



## APPLICATION PROCEDURE

### Hemucryl Enamel 58100 PAINT

#### 1. INTRODUCTION

The purpose of this procedure is to define the correct way to paint Viroc® panels with Hempel Enamel 58100 paint. The upper face on the package is called face A and will be the face that will be exposed and visible. The back face that will be hidden will be called face B.

#### 2. APPLICATION TEMPERATURE

The application of Hemucryl Enamel 58100 paint can only be carried out when the temperature at the application site is in the range 5°C to 30°C.

#### 3. RELATIVE HUMIDITY

The application of Hemucryl Enamel 58100 paint can only be carried out when the relative humidity at the application site is below 80%.

#### 4. DEW POINT

The application of Hemucryl Enamel 58100 paint can only be carried out when the surface temperature of the Viroc® panel is at least 3°C above the dew point.

#### 5. RECOAT INTERVALS

The minimum recoating interval between coats of Hemucryl Enamel 58100 is 8 hours (at a temperature of 20°C). When applied in the workshop, the panels can only be packed 120 hours (5 days) after applying the last coat of Hemucryl Enamel 58100 (at a temperature of 20°C) and placing a plastic film separating the panels.

#### 6. CLEANING THE VIROC® PANEL

Clean the face A of the Viroc® panel, removing any dirt, grease, dust or salts, by gently polishing with a cleaning disc. Viroc Portugal has suitable discs for cleaning the panels.

On face B, a simple cleaning can be performed, by brushing or sanding with fine sandpaper and subsequent removal of residues.



## 7. VARNISH APPLICATION

### Face B

Apply one coat of Hemucryl Enamel 58100 by roller, diluted 5% with clean water, layer (1); this coat is intended to seal the panel porosity.

### Face A and Edges

Apply one coat of Hemucryl Enamel 58100 by roller, diluted 5% with clean water, layer (2); this coat is intended to seal the panel porosity.

Apply two coats by spray or by roller of Hemucryl Enamel 58100, diluted 5% with clean water, layers (3) and (4).  
The minimum dry film thickness for these coats will be 60µm (30 µm per coat).

## 8. QUALITY CONTROL

The applicator, before and during the varnishing work of Viroc® panels, must carry out the following quality control registration tasks:

- a) Check that Viroc® panels are not wet.
- b) Check if the temperature of the panel is 3°C above the dew point.
- c) Measure the temperature and relative humidity of the place where the varnishing will be carried out.  
Frequency of measurements: 3 times a day during working hours (morning, midday and mid-afternoon).
- d) The batch numbers of the products used will be noted on the painting registration sheet.  
The expiry date shown on the package will also be recorded.
- e) In order to control the amount of paint applied on the Viroc® panel, samples of a minimum size of 400x800 mm will be carried out simultaneously with the painting of the panels, randomly arranged without ever being followed, where metal sheets will be placed (one unit per panel), with a minimum dimension of 75x150 mm and which will be spray-painted in the last two finishing coats, layers (3) and (4).
- f) The number of samples to be carried out will be one metal sheet per 200m<sup>2</sup>.  
The ink thickness measured on the control recording plates after drying, relating to layers (3) and (4), must not be less than 60 µm.
- g) If you verify that the amount of paint applied is less than that indicated above, additional coats will be applied until the minimum dry thickness is respected. You can lightly sand with fine sandpaper to improve the adhesion between coats.

## 9. MAINTENANCE

Remove all coats that do not guarantee good adhesion.

Wash and degrease the surface with a high pressure fresh water jet.

Allow to dry completely.

Apply Hemucryl Enamel 58100 paint in the necessary coats.



10. REMARKS:

- a) Viroc Portugal S.A. and Hempel Portugal S.A. reserve the right to change the information contained in this application procedure whenever they see fit.
- b) Hemucryl Enamel 58100 paint must be purchased in its base 50 (transparent).

# Hemucryl Enamel

## Product characteristics

### Description

Hemucryl Enamel 58100 is a water-borne, acrylic dispersion based paint. It dries to a non-yellowing and glossy coating with low dirt pick-up, good weathering properties, and high gloss retention. Especially suited for roller or brush application. For airless spray application, Hemucryl Enamel Hi-Build 58030 is recommended.

### Recommended use

As a glossy, finishing coat in water-borne paint systems, interior and exterior, in mildly to moderately corrosive environment. For use on buildings the relatively high resistance to diffusion of water vapour and carbon dioxide should be taken into account.

### Service temperature:

- Maximum, dry exposure only: 120°C [248°F].

## Product safety

**Flash point** 101°C [214°F]

### VOC content

Legislation	Value
EU	52 g/L [0.43 lb/US gal]
US (coatings)	64 g/L [0.53 lb/US gal]
US (regulatory)	142 g/L [1.19 lb/US gal]
China	52 g/L [0.43 lb/US gal]

According to specific legislation, see details in the Explanatory Notes available at Hempel website, [hempel.com](http://hempel.com) or at your local Hempel website. VOC values may vary with shade, please consult the Safety Data Sheet, section 9.

### Handling

Handle with care. Before and during use, observe safety labels on packaging and paint containers and follow all local and national safety regulations. Always consult Hempel's Safety Data Sheet for this product along with the Product Data Sheet.

