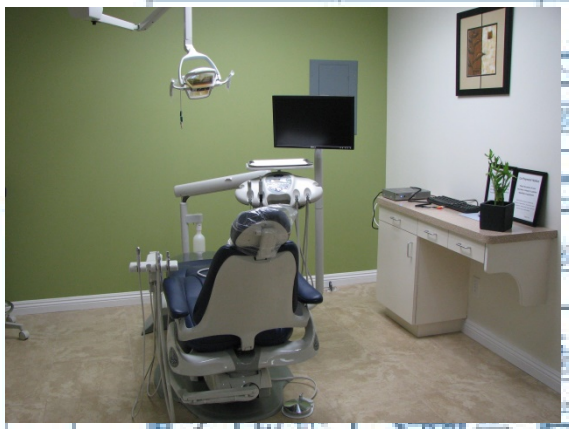
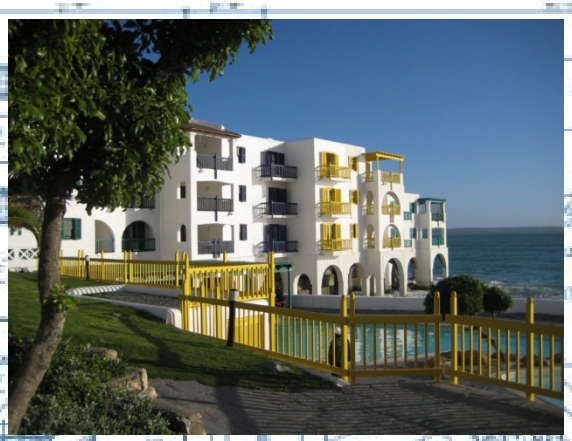




DEKRO
PAINTS

SABS ISO 9001

*...Dekro brings Paint to Life...*

# SPECIFICATION MANUAL

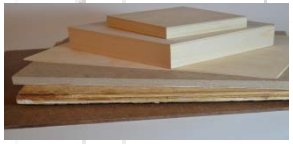
# INDEX

OUR PRODUCTS


QUICK GUIDE TO PAINTING


GENERAL SAFETY & HEALTH PROTECTION

THINNER GUIDE



INDEX OF SPECIFICATIONS FOR SURFACE COATINGS AND CONDITIONS

HYGIENE SOLUTIONS

HEAVY DUTY COATINGS

# OUR PRODUCTS

WATER-BASED TOPCOATS

WATER-BASED PRIMERS AND UNDERCOATS

SOLVENT-BASED TOPCOATS

SOLVENT-BASED PRIMERS AND UNDERCOATS

WOOD VARNISHES

MISCELLANEOUS PRODUCTS

THALES APPROVED COATINGS

# WATER-BASED TOPCOATS

**1. DEKRO ALLFLEX**
Dekro Allflex is a water based acrylic co-polymer resin assisted by a buoyant polymer which rises to the surfaces where it is functional. A high build smooth and flexible coating for the protection of exterior masonry surfaces. Dekro Allflex provides a thick, tough but elastic film to prevent hair cracks which waterproofs, resists UV and fungal growth.

Interior ☑
Exterior ☑

**2. DEKRO HYDROSILK (P.S.F.)**
Dekro Hydrosilk is an adhesion promoted plastic satin finish pure acrylic coating. Dekro Hydrosilk has outstanding interior/exterior durability and is stain and scrub resistant. This low sheen coating is non-yellowing and has anti-bacterial, fast drying and over coating properties.

Interior ☑
Exterior ☑

**3. DEKRO HYDROGLOSS**
A top quality pure acrylic with a glossy hard finish. Outstanding adhesion over gloss paint and is non yellowing.

Interior ☑
Exterior ☑

**5. DEKRO MEDIGUARD (ANTI-BACTERIAL/FUNGICIDAL)**
A top quality pure acrylic water-based coating for the prevention of fungal and algae growth. Resistance to a wide variety of bacteria. Outstanding interior and exterior durability with excellent alkali resistance. Also has stain and scrub resistant properties. It is non-toxic and non-irritant if standard painting conditions and code of painting practise is adhered to.

Interior ☑
Exterior ☑

**6. DEKRO HYDROCIDE ANTI-FUNGAL ACRYLIC**
A top quality 100% acrylic emulsion containing a special non-toxic biocide designed to combat bacteria and mould growth. Hydrocide has excellent adhesion and alkali resistance and dries to a flexible, tough sheen finish.

Interior ☑
Exterior ☑

**7. DEKRO HYDROCLAD**
Hydroclad is a self-cleaning, highly durable, copolymer based coating which cures to form a tightly adherent, decorative weatherproof membrane. As a waterborne-system, it is free from strong odour and toxic risk and may be cleaned with using only water on brushes and spray equipment. The Hydroclad membrane will tolerate thermal movement in the substrate without splitting or cracking and will retain its elastomeric properties even after prolonged exposure to ultra-violet light.

Interior ☐
Exterior ☑

# WATER-BASED TOPCOATS Continued…

**8. DEKRO SUPER ACRYLIC (100% PURE ACRYLIC)**
Dekro Super Acrylic is a high quality, washable, matt pure acrylic which dries to a smooth matt finish. Regarded as the most popular grade of emulsion paint. Regarded as the most popular grade of emulsion paint. Dekro Super Acrylic is a pure acrylic recommended for internal/external surfaces.

Interior ☑
Exterior ☑

**9. DEKMORE ACRYLIC**
Dekmore is a high opacity interior/exterior acrylic co-polymer and specially formulated for the painter and decorator. Dekmore is very quick drying with fast re-coating properties. Excellent wall and ceiling finish for interior/exterior surfaces and may be applied direct to new plaster, concrete and various types of composition boarding..

Interior ☑
Exterior ☑

**10. DEKRO SUPER FIBRETEX WATERPROOF COATING**
Most textured coats contain sand, silicate, mica or other coarse particles. These are used to assist in the textured appearance and to bridge cracks. The disadvantage is that these coatings have a high degree of dirt retention.
Super Fibretex is specially formulated with cellulose fibres to give a slight textured appearance and bridge hairline cracks without being too rough. This results in a coating that has low dirt retention, giving a much longer coating life.

Interior ☐
Exterior ☑

**11. DEKROCLAD**
Dekroclad is specially formulated to give a slight sheen appearance and bridge hairline cracks without being too rough. This results in a coating that has low dirt retention, giving a much longer coating life.

Interior ☑
Exterior ☑

**12. DEKRO SOLARDEK UV REFLECTING ROOF PAINT**
Solardek is a top quality pure Acrylic Roof Coating containing solar reflective white pigment. Solardek is a highly recommended finishing paint for roofs of galvanised iron, asbestos cement, cement roof tiles to reflect solar heat. It has outstanding finishes obtained on new and previously painted surfaces in sound condition.
Solardek is recommended for all above surfaces where outstanding adhesion, alkali resistance, water- and weather resistance is required, with added solar heat reflection. Solardek will reduce room temperatures by up to 25% and is widely used for encapsulation of old asbestos.

Interior ☑
Exterior ☑

**13. DEKRO ALLROOF PAINT**
A top quality 100% adhesion promoted pure acrylic roof paint which dries to a low sheen finish for roofs of galvanised iron, asbestos cement and cement roof tiles. Can be applied to damp surfaces. Highly recommended for above surfaces where outstanding adhesion, alkali resistance, water- and weather resistance is required.

Interior ☐
Exterior ☑

# WATER-BASED TOPCOATS Continued…

**13. DEKRO RIPPLETEX**
A flexible, heavy textured coating with excellent water resistance. Rippletex should be used where outstanding durability and waterproofing properties are required. It is designed to cover hairline cracks on old and crazed plaster.

Interior ☑
Exterior ☑

**14. DEKRO HYDROGLAZE (BRICK DRESSING)**
A water-based 100% pure acrylic brick dressing which enhances the natural beauty of brick and cretestone. Dries to a clear silky gloss finish, has excellent adhesion properties and is a highly flexible coating.

Interior ☑
Exterior ☑

**15. DEKRO RAINPROOF**
Rainproof is a waterproofing paint if used as a liquid membrane. A water-based acrylic that can be applied to damp surfaces, which is non-toxic and non-irritant. Resistant to mould and fungus growth.

Interior ☐
Exterior ☑

**16. DEKRO XTERIOR GUARD**
Dekro Xterior Guard is a flexible exterior fibre reinforced waterproofing coating based on a blend of Pure Acrylic polymers.

Interior ☐
Exterior ☑

**17.DEKRO HYDROTEX**
Dekro Hydrotex is a high quality, light textured coating that covers plaster imperfections, surface defects and bridges hairline cracks. It allows a protective flexible barrier against extreme weather elements on exterior walls.

Interior ☐
Exterior ☑

**18.DEKRO PURE MATT ACRYLIC**
Dekro Pure Matt Acrylic is a premium quality interior/exterior matt coating, which is highly washable, stain resistant and has excellent durability and opacity.

Interior ☑
Exterior ☑

**19.DEKRO PURE VELVET**
Dekro Pure Velvet is a premium quality interior/exterior velvet coating, with a low sheen finish which is highly washable, stain resistant and has excellent durability and high opacity.

Interior ☑
Exterior ☑

**20. FLAMELOCK**
Flamelock is water based coating which forms a tough, flexible, chemical resistant membrane with outstanding fire retardant properties.

Interior ☑
Exterior ☑

# WATER-BASED TOPCOATS Continued…

**21. DEKRO RIPPLE TOUCH**
Dekro Ripple Touch is a high quality, heavy textured coating that covers plaster imperfections, surface defects and bridges hairline cracks.

Interior ☑
Exterior ☑

**22. HYDROMED GLOSS**
Hydromed Gloss is a tough, flexible, water based modified acrylic coating which provides the ultimate safeguard against the growth of micro-organisms such as bacteria, mould (fungus) and yeasts. Sterility is achieved by the incorporation of a permanently effective, non-leaching, protective system which is free from heavy metal complexes, phenols and other toxic elements.

Interior ☑
Exterior ☑

**23. HYDROMED MATT**
Hydromed Matt is a tough and highly durable, matt finish, plastics based, decorative coating which protects against the growth of micro-organisms such as mould, fungi, yeasts and bacteria on its surface. Its antimicrobial system does not leach out, unlike those of traditional fungicidal paints, and it therefore remains safe and active throughout the life of the product.

Interior ☑
Exterior ☑

**24. HYDROPLAST**
Hydroplast is a high build, water based, weatherproof coating designed to keep long term maintenance costs to an absolute minimum. Suitable for use internally and externally over all common substrates. In many instances it may be used without a primer and will cure rapidly under normal conditions, often enabling two coats to be applied in the same working day. It contains an active fungistatic system which prevents the growth of mould, fungus and algae on its surface, thereby ensuring that it retains a clean, bright appearance throughout its life span. Hydroplast will not embrittle with age or UV exposure and tolerates thermal movement without cracking or flaking.

Interior ☑
Exterior ☑

**25. HYDROWASH FUNGICIDAL**
Hydrowash Fungicidal is designed to kill active mould, fungal and bacterial growths, and Chlorophyll containing organisms such as moss, lichen and algae prior to application of Hygiene solution primers and membrane systems. It is supplied in the form of a super concentrate with a blue dye to aid identification after application.

Interior ☑
Exterior ☑

# WATER-BASED TOPCOATS Continued…

**26.MEDIFLEX**
**Mediflex is a high gloss, single pack waterborne polyurethane based coating designed with specific hygiene functionality. The in-film preservative is designed to remain permanently locked in and active ensuring no growth of surface micro-organisms.**

Interior ☑
Exterior ☑

**27.METALDEC**
**Metaldec is a chemically modified, non-chlorinated synthetic rubber emulsion which contains a highly effective, zinc phosphate based anti-corrosive system. Consequently, it affords excellent protection against corrosion and weathering and is ideally suited for use over metal substrates in the most demanding climatic conditions.**

Interior ☑
Exterior ☑

**28.METALDEC PLUS**
**Metaldec Plus is a highly advanced waterborne, polyurethane based coating designed for the refurbishment of pre-coated metal cladding. It confers years of weatherproof, maintenance free protection whilst providing an attractive, hard wearing, sheen finish which incorporates an anti-microbial system to combat the growth of unsightly mould on its surface. As Metaldec Plus has low volatile organic content (VOC), it cures without the release of hazardous solvents or odours and also prevents many of the problems associated with moisture cure polyurethanes on the market, such as bubbling and pin-holing. Suitable for application to virtually all pre-coated cladding, including PVC plastisol, it resists UV degradation and exhibits excellent colour retention.**

Interior ☑
Exterior ☑

**29.PREMIUM ACRYLIC PVA**
**Economical wall coating for interior and exterior surfaces. May be applied direct to new plaster and concrete.**

Interior ☑
Exterior ☑

**30.SHEER ACRYLIC**
**Matt finish co-polymer acrylic coating**

Interior ☑
Exterior ☑

**31. SHEER SATIN**
**Pure acrylic satin finish coating**

Interior ☑
Exterior ☑

**32. SHEER SUPER Acrylic**
**High quality matt finish coating**

Interior ☑
Exterior ☑

**33. SHEER TEXTURED**
**Pure acrylic textured waterproofing coating**

Interior ☐
Exterior ☑

# WATER-BASED PRIMERS AND UNDERCOATS

**1. DEKROSEAL PIGMENTED EMULSION SEALER**
An excellent general purpose sealer for chalky surfaces and porous brick surfaces prior to the application of high quality emulsion paint. Alkali resistance, high penetration and sealing properties make Dekroseal ideal for interior and exterior use.

Interior ☑
Exterior ☑

**2. HYDROMETAL PRIMER**
Hydrometal Primer is a waterborne blend of a metal reactive acrylic based emulsion, electrochemically active anti-corrosive pigments, a barrier additive and anti-flash rust agents. It has a plum-red colour in its wet state and an oxide red colour when dry. This product has a very low hazard profile, is environmentally acceptable and safe to use. The primer is very fast drying and has excellent flexibility. It allows good adhesion with our anti-corrosive/barrier top coats, creating an elastic, flexible system. Suitable for use on ferrous metal, galvanised surfaces (degreased), stainless steel, zinc, lead, aluminium, tin and alloys including copper and brass.

Interior ☑
Exterior ☑

**3. DEKRO HYDROBOND 44 (ANTI-RUST METAL PRIMER)**
A water-based anti-corrosive and rust-inhibiting coating. It provides excellent protection for iron and other metal surfaces in a corrosive/industrial environment. It's non toxic, non-irritant, quick drying, lead and chromate free with excellent top coat adhesion.

Interior ☑
Exterior ☑

**4. DEKRO HYDROMET RUST CONVERTION**
Hydromet is unique insofar that an acid emulsion together with tannic acid has been combined so that conversion of the rust forms a protective coating which gives a good measure of protection for further corrosion and serves as a base for subsequent coats of paints. Good barrier properties; ie. very low
water vapour and oxygen permeability.

Interior ☑
Exterior ☑

**5.SHEER WATERBASED PLASTER PRIMER**
Alkali resistant co-polymer waterb ased primer for plaster and cement surfaces

Interior ☑
Exterior ☑

**6.MASONRY AND PLASTER PRIMER**
Dekro Plaster and Masonry Primer is a water based alkali resistant primer and sealer for use on new plaster, cretestone, fibre cement and alkaline surfaces.

Interior ☑
Exterior ☑

**7.HYDROLOCK PRIMER**
Hydrolock Primer is a 2-component water based epoxy.Hydrolock Primer is a rapid curing, water based primer consisting of two components; a pre-reacted epoxy resin dispersed in water (Part A), and a waterborne modified polyamine solution (Part B). In its wet mixed state, it is milky green and slightly viscous.

Interior ☑
Exterior ☑

# SOLVENT-BASED TOPCOATS

**1. DEKRO SUPER HIGH GLOSS ENAMEL**
A top quality high gloss alkyd enamel with excellent gloss, hardness and durability. Suitable for interior and exterior use on a variety of substrates in conjunction with appropriate primers and undercoats.

Interior ☑
Exterior ☑

**2. DEKRO URESHEEN (POLYURETHANE ENAMEL)**
A high quality, non-drip, silky sheen enamel. Suitable for finishing kitchen cupboards, furniture, toys, etc. Possesses remarkable flow and uniform sheen which makes it most suitable for kitchen and bathroom ceilings and walls, etc.

Interior ☑
Exterior ☑

**3. DEKRO EGGSHELL ENAMEL**
A high quality alkyd enamel designed to give hard-wearing abrasion-resistant properties. Pleasant sheen finish with excellent washability.

Interior ☑
Exterior ☐

**4. DEKROLITE MASONRY PAINT**
An outstanding matt coating based on a solvent-based modified acrylic, to give maximum alkali resistance, water vapour permeability and moisture repellency properties. May be employed as primer coat or as a self finish.

Interior ☑
Exterior ☑

**5. DEKRO ADTHANE POLYURETHANE ENAMEL**
A high gloss aliphatic polyurethane coating which dries to a tile-like finish with a mirror gloss. It is noted for its excellent durability, non yellowing properties and gloss retention. Normally recommended for painting of boats, aircraft, vehicles and various appliances. It is recoatable with itself at any stage of its life subject to normal preparation.

Interior ☑
Exterior ☑

**6. DEKRO POLYURETHANE FLOOR COAT**
A ready to use quick drying, glossy enamel designed for application to various substrates (new and old), based on an urethane alkyd binder. It is hard wearing and easy to clean and also prevents disintegration on cement-based floors.

Interior ☑
Exterior ☐

**7. ALKYD STOEP PAINT**
An air drying hard-wearing glossy floor paint designed for application to various substrates (new and old), based on an alkali resisting oleo resinous binder.

Interior ☑
Exterior ☑

# SOLVENT-BASED TOPCOATS Continued…

**8. DEKRO WALKSAFE**
**A twin pack polyurethane floor coating which is extremely tough and non-slip, even in cold and wet conditions. Excellent adhesion to most substrates including concrete, wood, primed metal and fibreglass. Excellent gloss retention, chemical and abrasion resistant.**

**Interior ☑**
**Exterior ☑**

**9.ACRI700**
**Dekro ACRI 700 (Floor Paint) is an Acrylic/Chlorinated Rubber Paint offering excellent resistance to weathering and abrasion. Dekro Acri 700 (Floor Paint) can be applied directly onto any previously painted floor surface if correct preparation is completed.**

**Interior ☑**
**Exterior ☑**

**10.AQUABLOCK**
**Aquablock is a poly-oxo aluminium stearate compound for waterproofing preparation.Dekro Aquablock Water Repellent is based upon a complex aluminium compound with outstanding waterproofing properties and high durability. It is ideal for use on brickwork, concrete and other porous surfaces exposed to the weather. Dekro Aquablock water Repellent can hardly be detected preserving the appearance and character of the substrate. An important property is its ability to reduce dirt retention even on rough substrates.**

**Interior ☑**
**Exterior ☑**

**11.BITUMINOUS ALUMINIUM**
**High lustre Bituminous Aluminium paint. Free from bleeding on bituminous surfaces. Improves illumination and reflects heat.**

**Interior ☑**
**Exterior ☑**

**12. BITUMINOUS BLACK**
**Recommended for sealing absorbent surfaces such as asbestos cement prior to the application of a finishing coat Of Bituminous Aluminium.**

**Interior ☑**
**Exterior ☑**

**13. BAKKIE LINER**
**A two pack Polyurethane which dries to a tough, non-slip and rubberized textured finished.**

**Interior ☑**
**Exterior ☑**

# SOLVENT-BASED TOPCOATS Continued…

**14.DRUIWEBAK PAINT**
Dekro Druiwebak Paint is an Acrylic/Chlorinated Rubber Paint offering excellent resistance to weathering and abrasion. Suitable as a coating for metal and masonry surfaces. Recommended for steel structure farm and factory implements, metal furniture, grape trailers, container coatings, rail cars and marine coatings after primed with a suitable primer.

Interior ☑
Exterior ☑

**15. EPICON**
Epicon Marine Finish, based on a combination of epoxy resin and polyamide curing agent, has high-build excellent durability and adhesion properties. It is suitable as a finish coat for protection of concrete floors.

Interior ☑
Exterior ☑

**16. FLEETCRYL 2K**
Twin Pack Polyurethane.A high performance topcoat for automotive refinishing. A long life coating for structural steelwork, appliances etc.

Interior ☑
Exterior ☑

**17. MOISTURE DISPLACING EPOXY**
A low viscosity Hydrophobic Epoxy resin for the lining of steel, concrete, Fibreglass, Wood, asbestos cement, ceramic tiles and most other building materials. Cures under cold, damp conditions, often used as a primer for polyurethane, polyester and epoxy linings on damp or green concrete.

Interior ☑
Exterior ☑

**18. MS PRIMER FILLER BASE**
Polyester / Isocyanate Filler Primer for use as a high build coating on suitably prepared surfaces

Interior ☑
Exterior ☑

**19.QD HEAT RESISTANT**
Special blend of aluminium paste and heat resisting resins.- Heat fuses paint to form a bright aluminium finish. Ready for use, fast drying aluminium. Heat resistant up to 200°C on exterior surfaces.

Interior ☑
Exterior ☑

**20. QD TRUCK AND TRACTOR**
High quality spraying enamel for the exterior use on trucks, tractors, etc.Superb appearance with a high gloss, good build and opacity. Excellent durability and gloss retention. Wide choice of attractive colours.

Interior ☑
Exterior ☑

# SOLVENT-BASED TOPCOATS Continued…

**21.SHEER GLOSS ENAMEL**
**High gloss finish for interior and exterior surfaces**

Interior ☑
Exterior ☑

**22.SILICON NO 400**
**A silicon resin aluminium paint based on a combination of silicon resin and aluminum pigment. It has excellent heat resistance. It withstands temperatures up to 400℃. It has excellent adhesion to SILICON No.400 PRIMER. It has excellent weathering resistance.**

Interior ☑
Exterior ☑

**23. STANDARD ALUMINIUM**
**Ready mixed leafing aluminium paint. General purpose high lustre aluminium. Protective coating for iron, steel, wood and other surfaces. Improves illumination. Reflects heat**

Interior ☑
Exterior ☑

**24.SCHOOLBOARD BLACK**
**High quality enamel for interior use only. Matt finish with good build and opacity.**

Interior ☑
Exterior ☐

**25.TRAFFIC PAINT**
**Quick drying Roadmarking/Traffic paint with excellent durability. Excellent day and night visibility. Proven performance with Municipalities and Provincial authorities**

Interior ☑
Exterior ☑

**26. TUFFCOAT**
**Tuffcoat is a surface tolerant epoxy coating, designed to protect steel with less surface preparation. Tuffcoat requires less surface preparation (St 2) and sandblasting is not necessary. It has excellent adhesion and can be applied to a slightly damp surface.**

Interior ☑
Exterior ☐

**27,ULTRA QD HAMERTONE**
**A quick drying coating for metal which dries to a Hammertone finish. Hammer Finishes are extensively used for switch boxes, domestic sheet metal ware, instrument cases, electrical components, machinery, office machinery and equipment, prefabricated office panelling and many other varied applications.**

Interior ☑
Exterior ☑

# SOLVENT-BASED TOPCOATS Continued…

**28.WALKSAFE**
Walksafe is a twin pack polyurethane floor coating which contains rubber particles and is extremely tough and non-slip, even in cold and wet conditions.

Interior ☑
Exterior ☑

**29.EVAMARINE**
Evamarine is an alkyd resin based paint with excellent adhesion property, weathering resistance and excellent color retention.

Interior ☑
Exterior ☑

**30.UNYMARINE**
Unymarine, based on polyurethane resin, has excellent gloss retention, durability and chemical resistance, etc. Unymarine is recommended as a glossy finish and is suitable for protection of concrete floors.

Interior ☑
Exterior ☑

**31.EPICON T-500**
EPICON T-500, a high build type epoxy coating, has excellent physical properties such as adhesion, toughness, abrasion resistance, etc. as well as chemical resistance to salt-water, fresh water, petroleum products, crude oil, alkalis and weak acids. It is suitable as a protective coating for tank interiors. It is also a food grade coating for storage of liquids ands solids as per FDA regulations.

Interior ☑
Exterior ☑

**32. UMEGUARD SX**
Umeguard SX is a surface tolerant, modified epoxy paint. It gives adhesion physical properties such as adhesion, toughness and abrasion resistance, etc. and chemical resistance to water, salt water and crude oil. Umeguard SX is recommended for cargo hold, Inside and outside of accommodation space, Void space, Cofferdam, Engine room, Pipe line, Other steel structure, etc.

Interior ☑
Exterior ☑

**33. BANNOH 500**
Bannoh 500, is a multi-purpose primer, which gives excellent physical properties such as toughness, abrasion resistance and adhesion, etc., and has excellent flexibility, resistance to water and cathodic protection. It is suitable for concrete flooring where optimal preparation is not possible.

Interior ☑
Exterior ☑

**34.SEAGRANDPRIX 660/1000**
Sea Grandprix 660 HS is a tin free antifouling paint with self polishing action in service and long protection against marine oganisms. The specific vehicle composition provides an advanced fusion technology during operation, resulting in long lasting antifouling performance. IMO Anti-fouling System convention compliant (AFS/CONF/26).
Sea Grandprix 1000 is recommended as antifouling paint on steel ship's bottom for world wide service with extended dry-docking interval.

