

Generic Paint Specification 1242B

V580, V790 for Mild Steel

Coating in C3 Env. 5 – 10 Years

Substrate	Mild Steel
Environment	AS/NZ C Medium (C3)
Products	Vitrethane 580 Epoxy Primer
	Vitrethane 790 Fluoropolymer Topcoat

Surface Preparation:

Thoroughly degrease the surface to remove all contaminants as per AS 1627.1

All sharp edges are to be removed by grinding to provide a 2mm minimum radiused edge.

Abrasive Blast Clean to AS 1627.4 class 2.5

Application

1. Apply Vitrethane 580 Epoxy Primer to achieve 150 um DFT as per Data Sheet 023.
2. Apply Vitreflon 790 Fluoropolymer topcoat to achieve 50µm DFT as per Data Sheet 011.

This Generic Paint Specification must be read having regard to the Notes below.

Notes:

This specification is a generic specification. This specification must be read in conjunction with all relevant Product Data Sheets and Safety Data Sheets. This specification is offered free of charge and as a guide only. To the extent permitted by law, A&I Coatings liability with respect to the Products is limited to supply of replacement materials and no further liability for failure of the Product or associated costs will be borne by A&I Coatings. Being a generic specification, there may be situations or conditions not considered that could influence the performance or appearance of the finished product. You must ensure this specification is suitable for your project by contacting your A&I Coatings representative prior to purchasing the Product. Product usage rates given in this specification are an indication only and do not allow for any wastage or variation due to factors beyond the control of A&I Coatings.

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This specification prepared By: Peter Gillies / Approved By: Frank Jiang / QAF037 Version Number: 01 / Issue Date: 30/03/10

Application data Table

Product	Data Sheet	Application Method	Dry Film Thickness Microns	Theoretical Spreading Rate M ² /L	No. of Packs	Mixing Ratio	Pot Life @25C	Thinner	Clean Up Solvent	Recoat Time At 25°C
V580	023	AS/CS	150	3.3	2	4:1	7	V122	V102	8 -48 Hours
V790	011	AS/CS	50	12	2	4:1	2	V111	V111	NA

AS = Airless Spray, CS = Conventional Spray

TOTAL MIN DRY FILM THICKNESS: 200 microns

Allow to cure for minimum 2 days (if possible) @ 21°C before service

Note: The dry film thicknesses quoted in this specification are the minimum to be achieved. Do not exceed specified thickness by more than 30%.

The specified film thickness for each coat shall be achieved prior to the application of the subsequent coat.

Any edges and welds shall have a stripe coat of each specified coating applied to them, to ensure correct film build is achieved, and to maximise the effectiveness of the paint system. On completion of painting, all crevices shall have a suitable type silicone or mastic sealant applied into them as per manufacturer’s instruction to aid in corrosion prevention.

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