



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 200m².
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).