Interior ☑
Exterior ☑

# SOLVENT-BASED PRIMERS AND UNDERCOATS

**1. DEKRO UNIVERSAL UNDERCOAT**
**A top quality alkyd-based undercoat for all interior and exterior primed metal, wood, plaster and various types of composition board. Recommended as an undercoat for High Gloss Enamel, and Eggshell Enamel**

Interior ☑
Exterior ☑

**2. DEKRO ALKALI RESISTING PLASTER PRIMER**
**A quick drying alkyd-based primer/sealer for all new interior and exterior porous surfaces such as asbestos cement, plaster, brick and cement. Recommended suitable primer for penetrating and sealing porous, alkaline surfaces prior to overcoating with Universal Undercoat and High Gloss Enamel or emulsion paints.**

Interior ☑
Exterior ☑

**3. DEKRO WOOD PRIMER – PINK / WHITE**
**A top quality primer for interior and exterior wood. Provides an excellent primed surface for Universal Undercoat, Eggshell and High Gloss Enamels.**

Interior ☑
Exterior ☑

**4. DEKROLITE MASONRY PRIMER**
**A styrene acrylic copolymer type coating with outstanding filling, bridging, obliteration and water repellent properties. Recommended for application to new and old plaster surfaces and can also be used as a priming coat for other water-based finishes where a high degree of adhesion and alkali resistance is required.**

Interior ☑
Exterior ☑

**5. DEKRO BONDING LIQUID**
**A bonding sealer for porous gypsum plaster and concrete surfaces. Recommended for penetrating and binding chalked but sound PVA or limewash to the original surface prior to the application of subsequent coats of emulsion paint.**

Interior ☑
Exterior ☑

**6. DEKRO SANDING SEALER (R.F.U.)**
**A sealer for wood surfaces for the filling of open grain and slight imperfections in timber, fibre boards, panelling and furniture. Gives surfaces a smooth base, after sanding, for overcoating with furniture lacquer and varnishes.**

Interior ☑
Exterior ☐

**7. DEKRO TWIN PACK WASH PRIMER**
**A twin pack vinyl-based primer with superior adhesion to new aluminium, galvanised iron, resin bonded fibreglass and similar types of moulded plastic materials.**

Interior ☑
Exterior ☑

# SOLVENT-BASED PRIMERS AND UNDERCOATS Continued…

**8.DEKRO VASBYT SINGLE PACK ETCH PRIMER**
**A quick drying single pack vinyl-based primer with excellent adhesion to galvanised iron or other types of metal surfaces.**

Interior ☑
Exterior ☑

**9.ADPRIME**
**A two component polyamide cured zinc phosphate epoxy primer. Primer for ferrous and non-ferrous substrates, especially where epoxy or polyurethane top coats are to be used.**

Interior ☑
Exterior ☑

**10.U.Q.D ZINC PHOSPHATE PRIMER**
**A cost effective metal primer designed for spray / dipping application of general steelwork where a tough fast drying primer coat is required. After required drying time, can be over-coated with all conventional air drying enamels.**

Interior ☑
Exterior ☑

**11.GP UNDERCOAT**
**A general purpose undercoat for all interior and exterior primed metal, wood, plaster and various types of composition boarding.**

Interior ☑
Exterior ☑

**12.SHEER UNDERCOAT**
**Alkyd based undercoat. Provides good durability to enamel top coats**

Interior ☑
Exterior ☑

**13.MS PRIMER FILLER BASE**
**Polyester / Isocyanate Filler Primer for use as a high build coating on suitably prepared surfaces.**

Interior ☑
Exterior ☑

# WOOD VARNISHES

**1. DEKRO TIMBERTEK**
**A single pack siliconised alkyd varnish with excellent UV resistance and weatherability.**

**Interior ☑**
**Exterior ☑**

**2. DEKROGUARD**
**A water repellent oil-based exterior coating for woodwork. Also contains wood preservatives, has excellent penetrating properties, is extremely flexible and has outstanding weathering properties.**

**Interior ☑**
**Exterior ☑**

**3. DEKRO POLYURETHANE VARNISH – GLOSSY / EGGSHELL / MATT**
**A single pack polyurethane varnish based on a polyurethane oil. A quick drying product with superior mar and abrasion resistance for interior use.**

**Interior ☑**
**Exterior ☐**

**4. DEKRO SPAR VARNISH**
**A high quality varnish containing UV absorbers as an exterior clear coating for natural woodwork. Provides a tough glossy film with waterproofing properties.**

**Interior ☑**
**Exterior ☑**

# MISCELLANEOUS PRODUCTS

**1. DEKRO SUPER PAINT STRIPPER**
**A general purpose paint remover with low wax content. Rinses off with water.**

**Interior ☑**
**Exterior ☑**

**2. DEKRO GALV-O-CLEAN**
**A concentrated alkaline detergent solution, designed to remove surface contaminates oil and grease by its emulsification action prior to rinsing clean with fresh water.**

**Interior ☑**
**Exterior ☑**

**3. DEKRO WUNDA CLEAN**
**A water rinsable solvent, which will emulsify oil and grease prior to the rinsing off and washing down with fresh water. Also an excellent brush cleaner.**

**Interior ☑**
**Exterior ☑**

# THALES APPROVED PRODUCTS

**1. HYDROLOCK**
A top quality twin pack, water-based epoxy primer with excellent adhesion to various kinds of substrates. Hydrolock dries quickly and can be overcoated within 1 hour with both water-based and solvent-based coatings.

Interior ☑
Exterior ☑

**2. DEKRO HYDROSILK (P.S.F.)**
Dekro Hydrosilk is an adhesion promoted plastic satin finish pure acrylic coating. Dekro Hydrosilk has outstanding interior/exterior durability and is stain and scrub resistant. This low sheen coating is non-yellowing and has anti-bacterial, fast drying and over coating properties.

Interior ☑
Exterior ☑

**3.DEKRO HYDROCIDE ANTI-FUNGAL ACRYLIC**
A top quality 100% acrylic emulsion containing a special non-toxic biocide designed to combat bacteria and mould growth. Hydrocide has excellent adhesion and alkali resistance and dries to a flexible, tough sheen finish.

Interior ☑
Exterior ☑

**4.MEDIFLEX**
Mediflex is a high gloss, single pack waterborne polyurethane based coating designed with specific hygiene functionality. The in-film preservative is designed to remain permanently locked in and active ensuring no growth of surface micro-organisms.

Interior ☑
Exterior ☑

**5. HYDROMED GLOSS**
Hydromed Gloss is a tough, flexible, water based modified acrylic coating which provides the ultimate safeguard against the growth of micro-organisms such as bacteria, mould (fungus) and yeasts. Sterility is achieved by the incorporation of a permanently effective, non-leaching, protective system which is free from heavy metal complexes, phenols and other toxic elements.

Interior ☑
Exterior ☑

**6. HYDROMED MATT**
Hydromed Matt is a tough and highly durable, matt finish, plastics based, decorative coating which protects against the growth of micro-organisms such as mould, fungi, yeasts and bacteria on its surface. Its antimicrobial system does not leach out, unlike those of traditional fungicidal paints, and it therefore remains safe and active throughout the life of the product.

Interior ☑
Exterior ☑

**7.ACRI700**
Dekro ACRI 700 (Floor Paint) is an Acrylic/Chlorinated Rubber Paint offering excellent resistance to weathering and abrasion. Dekro Acri 700 (Floor Paint) can be applied directly onto any previously painted floor surface if correct preparation is completed and correct primer used

Interior ☑
Exterior ☑

# THALES APPROVED PRODUCTS Continued…

**8. EPICON**
Epicon Marine Finish, based on a combination of epoxy resin and polyamide curing agent, has high-build excellent durability and adhesion properties. It is suitable as a finish coat for protection of concrete floors.

Interior ☑
Exterior ☑

**9. MOISTURE DISPLACING EPOXY**
A low viscosity Hydrophobic Epoxy resin for the lining of steel, concrete, Fibreglass, Wood, asbestos cement, ceramic tiles and most other building materials. Cures under cold, damp conditions, often used as a primer for polyurethane, polyester and epoxy linings on damp or green concrete.

Interior ☑
Exterior ☑

**10. TUFFCOAT**
Tuffcoat is a surface tolerant epoxy coating, designed to protect steel with less surface preparation. Tuffcoat requires less surface preparation (St 2) and sandblasting is not necessary. It has excellent adhesion and can be applied to a slightly damp surface.

Interior ☑
Exterior ☑

**11. DEKRO HYDROBOND 44 (ANTI-RUST METAL PRIMER)**
A water-based anti-corrosive and rust-inhibiting coating. It provides excellent protection for iron and other metal surfaces in a corrosive/industrial environment. It's non toxic, non-irritant, quick drying, lead and chromate free with excellent top coat adhesion.

Interior ☑
Exterior ☑

**12. DEKROLITE MASONRY PRIMER**
A styrene acrylic copolymer type coating with outstanding filling, bridging, obliteration and water repellent properties. Recommended for application to new and old plaster surfaces and can also be used as a priming coat for other water-based finishes where a high degree of adhesion and alkali resistance is required.

Interior ☑
Exterior ☑

**13. HYDROWASH FUNGICIDAL (Chlorine Free)**
Hydrowash Fungicidal is designed to kill active mould, fungal and bacterial growths, and Chlorophyll containing organisms such as moss, lichen and algae prior to application of Hygiene solution primers and membrane systems. It is supplied in the form of a super concentrate with a blue dye to aid identification after application.

Interior ☑
Exterior ☑

**14. EPICON**
Epicon Marine Finish, based on a combination of epoxy resin and polyamide curing agent, has high-build excellent durability and adhesion properties. It is suitable as a finish coat for protection of concrete floors.

Interior ☑
Exterior ☑

**15. DEKRO ADTHANE POLYURETHANE ENAMEL**
A high gloss aliphatic polyurethane coating which dries to a tile-like finish with a mirror gloss. It is noted for its excellent durability, non yellowing properties and gloss retention. Normally recommended for painting of boats, aircraft, vehicles and various appliances. It is recoatable with itself at any stage of its life subject to normal preparation.

Interior ☑
Exterior ☑

# QUICK GUIDE TO PAINTING

| | Cement Plaster | Skimmed Plaster | Asbestos Cement | Bricks | Cement and Clay Tiles | Wood Painted | Wood Varnished | Composition Board | Paper | Metal Ferrous | Metal Galvanized | Metal Non-Ferrous | Glass | Fibreglass | Plastic | Canvas | Floors | Roads and Signs | Bituminous Surfaces | Chemical Resistance | Heat Resistance | Freeze Resistance | Algae and Mould Resistance | Waterproofing | Coverage / m2 |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| **Primers and 1st Coats** | | | | | | | | | | | | | | | | | | | | | | | | | |
| Adprime No 1. | | | | | | | | | | x | x | x | | | | | | | | x | | x | | | 6 |
| ARP Plaster Primer | x | x | x | x | x | | | | | | | | | | | | | | | | | | | | 6 |
| Bannoh 500 | | | | | | | | | | x | x | | | | | | x | | | | | | | | 5 |
| Clearseal Bonding liquid | x | x | x | x | x | | | x | x | | | | | | | | | | | | | | | | 6 |
| Dekrolite Masonry Primer | x | x | x | x | x | | | x | x | | | | | | | | | | | | | | | | 6 |
| Dekroseal | x | x | x | x | x | | | x | x | | | | | | | | | | | | | | | | 6 |
| Epicon Zinc Rich Primer | | | | | | | | | | x | x | x | | | | | | | | | | | | | 6 |
| Hydrobond 44 | | | | | | | | | | x | x | x | | | | | | | | | | | | | 6 |
| Hydrolock | x | x | x | x | x | x | x | x | x | | | | | x | x | x | x | x | | x | | x | | | 10 |
| Hydromed Rust Conversion | | | | | | | | | | x | x | | | | | | | | | | | | | | 6 |
| Sanding Sealer (R.F.U) | | | | | | | x | | | | | | | | | | | | | | | | | | 6 |
| Sheer Waterbased Plaster Primer | x | x | x | x | x | | | x | | | | | | | | | | | | | | | | | 6 |
| Umeguard SX | | | | | | | | | | x | x | | | | | | x | | | | | | | | 5 |
| U.Q.D Zinc Phosphate Primer | | | | | | | | | | x | | | | | | | | | | | | | | | 6 |
| Vasbyt | | | | | | | | | | x | x | x | | | | | | | | | | | | | 6 |
| Wash Primer | | | | | | | | | | x | x | x | x | x | x | | | | | | | | | | 10 |
| Wood Primer | | | | | | x | | x | | | | | | | | | | | | | | | | | 6 |
| Masonry and Plaster Primer | x | x | x | x | x | | | x | | | | | | | | | | | | | | | | | 6 |

# QUICK GUIDE TO PAINTING Continued…

| | Cement Plaster | Skimmed Plaster | Asbestos Cement | Bricks | Cement and Clay Tiles | Wood Painted | Wood Varnished | Composition Board | Paper | Metal Ferrous | Metal Galvanized | Metal Non-Ferrous | Glass | Fibreglass | Plastic | Canvas | Floors | Roads and Signs | Bituminous Surfaces | Chemical Resistance | Heat Resistance | Freeze Resistance | Algae and Mould Resistance | Waterproofing | Coverage / m2 |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| Standard Aluminium | | | | | | | | | | x | x | | | | | | | | x | | | | | | 8 |
| Schoolboard Black | x | x | x | x | x | x | | x | | x | x | x | | | | | | | | | | | | | 6 |
| Super Acrylic | x | x | x | x | | x | | x | x | | | x | | | | | | | | | | | | | 8 |
| Super Fibretex | x | x | x | x | x | | | | | | | | | | | | | | | | | | | x | 6 |
| Super High Gloss Enamel | x | x | x | x | | x | | x | | x | x | x | x | | x | | | | | | | | | | 8 |
| Tennis Court Acrylic | | | | | | | | | | | | | | | | | x | | | | | | | | 8 |
| Timbertek Varnish | | | | | | | x | | | | | | | | | | | | | | | | | | 8 |
| Traffic Paint | | | | | | | | | | | | | | | | | | x | | | | | | | 6 |
| Tuffcoat | | | | | | | | | | x | | | | | | | x | | | | | x | | | 4 |
| Uresheen | x | x | x | | | x | | | | x | x | x | | | x | | | | | | | | | | 8 |
| Ultra Q.D Hammertone | | | | | | | | | | x | x | x | | | | | | | | | | | | | 6 |
| Unymarine | | | | | | | | | | x | x | | | | | | x | | | | | x | | | 8 |
| Walksafe | | | | | | | | | | | | | | | | | x | | | | | x | | | 2 |

| | Cement Plaster | Skimmed Plaster | Asbestos Cement | Bricks | Cement and Clay Tiles | Wood Painted | Wood Varnished | Composition Board | Paper | Metal Ferrous | Metal Galvanized | Metal Non-Ferrous | Glass | Fibreglass | Plastic | Canvas | Floors | Roads and Signs | Bituminous Surfaces | Chemical Resistance | Heat Resistance | Freeze Resistance | Algae and Mould Resistance | Waterproofing | Coverage / m2 |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| Dekro Non-Drip Enamel | x | x | x | x | x | x | | x | | x | x | x | | | | | | | | | | x | | | 8 |
| Dekro Pure Matt Acrylic | x | x | x | x | | x | | x | x | x | x | x | x | x | x | x | | | | | | | | | 8 |
| Dekro Pure Velvet | x | x | x | x | | x | | x | x | x | x | x | x | x | x | x | | | | | | | | | 8 |
| Dekro Ripple Touch | x | x | x | x | | x | | x | x | x | x | x | x | x | x | x | | | | | | | | | 4 |
| Druiwebak Paint | | | | | | | | | | x | x | x | | | | | | | | | | | | | 8 |
| Eggshell Enamel | x | x | x | x | x | x | | x | | x | x | x | | | | | | | | | | | | | 8 |
| Epicon | x | x | x | | | | | | | x | x | | | | | | x | | | x | | x | | | 7 |
| Epicon T-500 | x | x | x | | | | | | | x | x | | | | | | x | | | x | | x | | | 7 |
| Evamarine | x | x | x | x | x | x | | x | | x | x | x | | | | | | | | | | | | | 8 |
| Fleetcryl 2K | | | | | | | | | | x | x | x | | x | | | x | | | | | x | | | 6 |
| Hydrocide | x | x | x | x | x | | | | | | | | | | | | | | | | | x | x | | 8 |
| Hydroclad | x | x | x | x | x | | | | | | | | | | | | | | | | | | | x | 4 |
| Hydroglaze | | x | | x | | | | | x | | | | | | | | | | | | | | | | 10 |
| Hydromed Gloss | x | x | x | x | x | x | | x | | x | x | x | | | | x | | | | | | | | | 8 |
| Hydromed Matt | x | x | x | x | x | x | | x | | x | x | x | | | | x | | | | | | | | | 8 |
| Hydrometal Primer | | | | | | | | | | x | x | x | | | | | | | | | | | | | 6 |
| Hydroplast | x | x | x | x | x | | | | | | | | | | | | | | | | | | | | 2 |
| Hydrosilk | x | x | x | x | | x | | x | | x | x | x | x | x | x | x | | | | | | x | | | 9 |
| Hydrogloss | x | x | x | x | | x | | x | | x | x | x | x | x | x | x | | | | | | x | | | 8 |
| Hydrowash Fungicidal | x | x | x | x | x | x | x | x | | x | x | x | x | x | x | x | | x | x | x | x | x | x | | 10 |
| Mediflex | x | x | x | x | x | x | x | x | | | x | x | x | x | x | x | | | | | | | | | 8 |

| | Cement Plaster | Skimmed Plaster | Asbestos Cement | Bricks | Cement and Clay Tiles | Wood Painted | Wood Varnished | Composition Board | Paper | Metal Ferrous | Metal Galvanized | Metal Non-Ferrous | Glass | Fibreglass | Plastic | Canvas | Floors | Roads and Signs | Bituminous Surfaces | Chemical Resistance | Heat Resistance | Freeze Resistance | Algae and Mould Resistance | Waterproofing | Coverage / m2 |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| **Undercoats** | | | | | | | | | | | | | | | | | | | | | | | | | |
| GP Undercoat | x | x | x | x | | x | | x | | x | x | x | | | x | | | | | | | | | | 8 |
| Sheer Undercoat | x | x | x | x | | x | | x | | x | x | x | | | x | | | | | | | | | | 8 |
| Universal Undercoat | x | x | x | x | | x | | x | | x | x | x | | | x | | | | | | | | | | 8 |
| | | | | | | | | | | | | | | | | | | | | | | | | | |
| **Top Coats** | | | | | | | | | | | | | | | | | | | | | | | | | |
| Acri700 | x | x | x | x | | | | x | | x | x | x | | x | | | x | x | | x | x | x | | | 8 |
| Adthane Enamel | x | x | x | x | | x | | | | x | x | x | | x | x | | x | x | | x | x | x | | | 7 |
| Alkyd Stoep Paint | | | | | | | | | | | | | | | | | x | | | | | | | | 8 |
| Allflex | x | x | x | x | x | x | | x | | | | | | | | | | | | | | | | | 8 |
| Allroof Acrylic Roof Paint | x | x | x | x | x | x | | x | | x | x | x | | | | | | | | | | | | | 8 |
| Aquablock | x | | x | x | x | | | x | x | | | | | | | x | x | | | | | | | x | 6 |
| Bakkie Liner | | | | | | | | x | | x | x | x | | x | | | x | | | | | | | | 2 |
| Bituminous Aluminium | x | x | x | x | x | | | x | | x | x | x | | | | | | x | x | x | | | | x | 10 |
| Bituminous Black | x | x | x | x | x | | | x | | x | x | x | | | | | | x | x | x | | | | x | 10 |
| Dekmore | x | x | x | x | | | | x | | | | | | | | | | | | | | | | | 8 |
| Dekroklad | x | x | x | x | | x | | x | x | x | x | x | x | x | x | x | | | | | | | | | 5 |
| Dekroguard | | | | x | | | x | | | | | | | | | | | | | | | | | | 6 |
| Dekrolite Masonry Paint | x | x | x | x | x | | | | x | | | | | | | | | | | | | | | | 6 |
| Dekro Xterior Guard | x | x | x | x | | x | | x | | x | x | x | x | x | x | x | | | | | | | | x | 8 |
| Dekro Hydrotex | x | x | x | x | x | | | | | x | x | x | | | | | | | | | | | | x | 6 |

| | Cement Plaster | Skimmed Plaster | Asbestos Cement | Bricks | Cement and Clay Tiles | Wood Painted | Wood Varnished | Composition Board | Paper | Metal Ferrous | Metal Galvanized | Metal Non-Ferrous | Glass | Fibreglass | Plastic | Canvas | Floors | Roads and Signs | Bituminous Surfaces | Chemical Resistance | Heat Resistance | Freeze Resistance | Algae and Mould Resistance | Waterproofing | Coverage / m2 |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| Mediguard | x | x | x | x | | x | | x | | | | | | | | | | | | | | x | x | | 8 |
| Metaldec | | | | | | | | | | x | x | x | | | | | | | | | | x | x | | 6 |
| Metaldec Plus | | | | | | | | | | x | x | x | | | | | | | | | | x | x | | 6 |
| Moisture Displacing Epoxy | | | | | | | | | | | | | | | | | x | | | | | x | | | 1 |
| MS Primer Filler Base | | | | | | | | | | x | x | x | | | | | | | | | | x | | | |
| P/U Floor coat | | | | | | | | | | | | | | | | | x | | | | | | | | 8 |
| P/U Varnish | | | | | | | x | | | | | | | | | | | | | | | | | | 8 |
| Premium Acrylic PVA | x | x | x | x | | x | | x | | | | | | | | | | | | | | | | | 8 |
| QD Heat Resistant | | | | | | | | | | x | x | x | | | | | | | | | x | | | | 6 |
| QD Truck and Tractor | | | | | | | | | | x | x | x | | | | | | | | | | | | | 6 |
| Rainproof | x | x | x | x | | | | | | | x | x | | | | | | | | | | x | | x | 4 |
| Rippletex | x | x | x | x | x | | | | | | | | | | | | | | | | | | | | 4 |
| Seagrandprix | | | | | | | | | | x | x | | | | | | | | | | | | | | 5 |
| Sheer Acrylic | x | x | x | x | | x | | x | x | | | x | | | | | | | | | | | | | 8 |
| Sheer Gloss Enamel | x | x | x | x | | x | | x | | x | x | x | x | | x | | | | | | | | | | 8 |
| Sheer Satin | x | x | x | x | | x | | x | | x | x | x | x | x | x | x | | | x | | | x | | | 8 |
| Sheer Super Acrylic | x | x | x | x | | x | | x | | x | x | x | x | x | x | x | | | x | | | x | | | 8 |
| Sheer Textured | x | x | x | x | x | | | | | | | | | | | | | | | | | | | x | 8 |
| Silicon No 400 | | | | | | | | | | | | | | | | | | | | | x | x | | | 4 |
| Solardek | x | x | x | x | x | | | | | x | x | x | | | | | | | | | | | | | 8 |
| Spar Varnish | | | | | | | x | | | | | | | | | | | | | | | | | | 8 |

# General Health and Safety Protection

**HEALTH MATTERS - PERSONAL PROTECTION**

SKIN: Many paints dry out your skin. Those based on strong solvents have the potential of causing dermatitis. It is advisable to use barrier cream and avoid direct contact.

EYES: The use of goggles is recommended. Avoid direct contact with the eyes.

INGESTION: Wash hands before eating and drinking. Ingestion should always be avoided.

INHALATION: Some solvents and chemicals can be harmful to the respiratory system. It is therefore important to ensure adequate ventilation and use suitable respiratory protection when it is recommended on the Material Safety Data Sheet.

• ***Please contact 0800 222 423 for Material Safety Data Sheets***

**FIRST AID MEASURES**

SKIN: Use a suitable hand cleaner, and then rinse well with water. Clothing which is contaminated should be removed. If there is any discomfort, seek medical attention.

EYES: Rinse immediately with water and go to the doctor.

INGESTION: Do not induce vomiting. Get immediate medical attention.

INHALATION: Move to fresh air. If there is any discomfort, seek medical attention.

• ***Please contact 0800 222 423 for Material Safety Data Sheets***

## FIRE MATTERS - FIRE PROTECTION

Many paints contain flammable solvents. When working with such products, observe the following basic rules:

Avoid smoking.
Ensure no naked flames are in the vicinity.
When spraying, avoid using synthetic clothing such as nylon which can cause static.
Use cotton in a spray booth.
Keep containers cool.
Use earthing-straps when pouring paint.

- ***Please contact 0800 222 423 for Material Safety Data Sheets***

## FIRE FIGHTING

In the event of a paint fire, apply carbon dioxide, dry powder or foam. Do not use a water jet.

