should be above 10°C and at least 4°C above dew-point. Relative humidity should be below 70%
3. Set up the working environment by protecting the affected area with plastic sheeting. Examples are garden plants and shrubs, pavements, and driveways near the items to be sprayed. Remove vehicles to a safe distance.
4. Remove any gaskets, if possible. If not, mask with fine masking tape. Mask other items which do not require painting with tape and masking paper. These items include glass, handles, brickwork, hinges, etc.
5. All excess mastics and silicone sealants that are evident on the faces of the substrate should be completely removed prior to spraying. Silicone joints between two pieces of substrate should be partially removed and replaced after spraying.
6. All opening vents and doors are treated into the reveal. These are slightly opened and sealed around to prevent ingress of Kolorbond®.
7. Some areas may need scaffolding, aluminium towers or ladders. These are to be from a reputable hire company to the British Standard and erected by the spray personnel.
8. Clean the PVCu plastic or powder coating with Vinylkleen diluted with water using the ratio of 1 part Vinylkleen to 2 parts water. The surface of the substrate should be air-dried and wiped over with a lint free cloth. All dirt and grease contaminants are to be removed at this stage.

9. Abrade the surface to be painted with Scotchbrite on PVCu or 320 grit paper on powder coating. Any marks left by the grit paper should be removed using Scotchbrite. Thoroughly clean the surface with Windowprep.
10. Wipe over once again with a tack rag to remove any dust deposits.
11. Mix well and thoroughly stir the Kolorbond<sup>®</sup> before use. Check that the colour is correct.
12. Apply the Kolorbond<sup>®</sup> by conventional spray techniques. Use personal protection to comprise of a charcoal filter respirator, disposable overalls and gloves. Even though Kolorbond<sup>®</sup> contains no isocyanates, cadmium, or lead, Technispray Paints Limited will always promote safe working practices.
13. First apply a 'dust coat' of Kolorbond<sup>®</sup> to lightly cover the surface of the substrate, then cover the edges and surface protrusions. This 'dust coat' is essential. Allow a flash off time of 1 minute.
14. Apply a second moderate coat. This may be done in a number of passes, depending on the spray gun positioning and the physical job set-up. Care should be taken not to allow runs to form. Apply a third moderate coat. It is essential that several even coats be applied rather than one heavy coat.  
  
The final total dry film thickness should be 20 – 30 microns.
15. Leave to dry for approximately 10 minutes. De-mask, then replace gaskets and leave in a clean, tidy condition. Replacement of silicon mastics should not take place until a number of days after spraying.
16. Check all the work with the customer and that it is to the customers satisfaction

An adhesion tests should be undertaken on individual units and recorded on the work record sheet along with weather and hygrometer readings.