For professional use only.

## Product data

### Product code

58100

### Standard shade\* / code

White 10000

### Gloss

Glossy

### Volume solids

41 ± 2%

### Specific gravity

1.3 kg/L [11 lb/US gal]

### Reference dry film thickness

50 micron [2.0 mils]

## Surface preparation

### Cleanliness

- Remove oil, grease and other contaminants by suitable detergent cleaning.
- Remove salts, detergents, contaminants and marine growth by high pressure fresh water cleaning.

### New build:

- According to Hempel's Specification.

### Maintenance and Repair

- According to Hempel's Specification.

Consult Hempel's separate Surface Preparation Guidelines for more details.

# Hemucryl Enamel

## Application

### Mixing ratio

Stir well before use.

### Thinner

Fresh water

### Cleaner

Fresh water

### Application method

Tool	Thinning max vol.	Application parameters
Brush	5%	Not Applicable.
Roller	5%	Not Applicable.

### Film thickness

Specification range	Low	High	Recommended
Dry film thickness	30 micron [1.2 mils]	100 micron [3.9 mils]	50 micron [2.0 mils]
Wet film thickness	75 micron [3 mils]	250 micron [10 mils]	120 micron [5 mils]
Theoretical spreading rate	14 m <sup>2</sup> /L [570 sq ft/US gal]	4.1 m <sup>2</sup> /L [170 sq ft/US gal]	8.2 m <sup>2</sup> /L [330 sq ft/US gal]

Product may be specified in another film thickness than indicated depending on purpose and area of use. This will alter spreading rate, drying and curing time and overcoating interval. Overthickness should be closely controlled and never locally exceed 100 micron [3.9 mils] DFT. On irregular surfaces it is recommended to employ special care in avoiding over application.

### Application conditions

- To avoid condensation, apply on a clean and dry surface with a temperature that is at least 3°C [5°F] above the dew point.

### Relative Humidity:

- Relative humidity must be below 80% during application.

## Drying and overcoating

### Product compatibility

- Previous coat: According to Hempel's Specification. Recommended products are: Hemucryl Primer Hi-Build 18100, Hemudur 18500
- Subsequent coat: None.

### Drying time

Surface temperature		20°C [68°F]
Surface dry	min	15

Determined for dry film thickness 50 micron [2.0 mils] at standard conditions, see Hempel's Explanatory Notes for details.

### Overcoating

Consult Hempel's specification for more information.

### Drying conditions

- To obtain the drying time stated, it is important to maintain sufficient ventilation during application, drying and curing.
- Condensation on the freshly applied coating should be avoided.

### Overcoating details

- The surface must be dry and clean prior to application.

### Other remarks

- Hempel's Specification supersedes any recommendations given in the Product Data Sheets.

## Storage

### Shelf life

Ambient temperature	25°C [77°F]
Product	36 months

Shelf life from date of production, when stored in original, unopened containers. Thereafter, the product quality must be re-inspected. Always check the best before date or expiry date on the label.

# Hemucryl Enamel

## Storage conditions

- Product must be stored according to local legislation, at maximum 40°C [104°F], without direct sunlight and protected from rain and snow.
- Temperature must not go below 5°C [41°F] during transport and storage.

## Additional documents

Additional information is available at the Hempel website [hempel.com](http://hempel.com) or at your local Hempel website:

- Explanatory Notes explaining the fields in this Product Data Sheet.
- Surface Preparation Guidelines.
- Application Guidelines for different application methods.
- General Application Guidelines

This Product Data Sheet ("PDS") relates to the supplied product ("Product") and is subject to updating from time-to-time. Accordingly, the buyer/applicator should have regard to the PDS supplied together with the relevant batch of the Product (and not an earlier version). In addition to the PDS, the buyer/applicator may receive some or all of the following specifications, statements and/or guidelines as listed below or as are available from the Hempel website under 'Products' at [www.hempel.com](http://www.hempel.com) (the "Additional documents"):

No.	Document description	Location/comments
1.	Technical Statement	One-off specific advice provided on request for specific projects
2.	Specification	Only issued for specific projects
3.	PDS	This document
4.	Explanatory Notes to the PDS	Available at <a href="http://www.hempel.com">www.hempel.com</a> and contain relevant information about the Product testing parameters
5.	Application Instruction	Where available, at <a href="http://www.hempel.com">www.hempel.com</a>
6.	Generic technical guidelines (e.g. on application and surface preparation)	Where available, at <a href="http://www.hempel.com">www.hempel.com</a>

In the event of a conflict of information between the PDS and the Additional documents, the order of priority of information shall be in the order as set out above. In such event you should also contact your representative at Hempel for clarification. Furthermore, the buyer/applicator must have full regard to the relevant Safety Data Sheet provided with each Product and which can also be downloaded from [www.hempel.com](http://www.hempel.com).

Hempel shall not be liable for defects where the application of the Product has not been made fully in accordance with the recommendations and requirements set out in the relevant PDS and the Additional Documents. The information and terms of this disclaimer apply to this PDS, the Additional documents and any other documents supplied by Hempel in respect of the Product. In addition, the Product is supplied and all technical assistance is given subject to Hempel's General Conditions of Sale, Delivery and Service, unless otherwise expressly agreed in writing.