- ***Please contact 0800 222 423 for Material Safety Data Sheets***

# THINNER GUIDE

**Although solvents for thinning are mentioned, thinning should mostly be done when products need to be sprayed.**

**Where solvents for thinning are not mentioned, thinning is not recommended.**

**Contact our technical department (toll free: 0800 222 423) for all thinning instructions.**

| | For Cleaning | For Thinning |
|---|---|---|
| **Primers and 1st Coats** | | |
| Adprime No 1. | Epoxy Thinners | Epoxy Thinners |
| ARP Plaster Primer | Turps | |
| Bannoh 500 | Epoxy Thinners | Epoxy Thinners |
| Clearseal Bonding liquid | Turps | |
| Dekrolite Masonry Primer | Turps | |
| Dekroseal | Turps | |
| Epicon Zinc Rich Primer | Epoxy Thinners | Epoxy Thinners |
| Sanding Sealer (R.F.U) | Laquer Thinners | |
| Umeguard SX | Epoxy Thinners | Epoxy Thinners |
| U.Q.D Zinc Phosphate Primer | Spraying Thinners | Spraying Thinners |
| Vasbyt | Etch Prime Thinners | Etch Prime Thinners |
| Wash Primer | Etch Prime Thinners | Etch Prime Thinners |
| Wood Primer | Turps | Turps |

# THINNER GUIDE
# Continued…

**Although solvents for thinning are mentioned, thinning should mostly be done when products need to be sprayed.**

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| | For Cleaning | For Thinning |
|---|---|---|
| **Undercoats** | | |
| GP Undercoat | Turps | Turps |
| Sheer Undercoat | Turps | Turps |
| Universal Undercoat | Turps | Turps |
| | | |
| **Top Coats** | | |
| Acri700 | Acri Thinners | Acri Thinners |
| Adthane Enamel | Polyurethane Thinners | Polyurethane Thinners |
| Alkyd Stoep Paint | Turps | Turps |
| Aquablock | Turps | |
| Bakkie Liner | Polyurethane Thinners | Polyurethane Thinners |
| Bituminous Aluminium | Turps | Turps |
| Bituminous Black | Turps | Turps |
| Dekroguard | Turps | |
| Dekrolite Masonry Paint | Turps | Turps |
| Dekro Non-Drip Enamel | Turps | Turps |
| | | Spraying Thinners |
| Druiwebak Paint | Acri Thinners | Acri Thinners |
| Eggshell Enamel | Turps | Turps |
| | | Spraying Thinners |

# THINNER GUIDE Continued…

**Although solvents for thinning are mentioned, thinning should mostly be done when products need to be sprayed.**

**Where solvents for thinning are not mentioned, thinning is not recommended.**

**Contact our technical department (toll free: 0800 222 423) for all thinning instructions.**

| | For Cleaning | For Thinning |
|---|---|---|
| Epicon | Epoxy Thinners | Epoxy Thinners |
| | | Laquer Thinners |
| Epicon T-500 | Epoxy Thinners | Epoxy Thinners |
| | | Laquer Thinners |
| Evamarine | Turps | Turps |
| Fleetcryl 2K | Fleetcryl 2K Thinners | Fleetcryl 2K Thinners |
| Moisture Displacing Epoxy | Epoxy Thinners | Epoxy Thinners |
| MS Primer Filler Base | Fleetcryl 2K Thinners | Fleetcryl 2K Thinners |
| P/U Floor coat | Turps | Turps |
| P/U Varnish | Turps | Turps |
| QD Heat Resistant | Spraying Thinners | Spraying Thinners |
| QD Truck and Tractor | Spraying Thinners | Spraying Thinners |
| Seagrandprix | Acri Thinners | Acri Thinners |
| Sheer Gloss Enamel | Turps | Turps |
| | | Spraying Thinners |
| Silicon No 400 | Acri Thinners | Acri Thinners |
| Spar Varnish | Turps | |
| Standard Aluminium | Turps | Turps |
| Schoolboard Black | Turps | Turps |
| Super High Gloss Enamel | Turps | Turps |
| | | Spraying Thinners |
| Timbertek Varnish | Turps | Turps |
| Traffic Paint | Spraying Thinners | Spraying Thinners |
| Tuffcoat | Epoxy Thinners | Epoxy Thinners |
| Uresheen | Turps | |
| Ultra Q.D Hammertone | Spraying Thinners | Spraying Thinners |
| Unymarine | Polyurethane Thinners | Polyurethane Thinners |
| Walksafe | Polyurethane Thinners | Polyurethane Thinners |

# INDEX OF SPECIFICATIONS FOR SURFACE COATINGS

# CEMENT PLASTER – Specifications for Surfaces and Conditions

**CEMENT PLASTER**

**General:**
With new cement plaster problems arise mainly from three factors:
1. The presence of moisture.
2. The alkaline nature of some of the surfaces, and the presence of soluble crystalline salts.
3. Water is used in large quantities in new structures and until such time as walls, ceilings, pillars, soffits, etc. have dried out, it is dangerous to apply paints which seal the surface and prevent the natural evaporation of the water still deep in the plaster. An impermeable paint will entrap the moisture which will cause blistering and flaking .
Brickwork, concrete and cement plaster are alkaline from the cement and whilst some of the proprietory skim plasters are not intrinsically alkaline, they can become alkaline if the plasterer adds unslaked lime for easier working. Alkaline salts can leach from brick or cement backings during the drying out process. In the presence of moisture, the alkaline salts will attack the binder in oil paints, causing softening (saponification) of the paint.
The surest way of avoiding problems on these surfaces is to postpone painting until drying of cement plaster is complete, but unfortunately this is rarely possible as plaster can sometimes take many months to dry. When decoration must be carried out at an early stage, the paints used should interfere as little as possible with the drying process and be alkali resistant. In such cases “oil” paints cannot be used as they seal the surface and are attacked by free alkali. Fortunately the modern masonry and acrylic emulsion paints allow free passage of moisture in the wall without affecting the paint film. Of great importance is that this is a one-way passage, ie., water vapour can escape through the acrylic or masonry paint film from the wall to the atmosphere but water cannot penetrate the paint film back into the wall.
Another problem for which there is no cure, not even in the case of 100% acrylic paints, is efflorescence, or the development on the surface of a white crystalline deposit, which is due to the crystallisation of soluble salts formed during drying out, and their growth beneath a paint film will force off the coating. Efflorescence often occurs in the following areas: (i) ground level below dampcourse, (ii) lower portion of walls where there is no dampcourse, (iii) below leaking windowsills, (iv) near ceilings from roof leaks and (v) from leaking pipes in walls.

**Preparation:**
New plaster is not normally subject to cracking initially. Remove dust, dirt, plaster splashes. Clean down generally.

**Previously limewashed or distempered:**
Remove to bare plaster by wire brushing, scraping or high-pressure water blast. Cut out cracks and imperfections, fill and sand smooth when dry.

**Previously oil, enamel, P.V.A. or acrylic painted:**
If the existing paint is in poor condition, remove by scraping or with Dekro Super Paint Stripper. Wash down with a suitable concentrated detergent, rinse and allow to dry. Cut out cracks and imperfections, fill with a recommended crack filler and sand smooth when dry.
If the existing paint is in good condition, wash with a sugar soap solution and rinse clean, or with a suitable solvent to remove dirt, grease, wax polish or other contaminants. Sand glossy surfaces with a suitable abrasive. Rinse clean and allow to dry.

**Painting:**
**N.B.: Allow minimum of overnight drying time for an oil and alkyd-based paint to allow for seasonal low temperatures.**

# SKIMMED PLASTER – Specifications for Surfaces and Conditions

**SKIMMED PLASTER**

General:
See general comments under “Cement Plaster”. Another factor to be taken into account in the case of skimmed plaster, in addition to age, is its texture. With patent plasters such as Glass-stone, Cretestone, other gypsum or keenes types, the surfaces are sometimes trowelled so smooth, compact and hard as to be an almost marble-like finish. Special care must be exercised in the choice of the correct primer coat, as there is often a layer of fine powder on these surfaces. Skimmed plasters are only used on interior walls.
**Preparatio**n:
New:
Remove dust, dirt, plaster splashes. Cut out cracks and imperfections, fill and sand smooth when dry.
Previously limewashed or distempered:
Remove to bare plaster. Cut out cracks and imperfections, fill and sand smooth when dry.
Previously oil, alkyd, P.V.A. or acrylic painted:
If the existing paint is in poor condition, remove by scraping or with Dekro Super Paint Stripper. Wash down with a suitable concentrated detergent, rinse and allow to dry. Cut out cracks and imperfections, fill and sand smooth when dry.
If the existing paint is in good condition, wash with sugar soap and water, a suitable concentrated detergent or suitable solvent to remove dirt, grease, wax polish or other contaminants. Abrade glossy surfaces to form a key for subsequent coats. Rinse and allow to dry..

# FIBRE/ASBESTOS CEMENT – Specifications for Surfaces and Conditions

**FIBRE/ASBESTOS CEMENT**

**General:**
Fibre/Asbestos cement occurs in several forms in buildings, mainly as wall partitions, ceilings, roofing sheets (plain, corrugated), tiles, gutters and down pipes. This material is very absorbent, often highly alkaline, and may contain relatively high concentrations of salts.
"Oil" paints may not be used on new exterior fibre cement surfaces. Blistering and peeling may be caused by moisture which may persist due to entry from the back of the surface, e.g. when gutter, downpipes, etc., are not internally painted and the continued flow of rainwater maintains damp conditions within the asbestos cement.
Fibre/Asbestos cement should be dry before painting. Gutters, (bituminous solution is recommended for inside of gutters), window sills, fascia boards, etc., should be painted on both sides to prevent moisture penetration. For external asbestos cement surfaces, 100% acrylic type emulsion paints or Dekrolite Masonry Paint are preferred because of their high alkali resistance.
Fungus tends to grow on unpainted asbestos cement because it is alkaline and porous, holding moisture and food for spores. It is therefore highly recommended to waterproof unpainted surfaces with Aquablock Water Repellent.

**Preparation:**
**New:**
Ensure surfaces are clean and dust free.
**Previously limewashed or distempered:**
Remove to bare substrate.
**Previously oil, alkyd, P.V.A. or acrylic painted:**
If existing paint is in poor condition, remove by scraping or with Dekro Super Paint Stripper. Wash down with a suitable concentrated detergent solution, rinse and allow to dry. If the existing paint is in good condition wash with soap and water, a suitable concentrated detergent or solvent to remove dirt, grease, wax polish or other contaminants. Abrade glossy surfaces to form a key for subsequent coats, rinse clean – allow to dry.
**Previously painted or unpainted covered with fungus:**
Remove visible fungi and dirt with a suitable asbestos cleaner. Sterilise surface by applying an HTH solution or one coat Hydrowash Fungicidal and leave overnight to dry. Brush down with a stiff bristle brush. Rinse with clean water and allow to dry.

# BRICKS – Specifications for Surfaces and Conditions

**BRICKS**
**General:**
Brickwork presents a particularly variable surface for painting and often paint failures may be isolated to individual bricks owing to great differences in porosity, or to the presence of salts causing efflorescence with its attendant flaking, or the presence of coloured substances such as iron salts causing severe staining especially of water-based paints. Certain types of bricks have highly glazed surfaces and offer a poor key for paint systems. In addition, the greasy film of firmly adherent dirt and grime may cause subsequent flaking. Old exposed brickwork may have a loose powdery surface.
**Preparation:**
**New:**
Remove dust, dirt, plaster splashes.
**Previously limewashed or distempered:**
Remove to bare surface by wire brushing, scraping or washing.
**Previously oil, alkyd, P.V.A. or acrylic painted:**
If in poor condition remove to original surface; if in good condition clean to remove dirt, grease, etc.

## Painting

| | |
|---|---|
| First Coat | Suitable Dekro Primer |
| Second Coat | Suitable Top Coat |
| Third Coat | Suitable Top Coat |

## Brick Dressing

| | |
|---|---|
| First Coat | Hydroglaze / Aquablock |
| Second Coat | Hydroglaze / Aquablock |

# TILES– Specifications for Surfaces and Conditions

**TILES**
**General:**
**Apart from glazed tiles which are available in a wide range of colours and do not normally require painting, a cheaper cement tile is used by the building industry on roofs, windowsills, etc.**
**N.B.: This specification does not refer to floor and wall tiles.**
**Preparation:**
**New:**
**Remove dust, dirt, plaster splashes.**
**Previously oil, alkyd, P.V.A. or acrylic painted:**
**If in poor condition remove to original surface; if in good condition clean to remove dirt, grease, etc.**
**Unpainted covered with fungus:**
**Remove visible fungi and dirt. Apply one coat Hydrowash Fungicidal. Allow to dry then brush down with stiff bristle brush.**
**Rinse with clean water and allow to dry.**

# WOOD PAINTED– Specifications for Surfaces and Conditions

**WOOD-PAINTED**

**General:**
When wood is moisture-laden or unseasoned, the applied paint film will inevitably break down through blistering, cracking, flaking or peeling. When timber arrives on the site in a satisfactory condition, it is often inadequately protected from the weather and rapidly absorbs moisture. It is therefore essential that dry, unprimed timber arriving on site is properly prepared and primed at the earliest opportunity.
All faces and edges must be primed, especially surfaces which will be inaccessible after fixing and will absorb moisture from adjacent brickwork or plaster if unprotected. Special attention should be given to end grain where two coats of primer are recommended.
Wood primers are best applied by brush to ensure that the paint is forced well into the pores of the wood. Joinery stacked on site, even when primed, must be covered to protect it from the weather as a single coat of primer cannot give adequate protection. The use of poor quality primers is false economy and likely to cause breakdown of the whole paint system.
On previously painted surfaces where flaking has occurred, the bare wood may have been exposed to the weather for many months. Unless these surfaces are allowed to dry, there is little chance of the repainting being successful.
Wood which has been exposed for a lengthy period without paint, often becomes denatured and fibirous and in this condition it affords a poor key for paint. In such cases the perished outer layer must be removed by scraping and sanding before applying the primer.

**Preparation:**

**New:**
Remove dust, dirt, grease, etc. Sandpaper smooth and dust off.

**Previously oil, alkyd, P.V.A. or acrylic painted:**
If the existing paint is in poor condition, remove by scraping, burning or with Dekro Super Paint Stripper. Wipe down with a suitable solvent, sand smooth and dust off. If the existing paint is in good condition, wash down with a sugar soap solution, a suitable detergent solution or solvent to remove dirt, grease, wax polish or other contaminants. Sand down glossy surfaces with a suitable abrasive. Rinse and allow to dry thoroughly.

Dekro Zinc Phosphate Primer to nailheads.
Stop and fill nailheads with Plastic Wood and sand smooth.

| | |
|---|---|
| First Coat | Dekro Pink Wood Primer |
| Second Coat | Dekro Universal Undercoat |
| Third Coat | Suitable Top Coat |
| Fourth Coat | Suitable Top Coat |

**Dekro Adthane Polyurethane Enamel**

| | |
|---|---|
| First coat : | Dekro Adthane Enamel thinned 20% with polyurethane thinners |
| Second coat : | Dekro Adthane Enamel |
| Third coat : | Dekro Adthane Enamel |

# WOOD VARNISHED – Specifications for Surfaces and Conditions

WOOD-VARNISHES

General:
The natural beauty of wood is enhanced by the application of clear varnish, which can be used on both soft and hard woods. However, no clear varnish system on wood will stand up for any length of time if the surface is fully exposed to weather. Ultraviolet rays from the sun penetrate the transparent varnish and destroy the structure of the wood causing loss of adhesion and subsequent flaking. Varnishes containing transparent pigments which are U.V. absorbers, are the only varnishes that should be used on exterior exposed natural timber.
Preparation:
New:
Clean to remove dirt, plaster splashes, etc., rub down smooth with sandpaper and dust off.
Previously stained, varnished or lacquered:
If in poor condition, remove all existing stain, varnish or lacquer with Dekro Super Paint Stripper or a strong washing soda solution (1kg per 5 litres warm water), and steel wool. Wash down with vinegar water (1 litre vinegar to 5 litres water) and bleach to a uniform colour with a 10% Oxalic Acid Solution. Neutralize with domestic ammonia, rinse with clean water and leave to dry. Sand smooth and dust off.
Note: 1. Oxalic acid is highly toxic.
2. Light woods such as maple and birch cannot be treated as above.
3. After the above treatment the wood must be absolutely dry before coating.
If in good condition, wash down with sugar soap and water, or solvent to remove dirt, grease, wax polish, etc. Rub down smooth with sandpaper to a matt finish and dust off.
Previously waxed:
Wash down thoroughly with Dekro Wunda Clean or suitable concentrated detergent to remove all traces of Wax, rinse and allow to dry thoroughly. Rub down and dust off. Do a test patch to be sure all wax has been Removed before coating the whole area.

**Dekro Timbertek (Interior/Exterior)**
First coat : Dekro Timbertek thinned 20% with turps
Second coat : Dekro Timbertek
Third coat : Dekro Timbertek
N.B.: Sanding between coats.

**Dekro Glossy Polyurethane Varnish (Interior)**
First coat : Dekro Sanding Sealer. Omit over previously varnished surfaces in good condition
Second coat : Dekro Glossy Polyurethane Varnish
Third coat : Dekro Glossy Polyurethane Varnish

**Dekro Eggshell Polyurethane Varnish (Interior)**
First coat : Dekro Sanding Sealer. Omit over previously varnished surfaces in good condition
Second coat : Dekro Eggshell Polyurethane Varnish
Third coat : Dekro Eggshell Polyurethane Varnish

**Dekro Matt Polyurethane Varnish (Interior)**
First coat : Dekro Sanding Sealer. Omit over previously varnished surfaces in good condition
Second coat : Dekro Matt Polyurethane Varnish
Third coat : Dekro Matt Polyurethane Varnish

**Dekro Spar Varnish (Interior/Exterior)**
First coat : Dekro Sanding Sealer for interior work. Omit over previously varnished surfaces
in good condition
Second coat : Dekro Spar Varnish
Third coat : Dekro Spar Varnish

**Dekroguard (Exterior Wood Treatment)**
First coat : Dekroguard thinned 20% with turps
Second coat : Dekroguard
Third coat : Dekroguard Clear
Note: Dekroguard should only be used over bare wood.

# COMPOSITION BOARD – Specifications for Surfaces and Conditions

**COMPOSITION BOARD**

**General:**
Many types of composition boards, such as woodpulp (fibre) board, gypsum board, acoustic board, asbestos cement board, woodchip board, etc., are used in building constructions.
Fibre building boards tend to warp or buckle if used in humid conditions and under these circumstances it is advisable to paint the backs and edges before fixing. The fibres of some soft fibre boards may be raised if water paints are applied to them and where appearance is important, care must be taken that the paint does not fill the texture as this will impair the acoustic properties. Flat paint, using the minimum number of coats, gives the best results.
Although the harder grades of fibre boards (such as masonite) have a hard, polished surface, they should not be rubbed down, as abrasion will score the board and spoil its appearance. Some of these hardboards contain water soluble materials which bleed into and discolour waterpaints if not sealed off first with an “oil” paint.
**Preparation:**
**New:**
Dust off.
**Previously distempered:**
It is extremely difficult to remove existing powder distemper from composition boards completely without damaging the face of the board through excessive wetting and scraping. Therefore remove as much of the distemper by careful dry sanding and dust off loose powder.
**Previously oil, alkyd, P.V.A. or acrylic painted:**
If the existing paint is in poor condition, remove to bare surface by careful scraping and dry sanding, dust off powder. If in good condition, clean down to remove dirt, grease, etc. Sand glossy surface and dust off.

# PAPER– Specifications for Surfaces and Conditions

**PAPER**

**General:**
Whilst it is not usual to paint paper, it may on occasions be found desirable to do so, eg. overpainting of wallpaper, liningpaper, etc.
“Oil-based” paints should not be applied to paper because they harden and embrittle progressively with age.
Wallpaper adhesive remains water soluble and the paper would automatically bubble due to expansion and softening of the adhesive when overcoated with water based paints.
These bubbles usually disappear when the paint dries.
**Preparation:**
Dust off. Ensure that the paper is adhering firmly.

**Dekro Hydroglaze (Interior/Exterior)**
A coat of Dekro Hydroglaze confers washability to wallpaper.
**Not recommended for wallpapers containing mica.**

**Painting**

| | |
|---|---|
| First Coat | Suitable Top Coat |
| Second Coat | Suitable Top Coat |

# METAL FERROUS– Specifications for Surfaces and Conditions

**METAL (FERROUS)**

**General:**
The protection of iron and steel is a serious problem, and many millions of rands are spent annually to prevent or limit corrosion and on replacement of corroded metal.
**The important factors in the protection of iron and steel by painting are:**
1. The thoroughness of the preparatory work before painting.
2. The type of primer used.
3. The thickness of the paint system.

As far as preparatory work is concerned, it has been shown that the effective life of a paint coating of perfectly clean steel, free from rust and scales, may be up to five times longer than that of the same coating applied to imperfectly cleaned steel. The traditional manual methods of preparing new and old steelwork for painting by chipping, scraping and wirebrushing are far from ideal, as they cannot remove lightly-adherent scale nor deal effectively with rust on pitted or rough surfaces. Alternative methods such as pickling, grit blasting, flame cleaning and chemical derusting are either not practical on erected steel, or may be considered too expensive. It should be realised that the higher initial cost would be more than offset by a reduction in maintenance costs by the longer life of the paint coatings.

For general use on iron and steel, primers incorporating rust-inhibitive pigments must be used, for example, zinc phosphate, metallic zinc, etc., in various binders such as the conventional linseed oil, or alkyd resins, or epoxy resins, etc. Too often cheap and inferior primers are used containing less than the minimum quantities of anti-corrosive pigments to be effective. Such paints do more harm than good as they must first be removed before a systematic and effective painting operation can be carried out.

Steelwork must be primed as soon as possible after it has been prepared, whether on site or at the manufacturer's works, as even a few hours exposure in a damp or contaminated atmosphere will nullify the value of thorough preparation. The thickness of the overall paint is important and at least three full coats must be applied.

**Preparation:**

**New:**
Clean down to remove dirt, grease, oil, etc. Sand or grit blast to remove all rust and millscale. If sandblasting is not economically viable, chip, scrape or wirebrush to remove rust and loose scale back to clean metal. Where it is not possible by manual methods to remove rust from pitted or rough surfaces, apply a proprietory rust convertor such as Dekro Hydromet (RCC) or a similar product in accordance with the manufacturer's instruction. Cleaned and/or treated surfaces must be primed immediately.

**Previously painted:**
If in poor condition, remove by scraping, burning or with Dekro Super Paint Stripper. Then proceed as for new substrate. If in good condition, clean down thoroughly with a suitable solvent to remove dirt, grease, oil, etc. Sand glossy surfaces with suitable abrasive and dust off.

# METAL GALVANISED – Specifications for Surfaces and Conditions

**METAL (GALVANISED)**

**General:**
A galvanised surface, especially when new, is particularly difficult to paint for the following reasons:
1. It is so smooth and does not provide a good key for most paints.
2. It is usually heavily pretreated by the steel manufacturer to prevent white rust on storage and this pre-treatment must be thoroughly removed before paint is applied.
Zinc as a metal can react with the ingredients in some paint to form salts between the paint and the surface, thus further reducing adhesion. It was the practice in years gone by, either to allow the galvanised iron to weather to obtain a surface receptive for paint, or to use mordants such as copper sulphate, vinegar, spirits of salts, etc. These methods are now obsolete having been proved technically unsound.

**Preparation:**

**New**:
Hose or rinse down with clean water to remove heavy dust, grit or organic matter. Clean down with Dekro Galv-O-Clean Degreaser or Galv-Etch by working over the surface using a mop, brush or hessian. Thoroughly rinse down with clean water to remove residues. Note whether the final rinsing water forms a continuous film over the surface. If it does, then cleaning is sufficient, if not, repeat the cleaning operation.

**Previously painted:**
If the existing paint is in poor condition, remove by scraping, burning or with Dekro Super Paint Stripper. Then proceed as for new work.
If the existing paint is in good condition wash down to remove dirt, grease, dust or other contaminants with a suitable concentrated detergent. Abrade glossy surfaces with a suitable abrasive and dust off.

# METAL NON FERROUS – Specifications for Surfaces and Conditions

**METAL (NON-FERROUS)**

**General:**
Aluminium and its alloys are widely used in building construction in the form of flat or ribbed sheets, extruded sections, cast components, etc. Whilst aluminium as a metal is largely self-protective because of its oxide layers, it may require paint for decoration or for protection under very severe corrosive conditions. Sheets and extruded sections have a smooth shiny surface and require pre-treatment to obtain a satisfactory key for paint, whilst cast aluminium requires no pre-treatment other than removal of dirt and grease.
Lead and brass are best left unpainted as paints do not adhere well to these surfaces. Copper must be well abraded before the application of paint.
**Preparation:**
**New**:
Clean to remove grease, dirt, oil, etc., by washing with a suitable concentrated detergent.
**Previously painted:**
If in poor condition, remove with Dekro Paint Stripper. Then proceed as for new work.
If in good condition, clean down thoroughly with suitable solvent to remove dirt, grease, oil, etc. Sand glossy surfaces. Dust off.

| | |
|---|---|
| First Coat | Suitable Dekro Primer |
| Second Coat | Suitable Top Coat |
| Third Coat | Suitable Top Coat |

# GLASS – Specifications for Surfaces and Conditions

**GLASS**

**General:**
Glass does not present a very good surface for painting as it is extremely smooth. Nevertheless, extensive painting, mainly in the form of signwriting is carried out on glass using High Gloss Enamel and frosting using Semi-Gloss and Matt Enamels or Plastic Emulsion paints. Whenever possible, glass should be painted on the unexposed side.

**Preparation:**

**New**:
Wash down well with a suitable concentrated detergent solution to remove dust, dirt, greasiness from handling, etc.
Wipe down glass using methylated spirit and clean cloths.

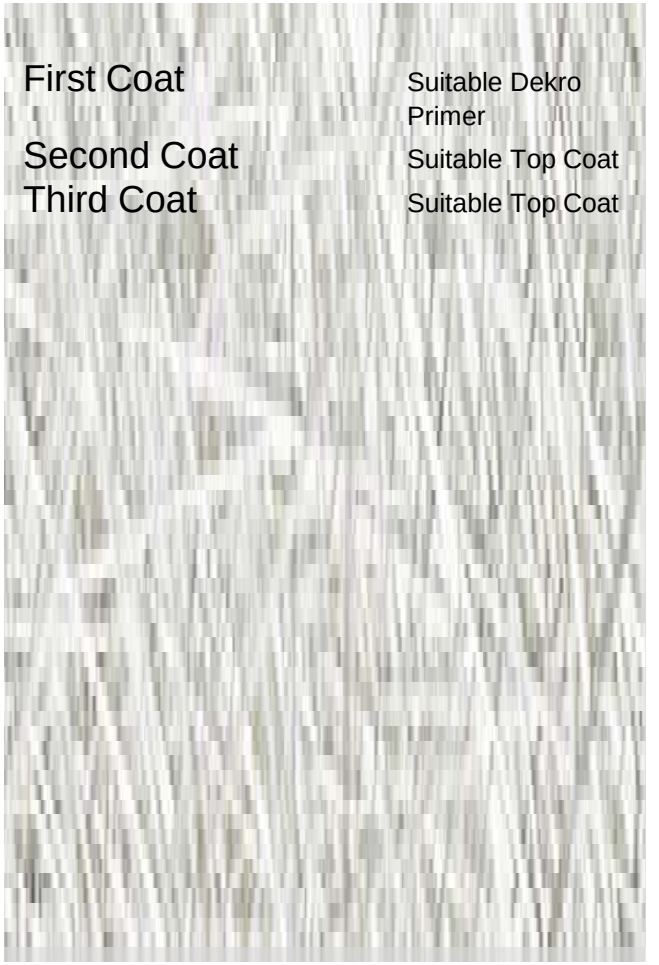
**Previously painted:**
Remove existing paint by scraping, or with Dekro Super Paint Stripper. Then proceed as for new work.
If in good condition, clean down thoroughly with a suitable solvent to remove dirt, grease, oil, etc. Sand glossy surfaces. Dust off.

| | |
|---|---|
| First Coat | Suitable Dekro Primer |
| Second Coat | Suitable Top Coat |
| Third Coat | Suitable Top Coat |

# FIBREGLASS – Specifications for Surfaces and Conditions

**FIBREGLASS**

**General:**
Fibreglass consists of a polyester resin reinforced with glass fibre, cured and hardened chemically through the use of catalysts. It is inherently resistant to weather and chemicals and is painted purely for decoration.
**Preparation:**
**New**:
Wash down well with a suitable concentrated detergent solution to remove mould release agents. Rinse with clean water. Sandpaper lightly and dust off. Sandpaper paint in good condition and dust off.



# PLASTIC – Specifications for Surfaces and Conditions

**PLASTIC**

**General:**
The term “plastic” today covers a very wide range of products of different compositions and characteristics. Because of their great physical strength and corrosion resistance polyethylene and P.V.C. piping are extensively used in the building industry as gutters, downpipes, etc. Many of these are self-coloured, but may require painting on occasion to blend in with the general colour scheme of the structure.

**Preparation:**

**New**:
Remove dust, dirt, oil, etc., by washing down with a suitable concentrated detergent solution. Then abrade with a suitable sandpaper to roughen the surface slightly. This is necessary to ensure good adhesion of the paint.

**Previously painted:**
If in poor condition, remove by scraping, sandpapering, etc. Do not use paint remover. If in good condition clean down and sandpaper lightly. Dust off.

# CANVAS – Specifications for Surfaces and Conditions

**CANVAS**

**General:**
Special products such as copper and zinc napthenate are used for the preservation on canvas. Oils, bitumens and waxes are used for impregnation and waterproofing. All these materials posses the necessary flexibility to withstand constant folding and unfolding. Paints as a rule do not posses the required flexibility, but on the odd occasion some form of painting may be required, e.g. awnings, sails, canoes, etc.

**Preparation:**
Remove gross contamination.

| | |
|---|---|
| First Coat | Suitable Dekro Primer |
| Second Coat | Suitable Top Coat |
| Third Coat | Suitable Top Coat |

# FLOORS – Specifications for Surfaces and Conditions

**FLOORS**

**General:**
When old floors, whether wood, cork, stone, steel, are painted or varnished, special care should be taken that no wax or polish remains on the surface before the paint or varnish coat is applied.
Wax polish can be removed from cement floors by scrubbing with a suitable concentrated detergent solution or Dekro Wunda Clean followed by acid etch, but on wood and cork floors only machine sanding will be effective. Floors covered with linoleum or synthetic/rubberised tiles do not normally take surface coatings.
New cement or stone surfaces must be completely dry and fully hydrated before application of paint or varnish.

**Preparation:**

**New:**
Clean down to remove dust, dirt or other contamination.

**Previously painted or varnished but not polished:**
If in poor condition, remove existing coat to original surface by scraping or with Dekro Paint Stripper. Clean down thoroughly and allow to dry. If in good condition, clean down and sandpaper lightly.

**Previously wax polished:**
Machine sand wood or cork floors. Dust off. Scrub cement floors with a suitable concentrated detergent solution, followed by an acid etch. Wash down with clean water and allow to dry.

**N.B.: It is essential to apply a test patch prior to the application of a floor coating to ensure compatibility, intercoat adhesion, wax removal, etc.**

**N.B.: We recommend that one of our expert technicians be consulted before coating any floor.**

**CEMENT FLOORS**

**Twin Packs (Interior/Exterior)**
First coat : Dekro Suitable Twin Pack thinned 20% with Suitable thinners
Second coat : Dekro Suitable Twin Pack
Third coat : Dekro Suitable Twin Pack

**Single Packs (Interior/Exterior)**
First coat : Dekro Suitable Single Pack Thinned 10% with suitable thinners.
Second coat :Dekro Suitable Single Pack

**Note: Intended for dry cement surfaces, but can be used on wood and suitably primed steel. A reasonablepriced product for areas with light traffic.**

# ROADS AND SIGNS – Specifications for Surfaces and Conditions

**ROADS AND SIGNS**

**General:**
Paint is used extensively for marking road surfaces, kerbs and road signs, as an aid to order and safety.
**Preparation:**
**New:**
Bitumen or concrete roads must be dry. Sweep thoroughly to remove dust, loose dirt and gravel.
**Previously painted:**
Sweep to remove loose paint, dust, dirt and gravel.

# BITUMINOUS AND CREOSOTED SURFACES – Specifications for Surfaces and Conditions

**BITUMINOUS OR CREOSOTED SURFACES**

**General:**
Bituminous paints do not lend themselves to overcoating with ordinary decorative paints, as they usually bleed through after a time and stain the finishing coat brown. Bituminous paints have the disadvantage of being very thermoplastic and finishing coats that cannot cope with the expansion and contraction will tend to crack. Where removal of the coating is not possible, the continued use of a bituminous material is advised. If the bulk of the bitumen has been removed, painting can be carried out reasonably successfully. Creosote or similar wood preservatives cause discolouration (bleeding) and slow drying of ordinary decorative paints. When aged, they can be painted reasonably successfully over a suitable sealer.

**Preparation:**
Painting over thick, soft bituminous coatings or over freshly creosoted timber is not advised. If the bitumen coating is thin and hard, and the creosote well aged, clean down to remove all dirt, dust and grease. Scrape off all loose and flaking material to a firm base.

**Previously painted:**
Sweep to remove loose paint, dust, dirt and gravel.

| | |
|---|---|
| First Coat | Hydrolock Primer |
| Second Coat | Suitable Top Coat |
| Third Coat | Suitable Top Coat |

**Dekro Bituminous Aluminium (Exterior)**
First coat : Dekro Bituminous Aluminium
Second coat : Dekro Bituminous Aluminium

**Dekro Standard Aluminium Paint (Interior/Exterior)**
First coat : Dekro Standard Aluminium Paint
Second coat : Dekro Standard Aluminium Paint

# CHEMICAL RESISTANT – Specifications for Surfaces and Conditions

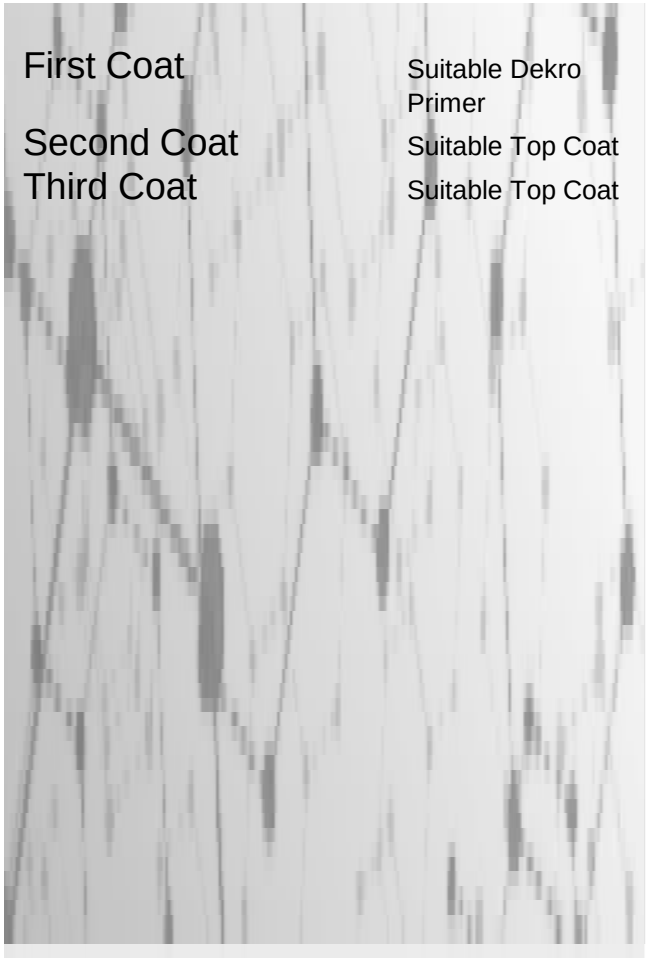
**CHEMICAL RESISTANT**

**General:**
Paint systems which are resistant to particular chemicals such as alkalies, acids, solvents, detergents, oils, fats, etc., are frequently required.
Where chemically resistant paints are required, two main types are available, namely:
i) Epoxy Enamel, based on epoxy resins
ii) Dekro Adthane Polyurethane Enamel (Urethane Acrylic)
It is essential to read thoroughly the comprehensive data sheets to ascertain the correct coating for the particular type of chemical resistance required. We recommend that one of our expert technicians be consulted before coating any important structure.
In each case careful attention must be given to preparation of surfaces, as thorough cleaning and preparation play a particularly important part in high chemical corrosion resistance. Thickness of the coating is of great importance where conditions are severe. Where these coatings have to be used primers and undercoats of the same type must generally be employed, as orthodox primers and undercoats are not always compatible. Finally it should be noted that in constantly corrosive conditions individual coats would become contaminated if left for too long before further coats are applied. Successive coats should therefore be applied without delay.

**Preparation:**

**New:**
Prepare new surfaces as previously outlined under the appropriate headings.

**Previously painted:**
If in poor condition, remove all paint back to the original surface, by scraping, wirebrushing, burning, sanding or with Dekro Paint Stripper.
Dekro Epicon Epoxy Enamel may be applied satisfactorily over existing paint, provided it is hard, in good condition, cleaned down and lightly sanded. Some paints, however, may soften or lift and it is recommended to assess this by small-scale trials. If the existing paint is not satisfactory in this respect, it must be stripped to the original surface.



# HEAT RESISTANT – Specifications for Surfaces and Conditions

**HEAT RESISTANT**

**General:**

Fluctuations in temperature impose more strain of the paint film than lengthy exposure to a steady temperature.

The resistance to moisture and chemical attack diminishes after long exposure at high temperatures. It may be found that a film will withstand several months exposure to high temperature, but may fail rapidly if the plant is closed down and moisture allowed to condense on the surface.

Surfaces subjected to heat or steam radiators, steam coil sand pipes, drying ovens, metal flues, chimneys, smoke stacks, etc.

**Preparation:**

**New**:

Hose or rinse down with clean water to remove heavy dust, grit or organic matter. Clean down with Dekro Galv-O-Clean Degreaser by working over the surface using a mop, brush or hessian. Thoroughly rinse down with clean water to remove residues. Note whether the final rinsing water forms a continuous film over the surface. If it does, then cleaning is sufficient; if not, repeat the cleaning operation.

**Previously painted Section:**

If the existing paint is in poor condition, remove by scraping, burning or with Dekro Super Paint Stripper. Then proceed as for new work.

If the existing paint is in good condition wash down to remove dirt, grease, dust or other contaminants with a suitable concentrated detergent. Abrade glossy surfaces with a suitable abrasive and dust off.

**100ºC – 200ºC**

Apply Dekro Heat Resistant Aluminium paint directly to clean bare metal. Raise temperatures to 150ºC and
maintain for one hour to precure before reaching normal working temperature.

**100ºC – 400ºC**

Apply Dekro Silicon NO.400 aluminium directly to clean metal.

# FREEZE RESISTANT – Specifications for Surfaces and Conditions

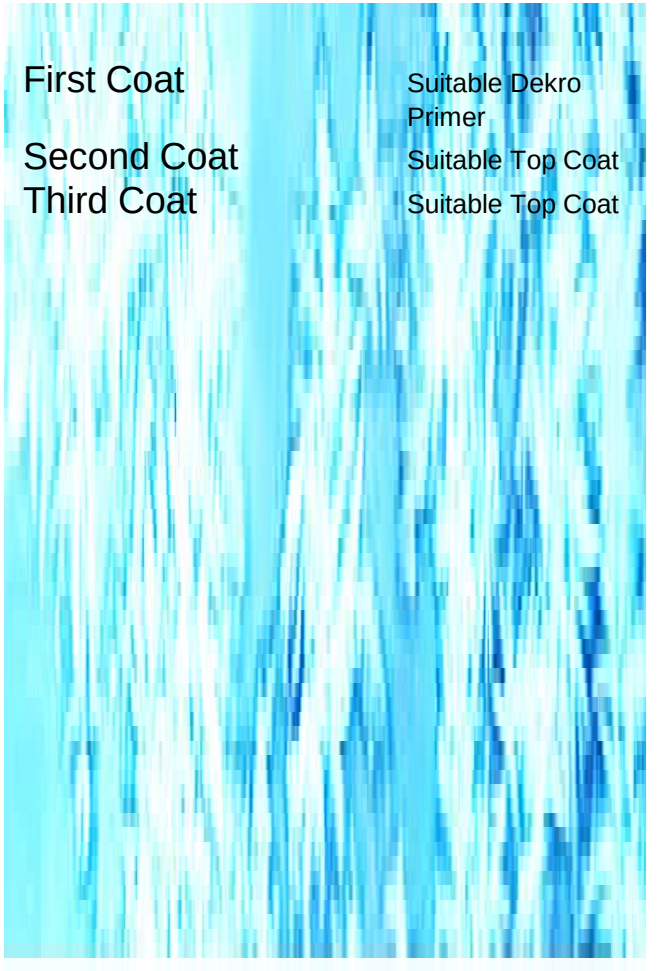
**FREEZE RESISTANT**

**General:**
Temperatures below 5ºC will prevail in most cold storage rooms, the actual operating temperature depending on the particular food product being preserved.
A further requirement would be resistance to various destructive influences such as water and ice, salts, fats, oils, blood, fruit juices, etc.
The paint coating used must also be non-toxic and should not taint food.
Two main products are recommended:
Dekro Hydrosilk for plaster surfaces and Clorinated Rubber for all metals, wood, composition board and plaster.

**Preparation:**

**New:**
Prepare the various surfaces as described under the appropriate headings.

**Previously painted:**
Prepare the various surfaces as described under the appropriate headings. Particular care must be taken to remove all traces of contaminants such as fats, oils, salts, etc.
Where Epoxy Enamel is to replace an old non-epoxy coating, the old coating must be removed completely if not compatible.



# FUNGUS AND ALGAE-RESISTANT – Specifications for Surfaces and Conditions

**FUNGUS- AND ALGAE-RESISTANT**

**General:**
Fungi (mildew or moss) are a low form of plant life existing in hundreds of species. The growth of a specie depends on the particular conditions which suit it, e.g. continuous high humidity, temperature, lack of light and sunshine, still air or whether the base is a nutrient, etc.
Fungus growth occurs in damp rooms and buildings such as lavatories, basements, laundries, breweries, cellars, etc., and outdoors, particularly on asbestos cement roofs.
Fungi may remain dormant for long periods under dry conditions, but are activated when the humidity rises above a certain level.
Algae often occur in south-facing walls during the damp rainy season and are recognised by the bright green colour which appears when completely dry.
**Preparation:**
**New:**
Where growth is expected to occur, surfaces should first be washed down with Hydrowash Fungicidal to destroy any spores on the surface.
**Previously painted:**
Badly infected films must be completely removed to the original surface which must then be treated with Hygiene Solution Primers.
Then proceed as for new work.

# WATERPROOFING – Specifications for Surfaces and Conditions

**WATERPROOFING PAINT SYSTEM**

**General:**

Dekro Rainproof system can be used on: new concrete roofs (after full curing of concrete), asbestos roofs, galvanised iron roofs, new timber roofs, expansion joints and flashings. Also on roofs previously treated with Asphalt, Malthoid or similar combination roof coverings.

**Preparation:**

STANDARD APPLICATION PROCEDURE:

1. Apply to the substrate one primer / sealer coat of Rainproof, diluted with 20% water and allow to dry (drying time is ± 4 hours at standard condition 25ºC and 50% humidity).
2. Apply one coat of Rainproof as supplied, to an area not exceeding one metre by the width of the Polyester Fabric used (Bidum) and firmly press the fabric into the coating, before the Rainproof coating begins to dry. Repeat the process in one metre lengths at a time. Allow the application to dry before proceeding. (Drying time is ±4 hours at standard condition 25ºC and 50% humidity). If the polyester fabric becomes rain saturated, allow to dry out completely over an extended period before proceeding with the application process.
3. Apply one coat of Rainproof, diluted with 20% water, to penetrate and saturate the Polyester fabric (Bidum) surface. Allow the application to dry thoroughly before proceeding. (Drying time is ±4 hours at standard condition at 25ºC and 50% humidity).
4. Finally apply two coats of Rainproof as supplied, allowing to dry between coats. (Drying time per coat is ±4 hours at standard condition 25ºC and 50% humidity).

**New Concrete Roofs:**

Screeding to be inspected and made good if necessary. Scrape all loose materials and sweep clean. Apply standard application procedures 1 – 4.

**Roofs previously treated with old Asphalt, Malthoid or similar combinations:**

Remove all loose material, clean out and fill cracks. Wash and brush down roof to clean surface.
Apply standard application procedures 1 – 4.

**Asbestos Roofs:**

Clean down by brushing, treat where necessary with Hydrowash Fungicidal. Allow to dry and remove dust. Treat screw heads by priming with Hydrobond 44. Treat cracks by priming with one coat Rainproof, diluted with 20% water. Allow to dry. Apply one coat Rainproof as supplied. Press into the coating a suitable patch of Polyester Fabric (Bidum) before the coating dries. Allow to dry. Apply to entire roof. Including patched-up area one coat of Rainproof, diluted with 20% water. Allow to dry. Apply two final coat of Rainproof as supplied.

**Galvanised Iron Roofs:**

Wire brush and wash down to remove all surface contamination. Treat rust areas with rust neutraliser after sandpapering. Treat screw heads by priming with Hydrobond 44. Treat minor holes by applying one coat Rainproof as supplied. Press into the coating a suitable patch of Polyester Fabric (Bidum) before the coating dries.
Apply one coat of Rainproof, diluted with 20% water, over the patched-up area. Allow to dry.
Apply to the entire area, including patches, two coats of Rainproof as supplied, allowing to dry between coats.

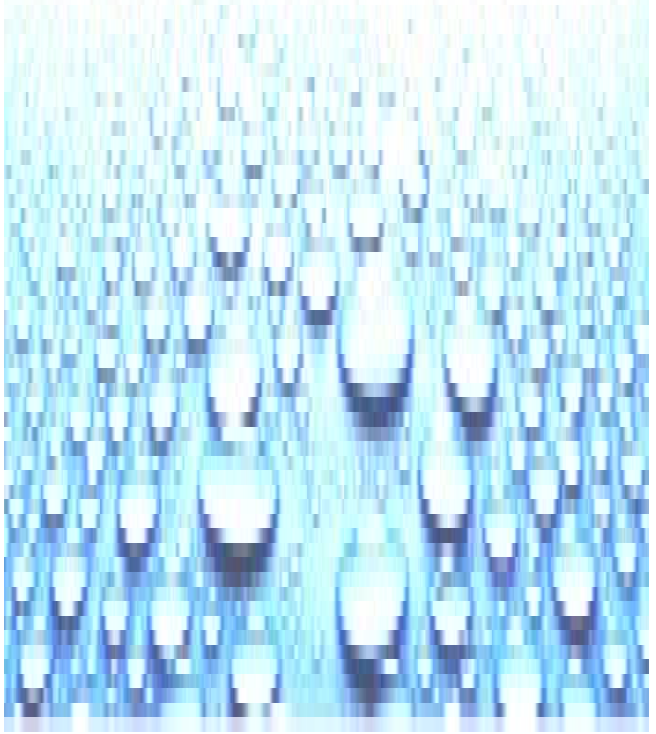
**New Timber Roofs:**

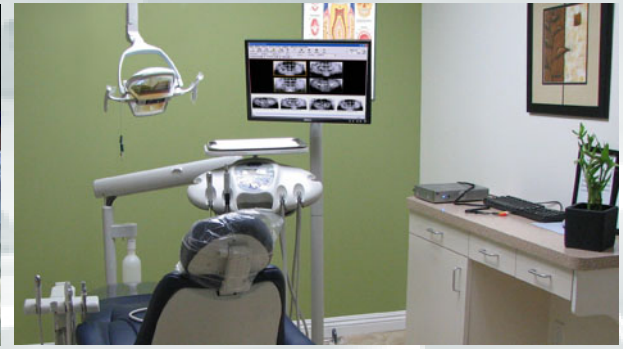
Ensure that the timber is completely dry.
Apply standard application procedures 1 – 4.

**Flashings:**

Apply standard application procedures 1 – 4, ensuring that the ends of the Polyester Fabric (Bidum) are not exposed.

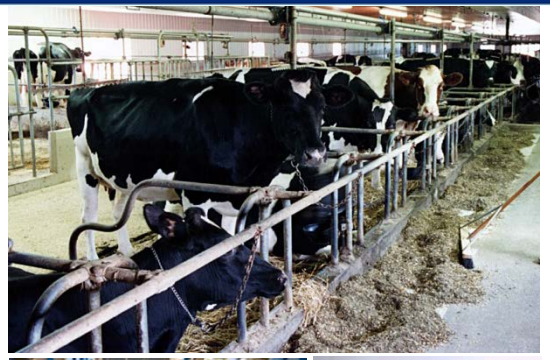
| | |
|---|---|
| First Coat | Suitable Dekro Primer |
| Second Coat | Suitable Top Coat |
| Third Coat | Suitable Top Coat |

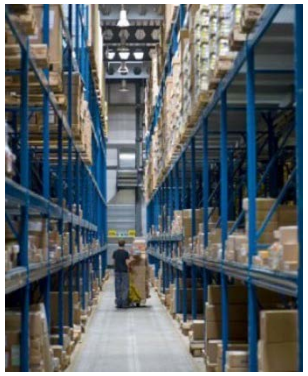




# HYGIENE COATINGS SPECIFICATION MANUAL

# INTRODUCTION TO DEKRO HYGIENE SOLUTIONS





**We have an extensive research and development team with dedicated micro-biological expertise and have forged strong relationships with leading authorities, educational institutions and independent test centres.**
**Consequently Dekro can provide a hygienic range of coatings that represents one of the most advanced hygiene protection solutions currently available. The Dekro Hygienic Range complies with the trend towards water-based and low solvent coating formulations which require greater anti-microbial protection. Certain coatings are Organohalogen free. Our coatings are designed to offer exceptional durability in the most demanding environments. Even in conditions of high humidity and under the most stringent of cleaning regimes, Dekro Hygiene coatings will far outlast traditional gloss paints and other coatings, typically exhibiting life spans in excess of ten years.**

**The following environments are just a few that are particularly susceptible to infections:**

- **hospital**
- **pharmaceutical**
- **hotel**
- **bakery**
- **catering establishment**
- **school**
- **military**
- **prison**
- **food retail chain**
- **food producer**
- **food and fruit storage**
- **sport centres and gymnasiums**
- **dairy**
- **brewery**
- **care home**
- **kitchen / bathroom**
- **Wineries**

**We will endeavour to improve our current product offering and develop new products to provide the best protection solutions in the industry.**

# IMPORTANCE OF HYGIENE COATINGS

**There are many different types of micro-organisms that co-exist with humans in shared environments with the vast majority harmless, causing no potential threat to humans. However, there are still many micro-organisms that can have a negative impact, causing infection and sometimes disease. Infectious disease caused by the growth and colonisation of micro-organisms contribute to millions of deaths in the world each year and in order to protect against the threat of these organisms it is imperative to take effective hygiene measures so as to eradicate or reduce any unnecessary risk.**

**Maximum protection**

**Conventional fungistatic paints release a fungicide by leaching and typically become defenceless against mould and bacteria within a relatively short time. Our special multiple active ingredients are incorporated into the polymer matrix of our hygiene coatings to actively combat the growth of micro-organisms. Our coatings remain active against micro-organisms throughout their long design life. The anti-microbial system does not leach out and washing the surface does not diminish the coating's ability to prevent microbial growth.**

**Safety**

**All our hygiene coatings have water-based formulations, in line with the global trend towards environmentally safe products. Consequently they cure without releasing any strong odour, actively combat the growth of micro-organisms and present no fire risks either during application or whilst curing. In addition, they are Mesatile Oxide free and contain no phenols, mercurials or heavy complexes and will not leach out any biocides or other toxic chemicals.**

**Long-term Savings**

**Unlike many traditional materials, our hygiene coatings don't need to be replaced at the end of their lives; when maintenance is eventually required, a simple re-coat is all that is needed to restore the original performance and life span. Our coatings are designed to offer exceptional durability in the most demanding of environments, with typical life spans in excess of 10 years.**

# IMPORTANCE OF WALL COATINGS

**Safety**
Dekro Hygiene wall coatings are water-based and have no flash point. They may therefore be used without the release of strong odour or harmful solvents, and present no fire risk during application. As a result, although the coatings are designed primarily to perform in aggressive external applications, they may also be used for highly demanding internal projects.

**Aesthetic Appeal**
Many standard colours are available and special colour batches may also be produced to meet particular design requirements or to match the appearance of an existing substrate. In addition, the range also includes a clear weatherproof coating with a highly advanced impregnation system which protects porous materials such as brickwork and stone without significantly altering their appearance.

**Quality Assurance**
All Dekro Paints products are manufactured in accordance with the demands of British Standard, European Norms and ISO 9001, the international standard for quality assurance.

**Technical Services**
In order to assist building owners, designers and specifiers in the selection of the most appropriate system for any given project, Dekro Paints offers free technical and onsite support and the production for detailed written method statements. It is also able to provide a list of contractors who are skilled in the use of the company's products. These services may be arranged through Dekro Paints.

**Further Literature**
The following sections provide detailed information about the standard range of Dekro Paints wall treatments. However, additional technical information is also available on request in the form of Technical Bulletins which describe the results of specific tests, special application techniques and other miscellaneous information.

**Health & Safety**
Safety data sheets for all Dekro Paints products are available on request.

# WHY USE DEKRO?

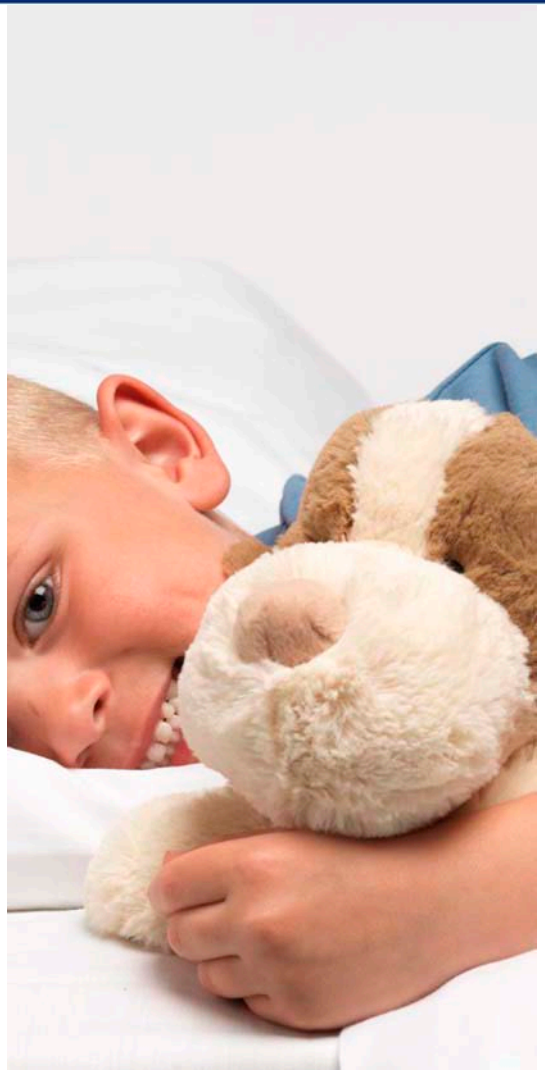
**Dekro has been established since 23 December 1966 and is a leading manufacturer and distributor of paint, coatings and resins. Our Head Office and Factory is in Cape Town and we have comprehensive branch networks and agents throughout South Africa and surrounding countries. We also export products into Africa, Australia, Europe and the Far East and are continually striving to increase our export market.**

**Maximum protection**
**Dekro hygiene coatings incorporate an anti-microbial system which remains effective throughout the design life of each coating, inhibiting the growth of mould and bacteria on its surface.**

**Safety**
**All our hygiene coatings have water based formulations. Consequently, they cure without releasing any strong odour and present no fire risks either during application or whilst curing. In addition, they contain no phenols, mercurials or heavy metal complexes and will not leach out any biocides or other toxic chemical traces that might otherwise contaminate nearby surfaces.**

**Durability**
**Dekro Hygiene coatings are designed to offer exceptional durability in the most demanding environments. Even in conditions of high humidity and under the most stringent of cleaning regimes, Dekro hygiene coatings will far outlast traditional gloss paints and other coatings, typically exhibiting life spans well in excess of ten years.**

**Long term savings**
**Unlike many traditional materials, they need not be replaced at the end of their design lives; when maintenance is eventually required, they may simply be re-coated to restore their original performance and life span.**



**Cost effectiveness**

**The unparalleled durability of Dekro hygiene systems helps to extend the maintenance cycle and to minimise all related material, labour and shutdown costs. The speed with which they can be installed and the ease with which they may subsequently be maintained also helps to create significant cost savings.**

**Wide colour range**

**Dekro Hygiene coatings are available in various standard colours and a choice of finishes. Special colour batches may also be produced to meet specific design requirements.**

**Quality assurance**

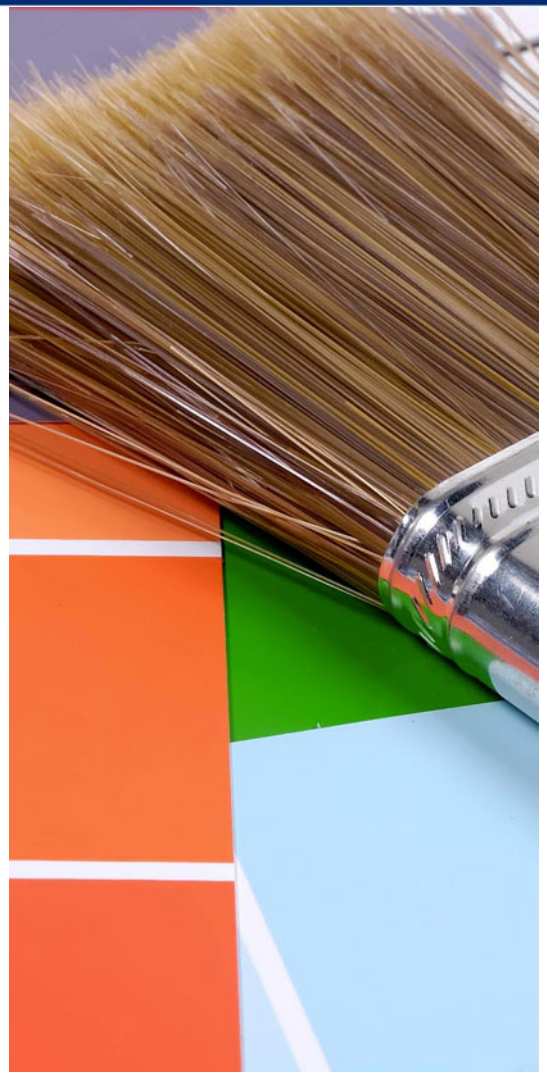
**All Dekro products are manufactured in accordance with SABS standards, the international standard for quality assurance. We also subject our products to British Standards 3900 and British Standards 3177, SABS standards 681 and SABS standards 515. We have been ISO9001 accredited since 1997.**

**Service**

**We are dedicated to maintaining the highest standard of service through our technical support and our distribution network of branches and stockists.**

**Guarantees**

**Comprehensive guarantees are available on request.**



# LIST OF BACTERIA, MOULD (FUNGI) AND YEAST THAT DEKRO HYGIENE SOLUTIONS OFFER PROTECTION AGAINST:

**In hygiene sensitive environments, it is vitally important to protect against the growth of micro-organisms on internal walls and ceilings.**

**Hydromed Matt, Hydromed Gloss and Mediflex contain an active film protectant which kills bacteria on contact and prevents the growth of mould (fungi) and yeast.**

| BACTERIA | HYDROMED MATT | HYDROMED GLOSS | MEDIFLEX |
|---|---|---|---|
| Acinetobacter | √ | | |
| Aerobacter aerogenes | √ | √ | |
| Bacillus megatherium | √ | √ | |
| Bacillus sp | | | √ |
| Bacillus subtilis | √ | √ | |
| Entrobacter aerogenes | √ | √ | √ |
| Escherichia coli | √ | √ | √ |
| Listeria monocytogenes | √ | √ | |
| MRSA | √ | √ | √ |
| Pseudomonas aeruginosa | √ | √ | |
| Pseudomonas fluorescens | √ | √ | √ |
| Pseudomonas putida | | | √ |
| Pseudomonas pyocyanea | √ | √ | |
| Salmonella typhimurium | √ | √ | √ |
| Serratia marcescens | √ | √ | √ |
| Staphylococcus aureus | √ | √ | √ |
| Staphylococcus spp | | | √ |
| Staphylococcus faecalis | √ | √ | |

# LIST OF BACTERIAL INFECTIONS THAT DEKRO HYGIENE SOLUTIONS OFFER PROTECTION AGAINST

**Eschenrichia Coli**
More commonly known as E.Coli, this has been identified as one of the biggest threats to food safety, as the level of bacterial contamination needed to produce food poisoning is very low, fewer than 10 individual bacteria can potentially lead to serious illness. The bacteria are found in undercooked meat products such as beef burgers, as well as other products including milk, yoghurt, raw vegetables and water. It can be spread from person to person if personal hygiene is inadequate.

Mediflex ☑
Hydromed Gloss ☑
Hydromed Matt ☑

**Methicillin Resistant Stryphylococcus Aureus**
MRSA is a form of bacteria which has caused massive problems in hospitals, doctors surgeries and clinics. It causes wound infections in people who have had recent surgery or injury and can cause chronic health problems, amputations or even death. It is one of the most dangerous forms of bacteria, because normal antibiotics do not kill it. An infected patient treated in hospital is usually kept in isolation and once the patient leaves it is imperative that the room be comprehensively cleaned to eradicate the presence of MRSA.

Mediflex ☑
Hydromed Gloss ☑
Hydromed Matt ☑

**Salmonella Typhimurium**
Salmonella is the second most common cause of food poisoning. Contaminated meat products such as burgers, sausages and chicken, are the main causes of infection and a relatively high mortality rate is common with this organism, especially in the elderly, demonstrating the need for safe handling of food and strict hygiene regimes.

Mediflex ☑
Hydromed Gloss ☑
Hydromed Matt ☑

**Candida Albicans**
A type of yeast like fungi present in all human beings; problems can occur when the amount of this yeast becomes abnormal. Symptoms of the Candida infection include thrush, athlete's foot and migraines. Even though Candida species are normally confinedto the human body there are frequently cases where it has been discovered in hospitals, on food, counter tops and floors. It is imperative that all of these areas are impeccably clean at all times.

Mediflex ☑
Hydromed Gloss ☑
Hydromed Matt ☑

# LIST OF YEAST THAT DEKRO HYGIENE SOLUTIONS OFFER PROTECTION AGAINST

| MOULD (FUNGI) / YEASTS | HYDROMED MATT | HYDROMED GLOSS | MEDIFLEX | MOULD (FUNGI) / YEASTS | HYDROMED MATT | HYDROMED GLOSS | MEDIFLEX |
|---|---|---|---|---|---|---|---|
| Absidia sp | √ | √ | | Mucor mucedo | √ | √ | |
| Aspergillus flavus | √ | √ | √ | Mucor racemosus | | | √ |
| Aspergillus fumigates | √ | √ | | Oidium lactis | √ | √ | |
| Aspergillus niger | √ | √ | √ | Penicillium expansum | | √ | |
| Aspergillus ochraceous | √ | √ | | Penicillium sp | | | √ |
| Aspergillus sp | | | √ | Penicillium spp | √ | √ | |
| Aspergillus sulphreus | √ | √ | | Penicillium brevicompactum | √ | √ | |
| Aspgergillus veriscolor | | | √ | | | | |
| Aureobasidium pullulans | √ | √ | | Penicillium digitatum | √ | √ | |
| Basidium sp | | | √ | Penicillium notatum | √ | √ | √ |
| Candida albicans | | √ | √ | Penicillium purporogenem | | √ | |
| Chaetomium crispatum | √ | √ | | Phoma violacea | | √ | |
| Chaetomium globosum | √ | √ | | Pullularia pullulans | √ | √ | |
| Cladosporium cladosporioides | | √ | | Rhizopus | √ | √ | |
| | | | | Rhizopus nigricans | √ | √ | |
| Cladosporium spp | √ | √ | | Rhodotorula rubra | | √ | |
| Cladosporium herbarum | √ | √ | | Sacharomyces cerevisiae | √ | √ | |
| Cladosporium resinae | √ | √ | √ | Sproblomyces roseus | | √ | |
| Coriolus versicolor | | | √ | Stachybotrys atra | | √ | |
| Fusarium monoliforme | √ | √ | | Trichophylum mentagrophyles | | √ | |
| Fusarium oxysporum | | | √ | | | | |
| Kloekera spp | √ | √ | | Tricoderma viride | √ | √ | |
| Mucor spp | √ | √ | | Ulocladium atrum | | √ | |

# TABLE OVERVIEW OF HYGIENE COATINGS FOR SPECIFIC ENVIRONMENTS

**The table below is designed to give an indicative overview of which hygiene coatings are most suited to which environments.**
**The information provided is a guide only and is by no means exhaustive, as the flexibility and adaptability of our coatings means that they can be displayed below. For more detailed description and individual products and their capabilities.**

**Hyrdromed Matt - Single pack, modified acrylic, anti-microbial coating with matt finish.**

**Hydromed Gloss - Single pack, modified acrylic, anti-microbial coating with a mid-sheen finish.**

**Mediflex - Rapid drying, single pack, waterborne polyurethane, anti-microbial coating with a gloss finish.**

| | | Hydromed Matt | Hydromed Gloss | Mediflex |
|---|---|---|---|---|
| Health & Hospitals | Operating Theatres | √ | √ | √ |
| | Kitchens | | √ | √ |
| | Wards | √ | √ | √ |
| | Corridors | √ | √ | √ |
| | Bathrooms | √ | √ | √ |
| | Shower Areas | √ | √ | √ |
| Food & Beverage | Preparation Areas | √ | √ | |
| | Laboratories | | √ | √ |
| | Processing | | √ | √ |
| | Storage | √ | √ | |
| | Refrigeration | √ | √ | √ |
| | Changing Areas | √ | √ | √ |
| Pharmaceutical | Cleanrooms | √ | √ | √ |
| | Corridors | √ | √ | |
| | Laboratories | √ | √ | √ |
| | Storage | √ | √ | |
| | Changing Areas | √ | √ | √ |
| | Shower Areas | √ | √ | √ |
| Leisure | Swimming Pools | √ | √ | |
| | Gyms | √ | √ | √ |
| | Kitchens | | √ | √ |
| | Changing Areas | √ | √ | √ |
| | Shower Areas | √ | √ | √ |
| Food Retails | Food Preparation | | √ | √ |
| | Storage | √ | √ | |
| | Kitchens | | √ | √ |
| | Serving Areas | | √ | √ |
| Prisons | Kitchens | | √ | √ |
| | Changing Areas | | √ | √ |
| | Shower Areas | | √ | √ |

# HYGIENE SUBSTRATE COMPATIBILITY

| SUBSTRATE | PRE-TREATMENTS REQUIRED | PRIMERS REQUIRED 8-12m² / ℓ (0.83 – 0.125 ℓ /m²) | 1st COAT |
|---|---|---|---|
| Asbestos Cement | Hydrowash Fungicidal<br>Locally reinforced joints, cracks etc.<br>Abrade bolt heads and use AMP | Hydrolock<br>25% dilution or Hydrolock<br>25% dilution | **Hydromed Matt 3.6m² / ℓ (0.275 ℓ/m²)**<br>**Hydromed Gloss 6m² / ℓ (0.166 ℓ/m²)**<br>Mediflex 10m² / ℓ (0.11/m²) |
| Bricks & Stone | Hydrowash Fungicidal<br>Re-grout, Proprietary filler | Hydrolock<br>Hydrolock | Hydromed Matt 3.6m² / ℓ (0.275 ℓ/m²)<br>Hydromed Gloss 6m² / ℓ (0.166 ℓ/m²) |
| Blockwork | Hydrowash Fungicidal<br>Monoseal | Hydrolock<br>Hydrolock | Hydromed Matt 3.6m² / ℓ (0.275 ℓ/m²)<br>Hydromed Gloss 6m² / ℓ (0.166 ℓ/m²) |
| Cement / Concrete | Hydrowash Fungicidal<br>Monofill | Hydrolock<br>25% dilution or Hydrolock | Hydromed Matt 3.6m² / ℓ (0.275 ℓ/m²)<br>Hydromed Gloss 6m² / ℓ (0.166 ℓ/m²) |
| Lining Board | Hydrowash Fungicidal<br>Reinforce or fill joints/rebates | Hydrolock<br>Hydrolock | Hydromed Matt 3.6m² / ℓ (0.275 ℓ/m²)<br>Hydromed Gloss 6m² / ℓ (0.166 ℓ/m²) |
| Glass | Degrease | Apply direct | Hydromed Matt 3.6m² / ℓ (0.275 ℓ/m²) |
| Insulation Materials | None | Hydrolock or apply direct<br>Hydrolock or apply direct | Hydromed Matt 3.6m² / ℓ (0.275 ℓ/m²)<br>Hydromed Gloss 6m² / ℓ (0.166 ℓ/m²) |
| Mastics | Hydrowash Fungicidal | Hydrolock<br>Hydrolock<br>Hydrolock | Hydromed Matt 3.6m² / ℓ (0.275 ℓ/m²)<br>Hydromed Gloss 6m² / ℓ (0.166 ℓ/m²) |
| Metal | Degrease (T.Wash)<br>Abade<br>Blast (Sa 2½) | Hydrometal Primer<br>Hydrometal Primer<br>Hydrometal Primer | Hydromed Matt 3.6m² / ℓ (0.275 ℓ /m²)<br>Hydromed Gloss 6m² / ℓ (0.166 ℓ /m²)<br>Mediflex 10m² / ℓ (0.11m²) |
| Plaster / Render | None | Hydrolock<br>Hydrolock or 25% dilution | Hydromed Matt 3.6m² / ℓ (0.275 ℓ /m²)<br>Hydromed Gloss 6m² / ℓ (0.166 ℓ /m²) |
| Plastics | Abrasion<br>Degrease | Apply direct or Hydrolock<br>Apply direct or Hydrolock<br>Apply direct | Hydromed Matt 3.6m² / ℓ (0.275 ℓ /m²)<br>Hydromed Gloss 6m² / ℓ (0.166 ℓ /m²)<br>Mediflex 10m² / ℓ (0.11m²) |
| Tiles (Glazed) | Re-grout<br>Hydrowash Fungicidal<br>Degrease & Abade | Hydrolock<br>Hydrolock | Hydromed Matt 3.6m² / ℓ (0.275 ℓ /m²)<br>Hydromed Gloss 6m² / ℓ (0.166 ℓ /m²) |
| Timber | Knot stop | Hydrolock<br>Hydrolock<br>25% dilution | Hydromed Matt 3.6m² / ℓ (0.275 ℓ /m²)<br>Hydromed Gloss 6m² / ℓ (0.166 ℓ /m²)<br>Mediflex 10m² / ℓ (0.11m²) |
| Painted Surfaces | Hydrowash Fungicidal | Hydrolock or apply direct<br>Hydrolock or apply direct<br>Apply direct | Hydromed Matt 3.6m² / ℓ (0.275 ℓ /m²)<br>Hydromed Gloss 6m² / ℓ (0.166 ℓ /m²)<br>Mediflex 10m² / ℓ (0.11m²) |

# DURABILITY OF WALL COATINGS

**Further Literature**

**The following sections provide detailed information about the standard range of Dekro Paints wall treatments. However, additional technical information is also available on request in the form of Technical Bulletins which describe the results of specific tests, special application techniques and other miscellaneous information.**

**Systems Guide**

**The following tables are designed to provide a general indication as to which systems are best suited to the demands of typical wall treatment projects. However, given that individual customer requirements and substrate conditions other differ very widely, it is impossible to outline a definite treatment for each of the substrates listed below.**

**Health & Safety**

**Please contact Dekro Paints on (Toll free) 0800 222 423 for Safety Data Sheets on all Dekro Paints products.**

| System | Basis | Anticipated Durability |
|---|---|---|
| Hydroclad system 1 (2 coats)[2] | Waterborne styrene butadiene copolymer | At least 10 years[3] |
| Hydroclad system 2 (2 coats)[2] | Waterborne styrene butadiene copolymer | At least 15 years[3] |
| Hydroplast (1 coat)[2] | Waterborne styrene acrylic copolymer | At least 5 years[3] |
| Hydroplast (2 coat)[2] | Waterborne styrene acrylic copolymer | At least 15 years[3] |
| Metaldec Plus | Waterborne spolyurethane | At least 10 years[3] |
| Dekro Aquablock Water Repellant | Masonry Waterproofing Solution | At least 10 years[3] |

**1. Durability to first maintenance. Hygiene coatings may subsequently be overcoated to restore the integrity of the membrane.**

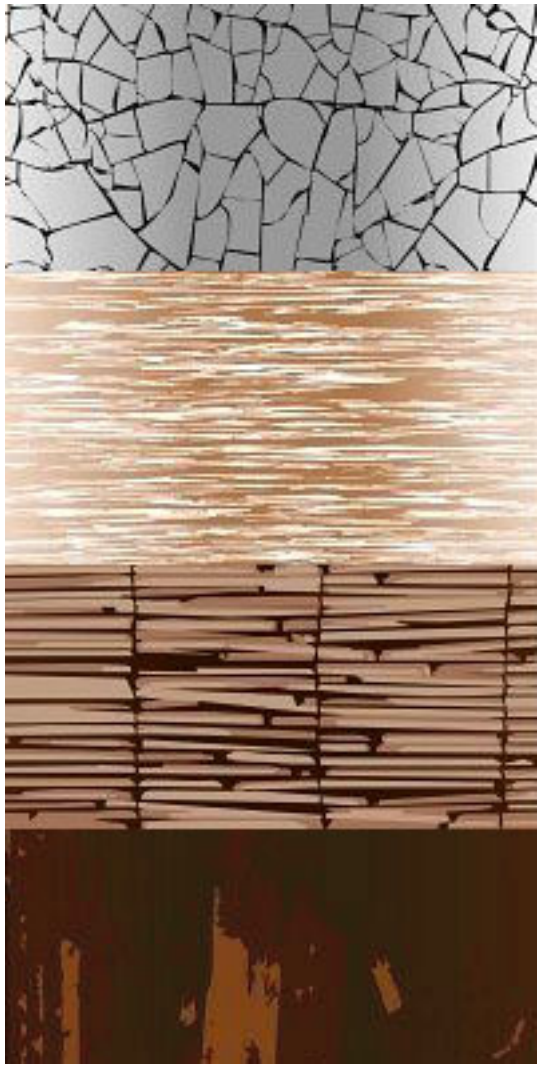
**2. May be reinforced with Chopped Strand Matt reinforcement for additional strength and durability.**

**3. Applications have been recorded where the Hydroclad membrane has lasted well over 25 years.**

**4. This is a minimum figure but life spans in excess of 30 years are expected.**

# COMPATIBILITY OF DEKRO WALL COATINGS TO VARIOUS SUBSTRATES

| Substrate / System | Hydroclad | Hydroplast | Metaldec Plus | Dekro Aquablock Water Repellant |
|---|---|---|---|---|
| Asbestos Cement | Yes | Yes | No | Yes |
| Bricks, Blocks & Stone | Yes | Yes | No | Yes |
| Cementitious Materials | Yes | Yes | No | Yes |
| Glass | No | No | No | No |
| Insulation Materials | Yes | No | No | No |
| Lining Boards | Yes | Yes | No | No |
| Mastics | Yes | Yes | No | No |
| Metals | Yes | Yes | No | No |
| Paints | Yes | Yes | No | No |
| Plaster | Yes | Yes | No | No |
| Plastics | Yes | Yes | No | No |
| Pre-coated Metal | No | No | Yes | No |
| Tiles | Yes | Yes | No | No |
| Timber | Yes | Yes | No | No |



**Note: Please refer to the Dekro Representative for specification advice on the various substrates.**

# HYGIENE SYSTEMS GUIDE

**The systems guide that follows gives a comprehensive overview of the coverage rates required for the various hygiene control coating systems, the types of reinforcement that can be incorporated, the dry film thickness and details of how many coats are typically required to achieve the finished system.**

**When referring to the table, please note that a combination of different Dekro Paints hygiene coatings can be used to produce a finished system. Unless otherwise stated, the product applied is that named in the 'System' column. Also note that the 'System' refers to which top-coat the system has.**

**The rates quoted are for smooth, sealed surfaces. Rough, porous, absorbent or undulating surfaces will inevitably increase the quantity of coating required, particularly at the first coat or embedment stage, to achieve the necessary film thickness and a pin-hole free finish.**

**Always allow primers and any previous coat to dry/cure thoroughly before applying the following coat. The time taken to cure will depend upon the ambient temperature and relative humidity, but in many cases, Dekro Paints hygiene coatings will dry sufficiently quickly to allow two coats to be applied on the same day. If in doubt, allow to cure overnight.**

| System | Embedment Coat m²/L/ (L/m²) | Reinforce-ment | 2nd Coat m²/L/ (L/m²) | 3rd Coat m²/L/ (L/m²) | 4th Coat m²/L/ (L/m²) | Dry Film Thickness |
|---|---|---|---|---|---|---|
| Hydromed Matt | - | - | 3.6m²/L (0.275L/m²) | - | - | 325 microns |
| Hydromed Matt with Chopped Strand Matt | 2m²/L (0.5L/m²) | Chopped Strand Matt | 2m²/L (0.5L/m²) | - | - | 635 microns |
| Hydromed Gloss | - | - | 6m²/L (0.165L/m²) | 6m²/L (0.165L/m²) | - | 140 (210)[1] microns |
| Hydromed Gloss with Chopped Strand Matt | Hydromed Matt 2m²/L (0.5L/m²) | Chopped Strand Matt | 6m²/L (0.165L/m²) | 6m²/L (0.165L/m²) | - | 410 microns |
| Hydromed Gloss with Chopped Strand Matt | 4m²/L (0.25L/m²) | Chopped Strand Matt | 4m²/L (0.25L/m²) | 6m²/L (0.165L/m²) | - | 340 microns |
| Hydromed Gloss with Chopped Strand Matt | Hydromed Matt 2m²/L (0.5L/m²) | Chopped Strand Matt | 6m²/L (0.165L/m²) | 6m²/L (0.165L/m²) | - | 650 microns |
| Mediflex | - | - | 10m²/L (0.1L/m²) | 10m²/L (0.1L/m²) | - | 72 (108)[1] microns |
| Mediflex with Chopped Strand Matt | Hydromed Matt 2m²/L (0.5L/m²) | Chopped Strand Matt | 10m²/L (0.1L/m²) | 10m²/L (0.1L/m²) | - | 360 microns |
| Mediflex with Chopped Strand Matt | Hydromed Gloss 4m²/L (0.25L/m²) | Chopped Strand Matt | Hydromed Gloss 4m²/L (0.25L/m²) | 10m²/L (0.1L/m²) | 10m²/L (0.1L/m²) | 320 microns |
| Mediflex with Chopped Strand Matt | Hydromed Matt 2m²/L (0.5L/m²) | Chopped Strand Matt | 10m²/L (0.1L/m²) | 10m²/L (0.1L/m²) | - | 625 microns |

# FREQUENTLY ASKED QUESTIONS?

***How do you determine the moisture level of a wall or other surface before painting?***

**It is very important to ensure that the moisture levels of walls or wood surfaces are suitable for paint. Damp is often the cause of discoloured plaster, loose wallpaper, peeling paint and 'tell tale' damp patches. Some damp can be noticed by mould growth or a musty odour. Often damp cannot be seen which, left unchecked, will cause problems. The most accurate way to determine moisture levels is with a damp detector. It will assess acceptable moisture levels and indicate excessive moisture requiring remedial action. Damp testing should be done methodically. Start outside, determining strategic places for damp. Examine the inside for potential problem areas. Important areas to test: floors and joints, door and window frames, skirting boards, walls, chimney breasts, inside cupboards and under the stairs, ceilings, especially under flat roofs, bathrooms, loft space. The detector can locate the source of moisture by taking different readings on the same wall. We can assist you with damp testing.**

***Can you explain why the colour in the paint can is not the same when it dries out on the walls?***

**The explanation begins with the fact that the components of paint reflect light differently when they are wet (in-can) compared to when they are dried (on the wall). These subtle differences are quite common and not a reflection on the quality of a paint product. A handy tip to make sure you are happy with the end colour on your wall is to use a sampler pot, apply the paint and check how it looks after drying.**

***Can I use a water-based paint over areas previously painted with solvent-based paint?***

**In short, yes you can. However some preparation is required before you start. First the surface needs to be sanded to a dull finish with a fine grit sandpaper, then wiped off with a damp cloth. A top quality pure acrylic water-based paint can then be applied quite successfully.**

***How should I paint on fresh plaster?***

**Fresh plaster should be allowed to dry thoroughly over a period of weeks depending on how thick the layer of plaster is and the ventilation in the room. Usually the plaster changes to a pale colour when drying and feels powdery smooth to touch. Once dry apply a quality primer followed by 1-2 layers of a high quality topcoat.**

*When and why is using a primer important?*

**Priming is essential when the surface is porous in any way, the surface has never been painted before or when the surface contains substances which can bleed through (eg. dirt, water and tobacco stains, tannins in wood such as mahogany). Priming has an important role; it blocks out staining materials from the surface being painted, it provides a good base for a uniform topcoat appearance and ensures maximum adhesion to the surface being painted. Primers can be solvent-based or water-based.**

*What if I just paint over the spores on my wood siding?*

**That will probably seal them in. It may solve your problem, but will give a pebbly appearance to your paint job. Each repainting will seal in the artillery fungus even more and your fungus problem will re-appear all the time.**

*Are there any registered fungicides that will kill the fungus? How about a weak solution of household bleach?*

**Mold and mildew can be a problem in areas that have high humidity and poor ventilation such as bathrooms kitchens, wine cellars, etc. bleach, would be very temporary, as it leaches out. Thales Wine Cellar Services have tested and approved our Hydrowash Fungicidal as safe for use and pose no risk of organohalogen contamination.**

*I have a mould problem in my bathroom. What is the easiest way to get rid of it and what should do to prevent it coming back?*

**The easiest way to get rid of mould is by washing the surface with Hydrowash Fungicidal. It will kill all the mould almost instantly. Preventing it from coming back depends on what type of paint you have on the walls and ceiling at the moment. We would recommend you use Dekro Hygiene Coatings.**

*How long should I wait before applying another coat of paint?*

**Although the paint will dry to touch fairly quickly, we recommend waiting four hours between coats. High humidity, low temperature, poor ventilation and thicker films will increase the recommended dry time.**

# HYGIENE SOLUTIONS CARE AND MAINTENANCE

**Routine Care and Maintenance Cleaning**

**Although none of Dekro Paints hygiene coatings will support the growth of micro-organisms, the build-up of dirt and nutrients on their surface will inhibit their effectiveness by creating a surface on which mould and bacteria could grow. Regular cleaning should therefore be undertaken where soiling is known to occur. For severe contamination and/or maximum hygiene control, use either scrubbers and scouring powder or steam cleaning equipment.**

**In the event of localised damage or to reinstate a completely seamless finish following structural modifications, repair can be made quickly and easily by applying more of the appropriate coating to the affected area. If treating small punctures or static cracks resulting from impact, the surrounding coating should be cleaned, primed if necessary and repaired by the application of more material. In some cases, a screed or repair mortar may be required to reinstate a smooth, fair faced finish before the coating can be applied. Consult our customer services department for details of compatible materials. If treating new joints, embed with Chopped Strand Matt into the wet coating as described in the preceding sections and allow curing before applying a second coat. In all cases, care should be taken to restore the dry film thickness of the original coating.**

Dekro Paints hygiene coatings should be inspected regularly, particularly when subject to regular impact, abrasion or highly aggressive cleaning regimes. Similarly, they should be examined when they approach the end of their anticipated design life. In practice, the actual durability of the various Dekro Paints hygiene systems will often far exceed the quoted life span and maintenance will not be repaired for several years after the termination of the stated period. Nonetheless, it is recommended that the system be overcoated when it has reached the end of its design life in order to ensure effective and continuous hygiene protection. In all cases, inspections should be carried out regularly (as part of routine cleaning operations, for example) in order to check for signs of wear or accidental impact damage.

## Refurbishment

As noted earlier, Dekro Paints hygiene control coatings do not need to be replaced at the end of their initial design lives. They may be restored to their original durability simply by the application of additional material. Coatings which were previously fully reinforced may be restored by the application of a single coat. This represents a highly cost-effective method of refurbishment and can help to produce significant savings on long-term maintenance costs.

# HYGIENE SOLUTIONS

**1. Aquablock Water Repellent**
**A complex water white aluminium compound with outstanding waterproofing properties. Normally used as a water repellent coating over absorbent surfaces, ie. masonry, concrete, stone, bricks, etc. it impregnates and seals porous surfaces. Aquablock water repellent can hardly be detected, preserving the appearance and character of the substrate.**

**Interior ☑**
**Exterior ☑**

**2. Hydrolock Primer**
**A top quality twin pack, water-based epoxy primer with excellent adhesion to various kinds of substrates, eg concrete, screeds and mortars, bituminious surfaces, wooden protrusions, etc. Hydrolock primer dries quickly and can be overcoated within 1 hour with both water-based and solvent-based coatings. It can be used on most building surfaces. It has good adhesion to bitumen surfaces and can be applied to partially cured concrete.**

**Interior ☑**
**Exterior ☑**

**3. Hydrometal Primer**
**An innovative water based blend of a metal reactive acrylic-based emulsion which is electro chemically active, anti-corrosive and has exchange pigments, barrier additives and anti-flash rust agents. The product has a very low hazard profile, is fast drying and has excellent flexibility. Suitable for ferrous metals, galvanised surfaces, stainless steel and zinc.**
**Red Oxide in colour.**

**Interior ☑**
**Exterior ☑**

**4. Hydrowash Fungicidal**
**Designed to kill active mould, fungal and bacteria spores and chlorophyll containing organisms such as moss, lichen and algae prior to the application of Hygiene Solution Primers and membrane systems.**
**It is supplied in the form of a super concentrate with a blue colour.**

**Interior ☑**
**Exterior ☑**

**5. Hydroclad**
**A self cleaning, highly durable, copolymer-based coating which cures to form a tightly adherent, decorative weatherproof membrane. As a waterborne-system, it is free from strong odour and toxic risk. Hydroclad tolerates substrate movement without splitting or cracking, is weather resistant and does not allow water vapour permeability.**

**Interior ☑**
**Exterior ☑**

# HYGIENE SOLUTIONS

**6. Hydromed Matt**
**A tough and highly durable, plastic based, decorative coating which eliminates the growth of micro-organisms such as: mould, fungae, yeast and bacterial colonies on it's surface.**
**It is highly elastic and expands and contracts with thermal and structural movement, obviating cracking and flaking, and its vapour permeability structure prevents blistering and loss of adhesion on damp surfaces. Ideal for hospitals, fruit storage, wine cellars, ceilings and bathroom walls.**

**Interior ☑**
**Exterior ☑**

**7. Hydromed Gloss**
**A tough, flexible, water-based, modified acrylic coating which provides the ultimate safeguard against the growth of micro organisms such as: bacteria, mould and yeast. Suitable for use in hospitals, food manufacturing plants, wine cellars, etc Hydromed Gloss is a non-leaching, hard wearing, scratch resistant, maintenance free coating.**

**Interior ☑**
**Exterior ☑**

**8. Mediflex**
**A single-pack, water borne polyurethane-based coating which is designed to enable premises to be occupied as soon as possible after application. It incorporates an effective, non-toxic, anti-microbial system which protects against growth of micro-organisms on its surface. It achieves a dense, glossy finish which is tough, flexible and highly tolerant to abrasives and other harsh cleaning agents. It is suitable for use in hospitals, food storage and processing plants, kitchens, breweries, dairies, etc.**

**Interior ☑**
**Exterior ☑**

**9. Hydroplast**
**A high build, water-based, waterproof coating designed to keep long term maintenance costs to an absolute minimum. It contains an active fungistatic system which prevents the growth of mould, fungus and algae on its surface. Hydroplast will not embrittle with age or exposure to ultra-violet light, it remains permanently elastomeric, tolerating thermal and structural movements without cracking or flaking. Hydroplast has excellent adhesion to most substrates.**

**Interior ☑**
**Exterior ☑**

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# HEAVY DUTY COATINGS SPECIFICATION MANUAL

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# ACRYLIC COATINGS

| Product Code | Product And Properties | Suggested Use |
|---|---|---|
| 652001 | **ACRI 700 FINISH,** is a finishing coat based on acrylic resin which dries by evaporation of the solvents. It has excellent adhesion properties, weathering resistance and gloss and colour retention. | Finishing coat on Ship's and Oil Rig's topside and superstructure, external of tanks and other steel structures. Concrete floors where chemical resistance is needed. |
| 651200-Silver<br>652201-Silver Red Tone | **ACRI 700 PRIMER,** is an effective corrosion protection primer based on acrylic resin which dries by evaporation of the solvents. It can be applied directly onto bare steel or an existing paint film, such as modified acrylic and epoxy. | Anti-corrosive primer for Ship's and Oil Rigs' topsides and superstructure, externals of tanks and other steel structures. |

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# ALKYD BASED COATINGS

| Product Code | Product And Properties | Suggested Use |
|---|---|---|
| 527001 | **EVAMARINE** is an alkyd resin based paint with excellent adhesion properties, weathering resistance and colour retention. | As a finishing coat on exterior wood and steel surfaces |
| 515100-Red<br>515700-Grey Green | **LZI PRIMER HB,** is a high-build type paint, based on special alkyd resin. It contains Zinc Phosphate as its main rust-preventing pigment. It is a highly effective rust-preventing primer which is quick drying, has excellent adhesion properties and weathering resistance. | As a rust preventing primer for the inside and outside of ships superstructures and other steel structures. |

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# EPOXY COATINGS

| Product Code | Product And Properties | Suggested Use |
|---|---|---|
| 355201-Base<br>355099-Hardener | **ADPRIME No. 1** is a two component polyamide cured zinc phosphate epoxy primer. | As a primer for ferrous and non-ferrous substrates, especially where epoxy or polyurethane top coats are to be used. |
| 359 350 | **BANNOH 500 R,** is a Tar-free epoxy anti-corrosive primer which is based on pure epoxy resin and specialized pigmentation. | Anti-corrosive paint for the repair ships and other steel structures<br>Surface Tolerant Epoxy for concrete floors. |
| 379614-Base<br>379099-Catalyst | **EPICON F-HB,** is a high-build type epoxy micaceous iron oxide paint based on a combination of epoxy resin and polyamide resin, pigmented with micaceous iron oxide. | Intermediate coat or finish coat for steel structures, bridges, outside of oil storage tanks, etc. |

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# EPOXY COATINGS

| Product Code | Product And Properties | Suggested Use |
|---|---|---|
| 369001-Base<br>369099-Catalyst | **EPICON MARINE FINISH** is an epoxy topcoat based on a combination of epoxy resin and a polyamide curing agent, which has excellent durability and adhesion properties. It is a protective finishing coat for steel ships, oil rigs, bridges, steel structures and concrete. | Finishing coat of Epicon Marine system of steel on ships, oil rigs, bridges and other steel structures.<br>Epoxy Coating suitable for concrete floors. |
| 375001-Base<br>375099-Catalyst | **EPICON T-500 FINISH A** is a high-build type epoxy coating, which has excellent physical properties such as, adhesion, toughness, abrasion resistance, as well as chemical resistance to salt water, fresh water, petroleum products, crude oil, alkalis and weak acids. | Finishing coat for cargo oil, fresh water and chemical tanks, cargo holds, solvent tanks, etc.<br>Food Grade Epoxy coating for Factory concrete floors and Silos. |

# EPOXY COATINGS

| Product Code | Product And Properties | Suggested Use |
|---|---|---|
| 365 001-Base<br>365 099-Hardener | **EPICON T-800** is a high-build type epoxy phenolic coating, which has excellent physical properties such as adhesion, toughness, abrasion resistance, as well as chemical resistance to salt-water, fresh water, hot water, petroleum products, crude oil, alkalis and weak acids. | Product carrier tanks, chemical tanks, water tanks, etc |
| 373 700-Base<br>373 099 -Catalyst | **NZ PRIMER S** is a non zinc type epoxy shop primer based on a combination of epoxy resin, rust-preventative pigments and quick drying hardener to give adequate preliminary protection of blast-cleaned steel plates. | As a shop primer for protection of blast-cleaned steel plates and especially suitable for steel plates subject to prolonged weathering. |

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# EPOXY COATINGS

| Product Code | Product And Properties | Suggested Use |
|---|---|---|
| 391614-Base<br>391099-Catalyst | **TUFFCOAT** is a modified surface tolerant epoxy coating containing micro glass flakes which protects corroded areas of steel where optimum surface pre-treatment is not always practical. | On steel structures and concrete floors |
| 387 001-Base<br>387 099-Catalyst | **UMEGUARD MT,** is a high solids modified epoxy paint which is specially designed for steel surfaces prepared by high pressure fresh water cleaning. | Ships and oil rigs deck, topside, superstructure, ballast tanks, inland construction and other steel surfaces |
| 388001-Base<br>388099-Catalyst | **UMEGUARD SX,** is a modified surface tolerant epoxy paint. | Cargo hold, inside and outside accommodation space, void spaces, engine room, pipelines, other steel structures etc. |

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# POLYURETHANE COATINGS

| Product Code | Product And Properties | Suggested Use |
|---|---|---|
| 470001-Base<br>470099-Catalyst | **ADTHANE ENAMEL** is an Acrylic / Polyurethane topcoat that dries to a “tile-like” finish with a mirror gloss appearance. | Adthane Enamel, because of its outstanding properties, can be applied to a wide variety of substrata. It is recommended for the following – boats, furniture, aircraft, vehicles, chemical plants and appliances. |
| 457001-Base<br>457099-Catalyst | **UNY MARINE** is a twin pack polyurethane which has excellent gloss retention, durability and chemical resistance, etc. It is a finishing coat suitable for protection of steel. | Glossy finish coat for superstructure, deck, topsides and other steel structures |
| 460071 | **WALKSAFE** is a twin pack Polyurethane floor coating which is extremely tough and non-slip, even in cold and wet conditions. | Floors where safety is important e.g. Old Age Homes, ablution blocks, shower floors, steps and ramps. Steel Ship Decks, Engine rooms, Oil Drilling Platforms, Refineries, Chemical Plants, Mines etc. |

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# SURFACE PREPARATION SOLUTIONS

| Product Code | Product And Properties |
|---|---|
| 181003 | **GALV-ETCH** is an acid/detergent solution, designed to etch new galvanized surfaces simultaneously with the emulsification of the surface contaminants i.e. prefabricators protective coating. Galv-Etch requires a wet reaction period of 10-15 minutes before rinsing clean. |
| 004500 | **HOLDTIGHT 102,** is an additive that prevents flash rusting of wet abrasive- and water-blasted iron and steel surfaces and of dry-blasted surfaces in a pressurized wash down. It also removes chlorides and other salts and contaminants very effectively. It is approved by most major coating suppliers for use with most coatings: Contact HoldTight Solutions Inc. for details and references. |
| 856001 | **HYDROMET,** is a rust converter to be used in situations where use of blast cleaning is not possible to achieve the ideal result, or is considered too costly or impracticable, the norm has been to remove loose material and then convert the iron oxide e.g. by use of a solution of tannic acid. |

# SURFACE PREPARATION SOLUTIONS

| Product Code | Product And Properties |
|---|---|
| 096104 | **SUPER PAINT STRIPPER** is a general purpose paint remover which is non-flammable, has a low wax content and rinses off with water. Recommended for removing previously painted or varnished surfaces of metal, wood or plaster. Plastic surfaces must be tested first before using Super Paint Stripper. |
| 096119 | **WUNDA CLEAN** is a degreaser for cement floors, metal and other surfaces which can be diluted and rinsed off with water. It also performs well as a brush cleaner in the removal of semi solidified paint coatings in the bristles of paint brushes, loosening the old paint before water rinsing under the tap thus rendering the brushes usable once again. |

# VINYL COATINGS

| Product Code | Product And Properties | Suggested Use |
|---|---|---|
| 617001 | **POLIBI T-1** is a vinyl chloride resin based paint, providing excellent adhesion properties, durability, weathering resistance and gloss retention. | Finishing coat of vinyl system on the inside and outside superstructure area of ships and oil rigs, the external of steel tanks and other steel structures |
| 614200-Silver<br>614201-Silver Red Toned | **VINYL AC-HB** is a vinyl chloride resin and aluminium pigment based primer, providing effective protection against corrosion. | Ship and Oil rig superstructures, externals of tanks and other steel structures. |

# ZINC COATINGS

| Product Code | Product And Properties | Suggested Use |
|---|---|---|
| 815001-Base<br>815099-Catalyst | **ADZINC NO 1,** is a twin pack inorganic ethyl -silicate base with metallic zinc dust pigmentation in paste form, and is dependant upon the presence of moisture in the atmosphere to initiate curing. | A corrosion resistant primer for industrial constructions of all natures; bridges, pipelines, storage tanks, etc . |
| 370004-Base<br>370099-Catalyst | **EPICON ZINC RICH PRIMER B2** is a two-pack primer, based on a combination of metallic zinc, epoxy resin and hardener. | Primer for protection of blast-cleaned steel plates. |
| 810012 | **METALLIC ZINC RICH PRIMER** is a general purpose zinc primer for the temporary protection of suitably prepared steel structures. | On Steel Structures and Welding repair areas. |

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# MISCELLANEOUS

| Product Code | Product And Properties | Suggested Use |
|---|---|---|
| 164001 | **BITUMINOUS ALUMINIUM PAINT** is a high lustre bituminous based aluminium paint. It is free from bleeding on bituminous surfaces, improves illumination and reflects heat. | Direct application to bituminous surfaces, “Malthoid” roofs and creosoted timber. |
| 164003 | **BITUMINOUS BLACK** is a general purpose protective coating which is impervious to moisture and most chemicals. | Recommended for sealing absorbent surfaces such as fibrous cement prior to the application of a finishing coat of Bituminous Aluminium. Also for direct application to any clean metal surface where a low cost protective coating is required. |
| 166280 | **QUICK DRYING HEAT RESISTANT ALUMINIUM 200°C** is a special blend of aluminium paste and heat resisting resins. | Used as a heat resistant finish on suitably prepared steel surfaces for exposure on kilns,exhaust manifolds, smoke stacks and incinerators, etc. |

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# MISCELLANEOUS

| Product Code | Product And Properties | Suggested Use |
|---|---|---|
| 358080 | **SILICON No. 400 SILVER,** is a Silicon resin Aluminium paint based on a combination of silicon resin and Aluminium pigment. | On boilers, cylinders of engines and the inside of exhaust pipes, radiators, stoves, oil burners, etc. |
| 605077-BLACK<br>605003-RED OXIDE | **VASBYT SINGLE PACK METAL ETCH PRIMER** is a fast drying Acid Hardening Metal Etch Primer. | Recommended pre-treatment primer for most new metal surfaces. |
| 602001-Base<br>602099-Catalyst | **WASH PRIMER** is a vinyl buteryl based primer, which conforms to SABS Standard 723 type Wash Primer. | Main use is over well prepared Galvanized Iron or Aluminium or Non-ferrous Metal. |

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| Coating Failure | Appearance Failure | Cause of Failure | Remedy |
|---|---|---|---|
| Wrinkling | Furrows and ridges in coating surface. May be linear or random pattern. Wrinkle may be fine or quite large. | Surface reaction where surface of coating expands more rapidly during drying than does the body of the film. | Choose coatings with even, thorough drying characteristics. Apply evenly, avoid excessive thickness. |
| Micro organism | Softening or slime reaction of coating. Blotchy brown or black spots on coating surface causing poor dirty appearance. | The biodegradation of the coating by bacteria or fungal attack. The coating is used as a source of nourishment. | Use oil paints which contain permanent fungicides or bactericides. Non oil coatings should use non-biodegradable modifiers. |
| Discoloration | Yellowing, greying or darkening of coating. | Resin or pigment colour change due to weather or chemical action. | Select coating formulated with both colour stable resins and pigments. |
| Checking (2) | Usually fine visible or microscopic checks. Does not penetrate to the substrate. | The Zinc pigment to binder ratio is high - rapid drying conditions cause surface checking. | Formulation should include reinforcing pigments. Apply coating as thin as recommended. Second coat, if necessary. Apply under favorable drying conditions. |
| Chemical | Pinpoint rusting progressing to continuous rusting. | Acid or Alkali reaction on both silicate binder and on metallic zinc. | Apply resistant topcoats over inorganic Zinc coatings. |
| Pinpoint Rusting | Pinpoint spots of corrosion progressing from a few square centimeters to almost continuous. | Uneven coating thickness - thin coated areas show first failure. | This is normal failure pattern for inorganic Zinc coatings. Apply maintenance coat at first sign of pinpoint failure. |
| Blistering | Hemispherical Bubbles in coating containing gas or liquid. | Blistered coatings have adhesion problems due to poor surface preparation, internal soluble materials or poor wetting of substrates. Osmosis, electro endosmosis, gases absorbed into the metal surface or solvent | Select a coating with very strong adhesion characteristics and a low moisture vapor transfer rate. Carefully apply to a clean, abrasive blasted surface. |

| Coating Failure | Appearance Failure | Cause of Failure | Remedy |
|---|---|---|---|
| Peeling | Coating may be smooth and lying on surface or it may be hanging in shreds. Little or no adhesion is evident. | Adherence is less than the tensile strength of the coating. When broken, the coating can easily be pulled from the surface leaving the original surface of the substrate. Coating may react with substrate and lose adhesion. Coating usually flexible. | Select a coating as outlined under blistering. |
| Flaking or Scaling | Pieces of coating curling at the edges, easily removed from the surface leaving bare substrate or in between thick old coating. | Coating usually brittle with internal shrinkage characteristics in addition to marginal adhesion. Oil type coatings may scale or flake from a galvanized surface. | Select a coating as outlined under blistering. For galvanizing use a primer compatible with Zinc. |
| Intercoat delamination | The topcoat does not adhere to the undercoat. It may lie on surface, blister, flake or peel. | The topcoat is not compatible with the undercoat. The surface of the undercoat may be contaminated. The undercoat may be over-cured to complete insolubility. | Select coatings with good compatibility and adhesion between coats. Make certain undercoat is clean before application of the second coat. Do not expose coal tar epoxy coatings to water or excessive sunlight before over-coating. |
| Improper mixing of coating | Thin coating. Non uniform pigment distribution. May be areas of poor adhesion, uneven colour, checking or cracking. | Most common cause is improper pigment-vehicle ratio, where settled pigment remains in the bottom of the paint can. | Thoroughly mix the liquid coating (preferably by mechanical stirrer ) to an even ,smooth, homogeneous liquid with no colour variation. Continue mixing as necessary during use. |
| Improper thinning of coating | Poor adhesion, pigment float or flooding (uneven colour). Separation of pigment and vehicle after application. Pin-holing, blushing (coating turning white after application). | Thinner incompatible with resins or pigments. Improper drying change in surface tension. Thinner evaporation too rapid, causing moisture to condense on liquid coating. | Use only manufacturer's recommend thinners, add slowly with thorough mixing. |

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| Coating Failure | Appearance Failure | Cause of Failure | Remedy |
|---|---|---|---|
| Poor atmospheric conditions for coating application | Poor adhesion and blistering from humid, damp conditions. Over spray - powdery coating where drying is too rapid. Soft uncured film. | Condensation of moisture on the surface prior to application. Lack of proper cure due to low or too high temperature during application. | Apply coatings at relative humidity of 80% or below and at least 3°C above the dew point. Apply paint and coating at 5 degree centigrade or above except for internally reactive materials which should be 25°C or above. |
| Improper coating thickness | Areas of pinpoint corrosion between areas of solid coating where coating is thin. Checking, cracking, flaking where coating is excessive. | Thin areas, spatter coating, holidays. Runs, puddles, excessive number of spray passes in area where coating access is difficult. | Careful application-even spray passes with each pass overlapped 50%. Use cross spray technique. |
| Overspray | Very rough coating surface. May appear like sand in the coating. Some dry coating, like dust, on the surface. | Improper spraying technique. Uneven spray passes with gun too far from the surface. Spray pressure too low, atomizing air pressure too high. Nitro-cellulose type coating most subject to overspray. | Apply coating with care and with even wet spray passes overlapped 50%. Use wire screen and sandpaper to obtain smooth surface before top-coating. |
| Pinholes | Small, visible holes in the coating. Holes generally appear in concentrations with a random distribution. | Improper spray technique. Spray gun too close to the surface with air bubbles being forced into the coating. Spray pot pressure too high with atomizing air pressure too low. Pinholes may also exist in the substrate. | Apply coating carefully with spray gun at the optimum distance from the surface. Make sure spray gun is properly adjusted. If pinholes already exist, apply coating by brush, working it into the surface. |
| Spatter Coat | Area of thin coating, usually at end of spray pass or around a complex section of structure. Small spots of coating which are non-continuous over substrate. In poor light, may seem continuous. | Discrete coating droplets which are not continuous over the surface. Inconsistent spray passes not overlapped 50%. Spray gun flipped at end of spray pass. Catalyst cured coatings most subject to spatter. | Apply coating with care. Use even, wet spray with each pass overlapped 50%. Use cross spray technique. |

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| Coating Failure | Appearance Failure | Cause of Failure | Remedy |
|---|---|---|---|
| Holidays | Bare areas of the surface which were uncoated by the painter. Most often in difficult areas to coat. | Poor, inconsistent application. Lack of care. | Apply coating in a careful, consistent manner, making certain that no areas remain uncoated. |
| Cratering | Bug eyes, fish eyes or craters randomly dispersed over coated area. May be more prevalent in thicker areas. | Improper solvent mixture, oil in atomizing air, surface contamination, particulate fall out during application, high surface tension silicone contamination. | Once cratering occurs, sand or roughen crater area. Apply another coat by brush, working coating into cratered area. Make sure contaminated is removed. |
| Bleeding | Staining of top coats. | Soluble resins or pigments in undercoat. | Seal with coating in which bleeding ingredient is soluble. |
| Blushing | Haziness or whitening of film. | Condensation of moisture on coating due to rapid dripping of solvents. | Wait for improved humidity conditions. Reduce atomizing air pressure to a minimum. |
| Lifting | Wrinkling, swelling or blistering of film. | Attack or swelling of film by solvents in top coat. | Remove old coating and recoat. |
| Orange Peel | Overall bumpy pattern. Surface is smooth but irregular. | Spraying technique, drying characteristics of the film. | Apply a wet mist coat. Use a slower evaporating solvent. |
| Runs or Sags | Coating running in droplets down vertical surface causing curtain effect. | Excessive application. | Apply thinner coats. Check surface temperature. May be too cold for proper drying. |

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# SPECIFICATION FOR SURFACES

Exterior exposed non-polluted inland atmosphere

**No. 1-001** Jan. 2010

| | |
|---|---|
| **Type:** | **Alkyd System** |
| Application: | Exterior exposed non-polluted inland atmosphere |
| Characteristics: | 1. Good rust-preventing property<br>2. Good weather-resisting property<br>3. Good appearance |

| Paints | Type of Paint | Product Name | Product Code | Thinner |
|---|---|---|---|---|
| | Rust-preventing Primer based on Special Synthetic Resin | LZI Primer HB | 515 100 Red<br>515 700 Grey<br>Green | Mineral Turps / Marine Thinners |
| | Alkyd Finish Paint | Evamarine Finish | 527 001 | |

Painting Specification

| Location | Process | Paint & Treatment | Practical Coverage ($m^2$/lt) | Dry Film Thickness (microns) | Painting Interval (20°C) | Thinning Ratio (by wt%) |
|---|---|---|---|---|---|---|
| At works or At Site | Surface Preparation | A. Blast cleaning to more than SIS-Sa 2 or power tool-cleaning to SIS-St 3.<br>B. Power tool-cleaning. Weld-seams and heat-damaged parts should be treated to SIS-St3. | | | | |
| | 1st Coat | LZI Primer HB | 8.4 | 50 | 16 Hrs ~90 Days | B: 0~3<br>S: 0~5 |
| | 2nd Coat | LZI Primer HB | 8.4 | 50 | 16 Hrs ~90 Days | B: 0~3<br>S: 0~5 |
| | 3rd Coat | Evamarine Finish | 12.2 | 30 | 16 Hrs ~30 Days | B: 0~3<br>S: 0~5 |
| | 4th Coat | Evamarine Finish | 12.2 | 30 | 16 Hrs | B: 0~3<br>S: 0~5 |

Thinning Ratio for: B: Brush application S: Airless Spray application

Remarks
1) Surface preparation (A) and (B) are as follows:
A) Is the case of no shop priming.
B) Is the case of shop priming. NZ Primer S is recommended as shop primer.
2) Painting interval is varied by environment condition or temperature during painting.

**No. 2-002** Jan. 2010

| | |
|---|---|
| **Type:** | **Vinyl Etch Primer & Alkyd System** |
| Application: | Exterior exposed non-polluted inland atmosphere |
| | (Long interval between work and at site) |
| Characteristics: | 1. Good rust-preventing property<br>2. Good weather-resisting property<br>3. Good appearance |

| Paints | Type of Paint | Product Name | Product Code | Thinner |
|---|---|---|---|---|
| | Single Pack Etch Primer | Vasbyt | 605 077 Black<br>605 003 Red Oxide | Etch Primer Thinner |
| | Rust Preventing Primer Based on special synthetic Resin | LZI Primer HB | 515 100 Red<br>515 700 Grey<br>Green | Mineral Turps / Marine Thinner |
| | Alkyd Finish Paint | Evamarine Finish | 527 001 | |

Painting Specification

| Location | Process | Paint & Treatment | Practical Coverage ($m^2$/lt) | Dry Film Thickness (microns) | Painting Interval (20°C) | Thinning Ratio (by wt%) |
|---|---|---|---|---|---|---|
| At works or At site | Surface Preparation | A. Blast cleaning to more than SIS-Sa 2 or power tool-cleaning to SIS-St 3.<br>B. Power tool-cleaning. Weld seams and heat parts should be treated to SIS-ST 3. | | | | |
| | 1st Coat | Vasbyt | 5.1 | 15 | 16 Hrs ~90 Days | B: 0~3<br>S: 0~5 |
| | 2nd Coat | LZI Primer HB | 8.4 | 50 | 16 Hrs ~90 Days | B: 0~3<br>S: 0~5 |
| | 3rd Coat | Evamarine Finish | 12.2 | 30 | 24 Hrs | B: 0~3<br>S: 0~5 |

Thinning Ratio for: B: Brush application S: Airless Spray application

Remarks
1) Surface preparation (A) and (B) are as follows:
A) Is the case of no shop priming.
B) Is the case of shop priming. NZ Primer S is recommended as shop primer.
2) Painting interval is varied by environment condition or temperature during painting.

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# SPECIFICATION FOR SURFACES

Exterior exposed polluted inland and coastal atmosphere

**No. 1-101** Jan. 2010

| | |
|---|---|
| **Type:** | **Acrylic Finish System** |
| Application: | Exterior exposed non-polluted inland atmosphere<br>(Long interval between work and at site) |
| Characteristics: | 1. Good rust-preventing properties<br>2. Good weather-resisting properties<br>3. Good appearance<br>4. Good adhesion properties in case of long interval between at work and at site<br>5. Good acid- and alkali-resisting properties |

| Paints | Type of Paint | Product Name | Product Code | Thinner |
|---|---|---|---|---|
| | Acrylic Anti-Rust Primer | Acri 700 Primer | 651 200 Silver<br>651 201 Silver Red Toned | CR/Acri Thinner |
| | Acrylic Finish Paint | Acri 700 Finish | 652 001 | CR/Acri Thinner |

Painting Specification

| Location | Process | Paint & Treatment | Practical Coverage ($m^2$/lt) | Dry Film Thickness (microns) | Painting Interval (20°C) | Thinning Ratio (by wt%) |
|---|---|---|---|---|---|---|
| At works | Surface Preparation | A. Blast cleaning to more than SIS-Sa 2 or power tool-cleaning to SIS-St 3.<br>B. Power tool-cleaning. Weld-seams and heat-damaged parts should be treated to SIS-St3. | | | | |
| | 1st Coat | Acri 700 Primer | 5.0 | 60 | 7 Hrs | B: 0~3<br>S: 0~5 |
| | 2nd Coat | Acri 700 Primer | 5.0 | 60 | 7 Hrs | B: 0~3<br>S: 0~5 |
| | 3rd Coat | Acri 700 Finish | 7.3 | 35 | 7 Hrs | B: 0~3<br>S: 0~5 |
| At Site | Surface Preparation | Damaged parts, rusted parts, and welded parts should be treated to SIS-St 3 with power tools after removal of foreign matter such as grease, moisture, dust and dirt | | | | |
| | Touching up | Touching-up with the above 1st & 2nd Coat | | | | |
| | 4th Coat | Acri 700 Primer | 5.0 | 60 | 7 Hrs | B: 0~3<br>S: 0~5 |
| | 5th Coat | Acri 700 Finish | 7.3 | 35 | 7 Hrs | B: 0~3<br>S: 0~5 |

Thinning Ratio for: B: Brush application S: Airless Spray application

Remarks

1) Surface preparation (A) and (B) are as follows:
   A) Is the case of no shop priming.
   B) Is the case of shop priming. NZ Primer S as shop primer.
2) Painting interval is varied by environment condition or temperature during painting.

**No. 4-303** Jan. 2010

| | |
|---|---|
| **Type:** | **Epoxy Zinc + Epoxy + Acrylic Polyurethane Finish System** |
| Application: | Exterior exposed polluted inland, coastal atmosphere<br>Long weather-resisting system |
| Characteristics: | 1. Excellent rust-preventing properties<br>2. Excellent weather-resisting properties<br>3. Excellent appearance<br>4. Long gloss retention<br>5. Excellent oil- and water-resisting properties |

| Paints | Type of Paint | Product Name | Product Code | Thinner |
|---|---|---|---|---|
| | High Build Type Epoxy Zinc Rich Primer | Epicon Zinc Rich Primer B-2 | 470 004 Base<br>470 099 Cat. | Epoxy Thinner |
| | High Build Epoxy Micaceous Iron Oxide Paint | Epicon F-HB | 379 614 Base<br>379 099 Cat. | |
| | Acrylic Polyurethane Finish System | Uny Marine Finish | 457 001 Base<br>457 099 Cat. | Urethane Thinner |

Painting Specification

| Location | Process | Paint & Treatment | Practical Coverage ($m^2$/lt) | Dry Film Thickness (microns) | Painting Interval (20°C) | Thinning Ratio (by wt%) |
|---|---|---|---|---|---|---|
| At works or At site | Surface Preparation | A. Blast cleaning to SIS-Sa 2.5.<br>B. Sweep-blast-cleaning. Weld-seams and heat-damaged parts should be treated to SIS-Sa 2.5. | | | | |
| | 1st Coat | Epicon Zinc Rich Primer B-2 | 5.3 | 50 | 16 Hrs ~180 Days | B: 0~5<br>S: 0~10 |
| | 2nd Coat | Epicon F-HB | 3.6 | 100 | 8Hrs ~30 Days | B: 0~3<br>S: 0~5 |
| | 3rd Coat | Epicon F-HB | 3.6 | 100 | 8 Hrs ~30 Days | B: 0~3<br>S: 0~5 |
| | 4th Coat | Uny Marine Finish | 8.8 | 40 | 4 Hrs | B: 0~5<br>S: 0~10 |

Thinning Ratio for: B: Brush application S: Airless Spray application

Remarks

1) Surface preparation (A) and (B) are as follows:
   A) Is the case of no shop priming.
   B) Is the case of shop priming. Epicon Zinc Rich Primer B-2 is recommended as shop primer.
2) Painting interval is varied by environment condition or temperature during painting.

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# SPECIFICATION FOR SURFACES

Exterior exposed polluted inland and coastal atmosphere

**No. 7-701** Jan. 2010

| | |
|---|---|
| **Type:** | **Inorganic Zinc & Silicone Finish System** |
| Application: | High temperature surface, up to 400℃<br>(Silver colour finishing) |
| Characteristics: | 1. Excellent rust-preventing properties<br>2. Good heat-resisting properties (up to 400℃)<br>3. Good weather-resisting properties<br>4. Good appearance |

| Paints | Type of Paint | Product Name | Product Code | Thinner |
|---|---|---|---|---|
| | High Build Type Inorganic Zinc Silicate Paint | Adzinc No 1 | 815 001 Base<br>815 099 Cat. | No Thinner |
| | Silicone Aluminium Paint | Silicon No 400 Silver | 358 080 | CR/Acri Thinner |

Painting Specification

| Location | Process | Paint & Treatment | Practical Coverage ($m^2$/lt) | Dry Film Thickness (microns) | Painting Interval (20℃) | Thinning Ratio (by wt%) |
|---|---|---|---|---|---|---|
| At works | Surface Preparation | A. Blast cleaning to more than SIS-Sa 2.5.<br>B. Sweep-blast-cleaning. Weld-seems should be treated to SIS-Sa 2.5. | | | | |
| | 1st Coat | Adzinc No 1 | 8.4 | 40 | 24 Hrs<br>~4 Days | S: 0 |
| | 2nd Coat | Silicon No 400 Silver | 17.3 | 15 | 16 Hrs<br>~1 Day | B: 0~5<br>S: 5~10 |
| At Site | Surface Preparation | Damaged parts, rusted parts, welded parts should be treated to SIS-Sa 2.5 by blasting after removal of foreign matters such as grease, moisture, dust and dirt | | | | |
| | 3rd Coat | Silicon No 400 Silver | 17.3 | 15 | 16 Hrs | B:0~5<br>S: 5~10 |

Thinning Ratio for: B: Brush application S: Airless Spray application

Remarks

1) Surface preparation (A) and (B) are as follows:
   A) Is the case of no shop priming.
   B) Is the case of shop priming. Adzinc No 1 is recommended as shop primer.
2) Painting interval is varied by environment condition or temperature during painting.
3) Adzinc No 1 should be applied less than120 microns dry film thickness.

**No. 7-201** Jan. 2010

| | |
|---|---|
| **Type:** | **Inorganic Zinc + Epoxy MIO + Acryl-urethane Finish System** |
| Application: | Exterior exposed polluted inland and coastal atmosphere. Long weather-resisting system<br>(Long intervals between at works and at site) |
| Characteristics: | 1. Excellent rust-preventing and weather resisting properties<br>2. Excellent appearance and long lasting gloss retention<br>3. Excellent water-resisting properties<br>4. Excellent adhesion properties in case of long interval between at works and at site |

| Paints | Type of Paint | Product Name | Product Code | Thinner |
|---|---|---|---|---|
| | High Build Type Inorganic Zinc Silicate Paint | Adzinc No 1 | 518 001 Base<br>815 099 Cat. | No Thinner |
| | High Build Epoxy Micaceous Iron Oxide Paint | Epicon F-HB | 379 614 Base<br>379 099 Cat. | Epoxy Thinner |
| | Acryl-urethane Finish Paint | Uny Marine Finish | 457 001 Base<br>457 099 Cat. | Urethane Thinner |
| | Organic Epoxy Zinc Rich Paint | Epicon Zinc Rich Primer B-2 | 370 004 Base<br>370 099 Cat. | Epoxy Thinner |

Painting Specification

| Location | Process | Paint & Treatment | Practical Coverage ($m^2$/lt) | Dry Film Thickness (microns) | Painting Interval (20℃) | Thinning Ratio (by wt%) |
|---|---|---|---|---|---|---|
| At works | Surface Preparation | A. Blast cleaning to SIS-Sa 2.5.<br>B. Sweep-blast-cleaning. Weld-seems should be treated to SIS-Sa 2.5. | | | | |
| | 1st Coat | Adzinc No 1 | 4.2 | 80 | 24 Hrs<br>~180 Days | S: 0 |
| | Mist Coat | Epicon F-HB | (7.1) | (50) | 30 Min<br>~1 Day | S: 40~50 |
| | 2nd Coat | Epicon F-HB | 3.6 | 100 | 10 Hrs | S: 0~5 |
| At Site | Surface Preparation | Damaged parts, rusted parts, welded parts should be treated to SIS-Sa 2.5. by blasting or to SIS-St 3 by power tools after removal of foreign matters such as oil and grease, moisture, dust and dirt. | | | | |
| | Touching up 1st Coat | Epicon Zinc Rich Primer B-2 | 8.0 | 40 | 16 Hrs<br>~180 Days | S: 0~10 |
| | Touching up 2nd Coat | Epicon F-HB | 3.6 | 100 | 10 Hrs | B: 0~3<br>S: 0~5 |
| | 3rd Coat | Epicon F-HB | 3.6 | 100 | 8 Hrs | B: 0~3<br>S: 0~5 |
| | 4th Coat | Uny Marine Finish | 8.8 | 40 | 4 Hrs | B: 0~5<br>S: 0~10 |

Thinning Ratio for: B: Brush application S: Airless Spray application

Remarks

1) Surface preparation (A) and (B) are as follows:
   A) Is the case of no shop priming.
   B) Is the case of shop priming. Epicon Zinc Rich Primer B-2 is recommended as shop primer.
2) Painting interval is varied by environment condition or temperature during painting.
3) Adzinc No. 1 should be applied at a D.F.T. of less than 120 microns to avoid mud-cracking.
4) In the case of brush application the number of coats should be increased to maintain the specified dry film thickness.

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# SPECIFICATION FOR SURFACES

Galvanised surface exposed non-polluted inland and coastal atmosphere

**No. 5-401** Jan. 2010

| | |
|---|---|
| **Type:** | **Wash Primer + Vinyl Finish System** |
| Application: | Galvanized surface exposed non-polluted inland and coastal atmosphere |
| Characteristics: | 1. Good weather-resisting properties<br>2. Good appearance<br>3. Excellent adhesion properties against galvanized surface<br>4. Limited surface treatment prior to painting |

| Paints | Type of Paint | Product Name | Product Code | Thinner |
|---|---|---|---|---|
| | Twin Pack Wash Primer for Galvanized Surface | Wash Primer | 602 001 Base<br>602 099 Cat. | Etch Primer Thinner |
| | Vinyl Primer | Vinyl AC HB | 614 200 Silver<br>614 201 Silver Red Toned | Vinyl Thinner |
| | Vinyl Finish Paint | Polibi T-1 | 617 001 | |

Painting Specification

| Location | Process | Paint & Treatment | Practical Coverage ($m^2$/lt) | Dry Film Thickness (microns) | Painting Interval (20℃) | Thinning Ratio (by wt%) |
|---|---|---|---|---|---|---|
| At works or At Site | Surface Preparation | White deposit, Zinc salt or foreign matters on the surface should be removed by wire-brushing or sanding with sand paper No. 100~150 | | | | |
| | 1st Coat | Wash Primer | 5.9 | 15 | 1 Hr ~90 Days | B: 0~3<br>S: 0~5 |
| | 2nd Coat | Vinyl AC HB | 4.2 | 40 | 4 Hrs | B: 0~3<br>S: 0~5 |
| | 3rd Coat | Polibi T-1 | 6.7 | 30 | 3 Hrs | B: 0~3<br>S: 0~5 |

Thinning Ratio for: B: Brush application S: Airless Spray application

Remarks 1) Painting interval is varied by environment condition or temperature during painting.

**No. 4-401** Jan. 2010

| | |
|---|---|
| **Type:** | **Epoxy + Polyurethane Finish System** |
| Application: | Galvanized surface exposed non-polluted inland and coastal atmosphere |
| Characteristics: | 1. Good weather-resisting properties<br>2. Good appearance<br>3. Excellent adhesion properties against galvanized surface<br>4. Light surface treatment prior to painting |

| Paints | Type of Paint | Product Name | Product Code | Thinner |
|---|---|---|---|---|
| | Epoxy Primer for Galvanized Surface | Adprime No.1 | 355 201 Base<br>355 099 Hardener | Epoxy Thinner |
| | Polyurethane Finish Paint | Adthane Enamel | 470 001 Base<br>470 099 Cat. | Urethane Thinner |

Painting Specification

| Location | Process | Paint & Treatment | Practical Coverage ($m^2$/lt) | Dry Film Thickness (microns) | Painting Interval (20℃) | Thinning Ratio (by wt%) |
|---|---|---|---|---|---|---|
| At works Or At Site | Surface Preparation | White deposit, Zinc salt or foreign matters on the surface should be removed by wire-brushing or sanding with sand paper No. 100~150. Galv Etch may also be used for surface preparation (consult Data Sheet) | | | | |
| | 1st Coat | Adprime No. 1 | 10.3 | 50 | 10 Hrs ~24 Hrs | B: 0~5<br>S: 0~10 |
| | 2nd Coat | Adthane Enamel | 10.3 | 30 | 12 Hrs | B: 0~3<br>S: 0~5 |
| | 3rd Coat | Adthane Enamel | 10.3 | 30 | 12 Hrs | B: 0~3<br>S: 0~5 |

Thinning Ratio for: B: Brush application S: Airless Spray application

Remarks 1) Painting interval is varied by environment condition or temperature during painting.

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# SPECIFICATION FOR SURFACES

Galvanised surface exposed non-polluted inland and coastal atmosphere

**No. 5-001** Jan. 2010

| | |
|---|---|
| **Type:** | **Wash Primer + Alkyd Finish System** |
| Application: | Galvanized surface exposed non-polluted inland and coastal atmosphere |
| Characteristics: | 1. Good weather-resisting properties<br>2. Good appearance<br>3. Excellent adhesion properties against galvanized surface<br>4. Limited surface treatment prior to painting |

| Paints | Type of Paint | Product Name | Product Code | Thinner |
|---|---|---|---|---|
| | Twin Pack Wash Primer for Galvanized Surface | Wash Primer | 602 001 Base<br>602 099 Cat. | Etch Primer<br>Thinner |
| | Alkyd Primer | LZI Primer HB | 515 100 Red<br>515 700 Grey | Mineral Turps / Marine Thinner |
| | Alkyd Finish Paint | Evamarine Finish | 527 001 | |

Painting Specification

| Location | Process | Paint & Treatment | Practical Coverage ($m^2$/lt) | Dry Film Thickness (microns) | Painting Interval (20℃) | Thinning Ratio (by wt%) |
|---|---|---|---|---|---|---|
| At works Or At site | Surface Preparation | White deposit, Zinc salt or foreign matters on the surface should be removed by wire-brushing or sanding with sand paper No. 100~150 | | | | |
| | 1st Coat | Wash Primer | 5.8 | 15 | 1 Hr | B: 0~3<br>S: 0~5 |
| | 2nd Coat | LZI Primer HB | 10.1 | 40 | 16 Hrs ~90 Days | B: 0~3<br>S: 0~5 |
| | 3rd Coat | Evamarine Finish | 12.2 | 30 | 24 Hrs | B: 0~3<br>S: 0~5 |

Thinning Ratio for: B: Brush application S: Airless Spray application

Remarks 1) Painting interval is varied by environment condition or temperature during painting.

**No. 5-101** Jan. 2010

| | |
|---|---|
| **Type:** | **Wash Primer + Acrylic Finish System** |
| Application: | Galvanized surface exposed non-polluted inland and coastal atmosphere |
| Characteristics: | 1. Good weather-resisting properties<br>2. Good appearance<br>3. Excellent adhesion properties against galvanized surface<br>4. Limited surface treatment prior to painting |

| Paints | Type of Paint | Product Name | Product Code | Thinner |
|---|---|---|---|---|
| | Twin Pack Wash Primer for Galvanized Surface | Wash Primer | 602 001 Base<br>602 009 Cat. | Etch Primer<br>Thinner |
| | Acrylic Primer | Acri 700 Primer | 651 200 Silver<br>651 201 Silver<br>Red Toned | CR / Acri Thinner |
| | Acrylic Finish Paint | Acri 700 Finish | 652 001 | |

Painting Specification

| Location | Process | Paint & Treatment | Practical Coverage ($m^2$/lt) | Dry Film Thickness (microns) | Painting Interval (20℃) | Thinning Ratio (by wt%) |
|---|---|---|---|---|---|---|
| At works or At Site | Surface Preparation | White deposit, Zinc salt or foreign matters on the surface should be removed by wire-brushing or sanding with sand paper No. 100~150 | | | | |
| | 1st Coat | Wash Primer | 5.8 | 15 | 1 Hr ~2 Days | B: 0~3<br>S: 0~5 |
| | 2nd Coat | Acri 700 Primer | 5.8 | 40 | 7 Hrs | B: 0~3<br>S: 0~5 |
| | 3rd Coat | Acri 700 Finish | 8.6 | 30 | 7 Hrs | B: 0~3<br>S: 0~5 |

Thinning Ratio for: B: Brush application S: Airless Spray application

Remarks 1) Painting interval is varied by environment condition or temperature during painting.

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# SPECIFICATION FOR SURFACES

Galvanised surface exposed non-polluted inland and coastal atmosphere

**No. 5-801** Jan. 2010

| | |
|---|---|
| **Type:** | **Wash Primer + Water-borne Finish System** |
| Application: | Galvanized surface exposed non-polluted inland and coastal atmosphere |
| Characteristics: | 1. Good weather-resisting properties<br>2. Good appearance<br>3. Excellent adhesion properties against galvanized surface<br>4. Limited surface treatment prior to painting |

| Paints | Type of Paint | Product Name | Product Code | Thinner |
|---|---|---|---|---|
| | Twin Pack Wash Primer for Galvanized Surface | Wash Primer | 602 001 Base<br>602 099 Cat. | Etch Primer Thinner |
| | Water Based Finish Paint | Hydrosilk | 112 801 | Water |

Painting Specification

| Location | Process | Paint & Treatment | Practical Coverage ($m^2$/lt) | Dry Film Thickness (microns) | Painting Interval (20°C) | Thinning Ratio (by wt%) |
|---|---|---|---|---|---|---|
| At works or At Site | Surface Preparation | White deposit, Zinc salt or foreign matters on the surface should be removed by wire-brushing or sanding with sand paper No. 100~150 | | | | |
| | 1st Coat | Wash Primer | 5.9 | 15 | 1 Hr<br>~2 Days | B: 0~3<br>S: 0~5 |
| | 2nd Coat | Hydrosilk | 9.3 | 30 | 4 Hrs | B: 0~3<br>S: 0~5 |
| | 3rd Coat | Hydrosilk | 9.3 | 30 | 4 Hrs | B: 0~3<br>S: 0~5 |

Thinning Ratio for: B: Brush application S: Airless Spray application

Remarks 1) Painting interval is varied by environment condition or temperature during painting.

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# SPECIFICATION FOR SURFACES

Exterior exposed polluted inland, coastal and light damp or wet atmosphere

**No. 3-201** Jan. 2010

| | |
|---|---|
| **Type:** | **Organic Epoxy Zinc Primer & Acrylic System** |
| Application: | Exterior exposed polluted inland and coastal and damp or wet atmosphere |
| Characteristics: | 1. Good rust-preventing properties<br>2. Good weather-resisting properties<br>3. Good appearance<br>4. Good adhesion properties in case of long interval between at work and at site<br>5. Good acid- and alkali-resisting properties<br>6. Good water-resisting properties |

| Paints | Type of Paint | Product Name | Product Code | Thinner |
|---|---|---|---|---|
| | Organic Epoxy Zinc Rich Primer | Epicon Zinc Rich Primer B-2 | 370 004 Base<br>370 099 Cat. | Epoxy Thinner |
| | Acrylic Primer | Acri 700 Primer | 651 200 Silver<br>651 201 Silver Red Toned | CR/Acri Thinner |
| | Acrylic Finish Paint | Acri 700 Finish | 652 001 | CR/Acri Thinner |

Painting Specification

| Location | Process | Paint & Treatment | Practical Coverage ($m^2$/lt) | Dry Film Thickness (microns) | Painting Interval (20°C) | Thinning Ratio (by wt%) |
|---|---|---|---|---|---|---|
| At works | Surface Preparation | A. Blast cleaning to more than SIS-Sa 2.5.<br>B. Sweep blast-cleaning. Weld-seems and heat-damaged parts should be treated to SIS-Sa 2.5. | | | | |
| | 1st Coat | Epicon Zinc Rich Primer B-2 | 5.3 | 50 | 16 Hrs ~4 Days | B: 0~5<br>S: 10~20 |
| | 2nd Coat | Acri 700 Primer | 5.0 | 60 | 7 Hrs | B: 0~3<br>S: 0~5 |
| | 3rd Coat | Acri 700 Primer | 5.0 | 60 | 7 Hrs | B: 0~3<br>S: 0~5 |
| At Site | Surface Preparation | Damaged parts, rusted parts, and welded parts should be treated to SIS-St 3 with power tools after removal of foreign matter such as grease, moisture, dust and dirt | | | | |
| | Touching up | Touching-up with the above 1st, 2nd and 3rd Coat | | | | |
| | 4th Coat | Acri 700 Primer | 5.0 | 60 | 7 Hrs | B: 0~3<br>S: 0~5 |
| | 5th Coat | Acri 700 Finish | 7.3 | 35 | 7 Hrs | B: 0~3<br>S: 0~5 |

Thinning Ratio for: B: Brush application S: Airless Spray application

Remarks
1) Surface preparation (A) and (B) are as follows:
A) Is the case of no shop priming.
B) Is the case of shop priming. Epicon Zinc Rich Primer B-2 is recommended as shop primer.
2) Painting interval is varied by environment condition or temperature during painting.

**No. 4-302** Jan. 2010

| | |
|---|---|
| **Type:** | **Epoxy System** |
| Application: | Exterior exposed polluted inland, coastal and frequently damp or wet atmosphere<br>Acidic gas atmosphere |
| Characteristics: | 1. Excellent rust-preventing properties<br>2. Excellent weather-resisting properties<br>3. Good appearance<br>4. Excellent adhesion properties against steel surface<br>5. Excellent oil- and water-resisting properties<br>6. Excellent acid- and alkali-resisting properties |

| Paints | Type of Paint | Product Name | Product Code | Thinner |
|---|---|---|---|---|
| | High Build type Modified Epoxy Anti Corrosive Primer | Umeguard SX | 388 001 Base<br>388 099 Cat. | Epoxy Thinner |
| | High Build Epoxy Micaceous Iron Oxide Paint | Epicon F-HB | 379 614 Base<br>379 099 Cat. | |
| | Epoxy Finish Paint | Epicon Marine Finish | 369 001 Base<br>369 099 Cat. | |

Painting Specification

| Location | Process | Paint & Treatment | Practical Coverage ($m^2$/lt) | Dry Film Thickness (microns) | Painting Interval (20°C) | Thinning Ratio (by wt%) |
|---|---|---|---|---|---|---|
| At works Or At Site | Surface Preparation | A. Blast cleaning to more than SIS-Sa 2.5.<br>B. Sweep-blast-cleaning. Weld-seams and heat-damaged parts should be treated to SIS-Sa 2.5 | | | | |
| | 1st Coat | Umeguard SX | 3.3 | 150 | 10 Hrs ~30 Days | B: 0~3<br>S: 0~5 |
| | 2nd Coat | Epicon F-HB | 3.6 | 100 | 10 Hrs ~30 Days | B: 0~3<br>S: 0~5 |
| | 3rd Coat | Epicon Marine Finish | 8.4 | 40 | 8 Hrs ~30 Days | B: 0~3<br>S: 0~5 |

Thinning Ratio for: B: Brush application S: Airless Spray application

Remarks
1) Surface preparation (A) and (B) are as follows:
A) Is the case of no shop priming.
B) Is the case of shop priming. NZ Primer S is recommended as shop primer.
2) Painting interval is varied by environment condition or temperature during painting.
3) Number of coats will be increased to maintain the specified dry film thickness in the case of brush application.

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# SPECIFICATION FOR SURFACES

High temperature surface up to 400 degrees centigrade

**No. 4-701** Jan. 2010

| | |
|---|---|
| **Type:** | **Quick Drying Heat Resistant Paint** |
| Application: | High temperature surface, up to 200℃ |
| Characteristics: | 1. Excellent rust-preventing properties<br>2. Good weather-resisting properties<br>3. Good appearance<br>4. Good heat resisting properties (up to 200℃) |

| Paints | Type of Paint | Product Name | Product Code | Thinner |
|---|---|---|---|---|
| | Quick Drying Heat Resistant Paint | QD Heat Resistant Aluminium | 166 280 | Mineral Turps |

Painting Specification

| Location | Process | Paint & Treatment | Practical Coverage ($m^2$/lt) | Dry Film Thickness (microns) | Painting Interval (20℃) | Thinning Ratio (by wt%) |
|---|---|---|---|---|---|---|
| At works | Surface Preparation | A. Blast cleaning to more than SIS-Sa 2.5.<br>B. Sweep-blast-cleaning. Weld-seems and heat-damaged parts should be treated to SIS-Sa 2.5. | | | | |
| | 1st Coat | QD HR Aluminium | 10.9 | 25 | 16 Hrs | B: 0~5<br>S: 10~20<br>(S: 5~10) |
| At Site | Surface Preparation | Damaged parts, rusted parts, and welded parts should be treated to SIS-St 3 by power tools after removal of foreign matters such as grease, moisture, dust and dirt. | | | | |
| | Touching up | Touching-up with the above 1st and 2nd Coat | | | | |
| | 2nd Coat | QD HR Aluminium | 10.9 | 25 | 16 Hrs | B: 0~3<br>S: 0~5<br>(S: 5~10) |

Thinning Ratio for: B: Brush application S: Airless Spray application

Remarks
1) Surface preparation (A) and (B) are as follows:
A) Is the case of no shop priming.
B) Is the case of shop priming. Epicon Zinc Rich Primer B-2 is recommended as shop primer.
2) Painting interval is varied by environment condition or temperature during painting.

**No. 7-701** Jan. 2010

| | |
|---|---|
| **Type:** | **Inorganic Zinc & Silicone Finish System** |
| Application: | High temperature surface, up to 400℃<br>(Silver colour finishing) |
| Characteristics: | 1. Excellent rust-preventing properties<br>2. Good heat-resisting properties (up to 400℃)<br>3. Good weather-resisting properties<br>4. Good appearance |

| Paints | Type of Paint | Product Name | Product Code | Thinner |
|---|---|---|---|---|
| | High Build Type Inorganic Zinc Silicate Paint | Adzinc No 1 | 815 001 Base<br>815 099 Cat. | No Thinner |
| | Silicone Aluminium Paint | Silicon No 400 Silver | 358 080 | CR/Acri Thinner |

Painting Specification

| Location | Process | Paint & Treatment | Practical Coverage ($m^2$/lt) | Dry Film Thickness (microns) | Painting Interval (20℃) | Thinning Ratio (by wt%) |
|---|---|---|---|---|---|---|
| At works | Surface Preparation | A. Blast cleaning to more than SIS-Sa 2.5.<br>B. Sweep-blast-cleaning. Weld-seems should be treated to SIS-Sa 2.5. | | | | |
| | 1st Coat | Adzinc No 1 | 8.4 | 40 | 24 Hrs<br>~4 Days | S: 0 |
| | 2nd Coat | Silicon No 400 Silver | 17.3 | 15 | 16 Hrs<br>~1 Day | B: 0~5<br>S: 5~10 |
| At Site | Surface Preparation | Damaged parts, rusted parts, welded parts should be treated to SIS-Sa 2.5 by blasting after removal of foreign matters such as grease, moisture, dust and dirt | | | | |
| | 3rd Coat | Silicon No 400 Silver | 17.3 | 15 | 16 Hrs | B:0~5<br>S: 5~10 |

Thinning Ratio for: B: Brush application S: Airless Spray application

Remarks
1) Surface preparation (A) and (B) are as follows:
A) Is the case of no shop priming.
B) Is the case of shop priming. Adzinc No 1 is recommended as shop primer.
2) Painting interval is varied by environment condition or temperature during painting.
3) Adzinc No 1 should be applied less than120 microns dry film thickness.

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# SPECIFICATION FOR SURFACES

Tank interior. Frequently damp or wet atmosphere

**No. 4-501** Jan. 2010

| | |
|---|---|
| **Type:** | **Epoxy System** |
| Application: | Tank Interior<br>Frequently damp or wet atmosphere |
| Characteristics: | 1. Excellent water-resisting properties<br>2. Excellent anti-corrosive properties<br>3. Excellent oil-resisting properties<br>4. Excellent oil- and water-resisting properties<br>5. Excellent solvent-resisting properties |

| Paints | Type of Paint | Product Name | Product Code | Thinner |
|---|---|---|---|---|
| | Epoxy Holding Primer / Shop Primer | NZ Primer S | 373 700 Base<br>373 099 Cat. | Epoxy Thinner |
| | Epoxy Finish Paint | Epicon T-500 Finish A | 375 001 Base<br>375 099 Cat. | |

Painting Specification

| Location | Process | Paint & Treatment | Practical Coverage ($m^2$/lt) | Dry Film Thickness (microns) | Painting Interval (20℃) | Thinning Ratio (by wt%) |
|---|---|---|---|---|---|---|
| At works or At Site | Surface Preparation | A. Blast cleaning to SIS-Sa 2.5.<br>B. Sweep-blast-cleaning. Weld-seams and heat-damaged parts should be treated to SIS-Sa 2.5. | | | | |
| | 1st Coat | NZ Primer S | 7.0 | 25 | 16 Hrs ~120 Days | S: 0~10 |
| | 2nd Coat | Epicon T-500 Finish A | 4.2 | 100 | 8 Hrs ~7 Days | S: 0~5 |
| | 3rd Coat | Epicon T-500 Finish A | 4.2 | 100 | 16 Hrs ~7 Days | S: 0~5 |
| | 4th Coat | Epicon T-500 Finish A | 4.2 | 100 | 16 Hrs ~7 Days | S: 0~5 |

Thinning Ratio for: B: Brush application S: Airless Spray application

Remarks

1) Surface preparation (A) and (B) are as follows:
   A) Is the case of no shop priming.
   B) Is the case of shop priming. NZ Primer S is recommended as shop primer.
2) Painting interval is varied by environment condition or temperature during painting.
3) Number of coats will be increased to keep the specified dry film thickness in the case of brush application
4) Ventilation should be carried out for minimum 3 days after painting
5) The painting condition should be controlled with dew-point.

**No. 4-601** Jan. 2010

| | |
|---|---|
| **Type:** | **Epoxy Phenolic System** |
| Application: | Tank Interior<br>Frequently damp or wet atmosphere |
| Characteristics: | 1. Excellent water-resisting properties<br>2. Excellent anti-corrosive properties<br>3. Excellent oil-resisting properties<br>4. Excellent acid- and alkali-resisting properties<br>5. Excellent solvent-resisting properties |

| Paints | Type of Paint | Product Name | Product Code | Thinner |
|---|---|---|---|---|
| | Epoxy Holding Primer / Shop Primer | NZ Primer S | 373 700 Base<br>373 099 Cat. | Epoxy Thinner |
| | Epoxy Phenolic Finish Paint | Epicon T-800 Finish A | 365 001 Base<br>365 099 Hardener | |

Painting Specification

| Location | Process | Paint & Treatment | Practical Coverage ($m^2$/lt) | Dry Film Thickness (microns) | Painting Interval (20℃) | Thinning Ratio (by wt%) |
|---|---|---|---|---|---|---|
| At works Or At Site | Surface Preparation | A. Blast cleaning to more than SIS-Sa 2.5<br>B. Sweep-blast-cleaning. Weld-seams and heat damaged parts should be treated to SIS-Sa 2.5 | | | | |
| | 1st Coat | NZ Primer S | 7.0 | 25 | 16 Hrs ~120 Days | S: 0~10 |
| | 2nd Coat | Epicon T-800 Finish A | 4.7 | 100 | 16 Hrs ~7 Days | S: 0~5 |
| | 3rd Coat | Epicon T-800 Finish A | 4.7 | 100 | 16 Hrs ~7 Days | S: 0~5 |
| | 4th Coat | Epicon T-800 Finish A | 4.7 | 100 | 16 Hrs ~7 Days | S: 0~5 |

Thinning Ratio for: B: Brush application S: Airless Spray application

Remarks

1) Surface preparation (A) and (B) are as follows:
   A) Is the case of no shop priming.
   B) Is the case of shop priming. Epicon Zinc Rich Primer or NZ Primer S is recommended as shop primer.
2) Painting interval is varied by environment condition or temperature during painting.
3) Number of coats will be increased to keep the specified dry film thickness in the case of brush application
4) Ventilation should be carried out for minimum 3 days after painting
5) The painting condition should be controlled with dew-point.
6) As the 2nd, 3rd and 4th coats are of the same product it will be advantageous to apply different colours for each of these coats.

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# SPECIFICATION FOR SURFACES

Sea water immersed. Sea water splash zone

**No. 4-301** Jan. 2010

| **Type:** | **Epoxy System** |
|---|---|
| Application: | Sea water, immersed<br>Sea water splash zone |
| Characteristics: | 1. Excellent anti-corrosive properties<br>2. Excellent water-resisting properties<br>3. Excellent adhesion properties against steel surface<br>4. Good appearance |

| Paints | Type of Paint | Product Name | Product Code | Thinner |
|---|---|---|---|---|
| | High-build Type Modified Epoxy Anti-corrosive Primer | Umeguard SX | 388 001 Base<br>388 099 Cat. | Epoxy Thinner |
| | Epoxy Finish Paint | Epicon Marine Finish | 457 001 Base<br>457 099 Cat. | |

Painting Specification

| Location | Process | Paint & Treatment | Practical Coverage ($m^2$/lt) | Dry Film Thickness (microns) | Painting Interval (20°C) | Thinning Ratio (by wt%) |
|---|---|---|---|---|---|---|
| At works or At Site | Surface Preparation | A. Blast cleaning to more than SIS-Sa 2.5<br>B. Sweep-blast-cleaning. Weld-seams should be treated to SIS-Sa 2.5. | | | | |
| | 1st Coat | Umeguard SX | 3.3 | 150 | 10 Hrs ~30 Days | B: 0~3<br>S: 0~5 |
| | 2nd Coat | Umeguard SX | 3.3 | 150 | 10 Hrs ~30 Days | B: 0~3<br>S: 0~5 |
| | 3rd Coat | Epicon Marine Finish | 8.4 | 40 | 8 Hrs ~30 Days | B: 0~3<br>S: 0~5 |

Thinning Ratio for: B: Brush application S: Airless Spray application

Remarks

1) Surface preparation (A) and (B) are as follows:
   A) Is the case of no shop priming.
   B) Is the case of shop priming. Epicon Zinc Rich Primer B-2 is recommended as shop primer.
2) Painting interval is varied by environment condition or temperature during painting.
3.) Number of coats will be increased to maintain the specified dry film thickness in the case of brush application.

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# PRODUCT SPREADING RATE CHART

**Theoretical and Practical Spreading Rates given below are also expressed in Square Meters per Litre and Litres per Square Metres.**

**Spreading rates can also vary with the type of application e.g. spray, brush or roller. Practical spread rates are determined by a loss factor which is affected by weather conditions, and the surface roughness or profile especially with spray application.**

**These spreading rates are equated against the given typical dry film thickness (D.F.T.).**

**Spreading rates must not be confused with coverage and therefore for costing purposes and quantities it is advisable that the relative Data Sheet be consulted to establish the required number of coats to be applied against the recommended film thickness.**

| PRODUCT DESCRIPTION | THEORETICAL Sq.Mtr/Ltr | THEORETICAL Ltr/Sq.Mtr | PRACTICAL Sq.Mtr/Ltr | PRACTICAL Ltr/Sq.Mtr | TYPICAL D.F.T. |
|---|---|---|---|---|---|
| Acri 700 Finish | 12.3 - 10.5 | 0.081 - 0.095 | 8.6 - 7.3 | 0.116 - 0.137 | 30 - 35 microns |
| Acri 700 Primer | 9.5 - 4.7 | 0.105 - 0.211 | 6.7 - 3.3 | 0.149 - 0.303 | 40 - 80 microns |
| Adprime No. 1 | 22.0 - 7.5 | 0.045 - 0.133 | 15.4 - 5.3 | 0.065 - 0.189 | 20 - 60 microns |
| Adthane Enamel | 14.7 - 11.0 | 0.068 - 0.091 | 10.3 - 7.7 | 0.097 - 0.130 | 30 - 40 microns |
| Adzinc No. 1 | 12.0 - 6.0 | 0.083 - 0.167 | 8.4 - 4.2 | 0.119 - 0.238 | 40 - 80 microns |
| Bannoh 500 R | 8.3 - 3.4 | 0.120 - 0.290 | 5.8 - 2.4 | 0.172 - 0.417 | 75 - 175 microns |
| Bituminous Aluminium | 18.8 - 9.4 | 0.053 - 0.106 | 13.2 - 6.6 | 0.076 - 0.152 | 25 - 50 microns |
| Bituminous Black | 14.8 - 7.4 | 0.068 - 0.135 | 10.4 - 5.2 | 0.096 - 0.192 | 50 - 100 microns |
| Epicon F-HB | 10.2 - 5.1 | 0.098 - 0.196 | 7.1 - 3.6 | 0.141 - 0.278 | 50 - 100 microns |
| Epicon Marine Finish | 15.2 - 9.0 | 0.066 - 0.111 | 10.6 - 6.3 | 0.094 - 0.159 | 30 - 50 microns |
| Epicon T-500 Finish | 7.4 - 4.4 | 0.136 - 0.227 | 5.2 - 3.1 | 0.192 - 0.323 | 75 - 125 microns |
| Epicon T-800 | 8.4 - 5.0 | 0.119 - 0.199 | 5.9 - 3.5 | 0.169 - 0.286 | 75 - 125 microns |
| Epicon Zinc Rich Primer B-2 | 19.0 - 7.6 | 0.053 - 0.132 | 13.3 - 5.3 | 0.075 - 0.189 | 20 - 50 microns |
| Evamarine Finish | 20.4 - 14.5 | 0.048 - 0.068 | 14.3 - 10.2 | 0.070 - 0.098 | 25 - 35 microns |
| Hydrobond 44 | 12.9 - 10.0 | 0.078 - 0.100 | 9.0 - 7.0 | 0.111 - 0.143 | 35 - 45 microns |
| Hydrogloss | 12.8 - 9.8 | 0.078 - 0.102 | 9.0 - 7.0 | 0.111 - 0.143 | 35 - 45 microns |
| Hydrosilk | 13.3 - 10.0 | 0.075 - 0.100 | 9.3 - 7.0 | 0.108 - 0.143 | 30 - 40 microns |
| LZI Primer HB | 16.9 - 7.2 | 0.059 - 0.138 | 11.8 - 5.0 | 0.085 - 0.200 | 30 - 70 microns |
| Metallic Zinc Rich Primer | 5.0 – 2.5 | 0.200 - 0.400 | 3.5 - 1.8 | 0.286 - 0.555 | 140 - 280 microns |
| NZ Primer S | 12.0 - 8.0 | 0.083 - 0.125 | 8.4 - 5.6 | 0.119 - 0.179 | 20 - 30 microns |
| Polibi T-1 | 13.9 - 9.5 | 0.072 - 0.108 | 9.7 - 6.7 | 0.103 - 0.149 | 20 - 30 microns |
| QD HR Aluminium 200℃ | 15.6 - 11.1 | 0.064 - 0.090 | 10.9 - 7.8 | 0.092 - 0.128 | 25 -35 microns |
| Silicon No. 400 Silver | 33.0 - 16.4 | 0.030 - 0.061 | 23.1 - 11.5 | 0.043 - 0.087 | 10 - 20 microns |
| Tuffcoat | 6.0 - 3.0 | 0.167 - 0.333 | 4.2 - 2.1 | 0.238 - 0.476 | 140 - 280 microns |
| Umeguard MT | 8.3 - 4.1 | 0.121 - 0.241 | 5.8 - 2.9 | 0.172 - 0.345 | 100 - 200 microns |
| Umeguard SX | 5.8 - 2.3 | 0.172 - 0.431 | 4.1 - 1.6 | 0.244 - 0.625 | 100 - 250 microns |
| Uny Marine | 16.9 - 12.6 | 0.059 - 0.079 | 11.8 - 8.8 | 0.085 - 0.114 | 30 - 40 microns |
| Vasbyt Single Pack Etch Primer | 7.3 - 5.5 | 0.137 - 0.182 | 5.1 - 3.9 | 0.196 - 0.256 | 15 - 20 microns |
| Vinyl AC-HB | 8.8 - 3.7 | 0.113 - 0.272 | 6.2 - 2.6 | 0.161 - 0.385 | 25 - 60 microns |
| Walksafe | 2.0 - 1.0 | 0.500 - 1.000 | 1.4 - 0.7 | 0.714 - 1.428 | 250 - 500 microns |
| Wash Primer | 11.0 - 5.5 | 0.091 - 0.182 | 7.7 - 3.9 | 0.130 - 0.256 | 10 - 15 microns |

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# Operating Surface Temperatures

| PRODUCT | MINIMUM | MAXIMUM | | | |
|---|---|---|---|---|---|
| | DRY | DRY | | WET | |
| | | CONTINUOUS | TEMPORARY | CONTINUOUS | TEMPORARY |
| Acri 700 Finish | -30 | 80 | 80 | | |
| Acri 700 Primer | -30 | 80 | 80 | | |
| Adprime No. 1 | -40 | 100 | 100 | | |
| Adthane Enamel | -40 | 120 | 120 | | |
| Adzinc No. 1 | -30 | 100 | 100 | | |
| Bannoh 500 R | -60 | 100 | 150 | | |
| Bituminous Aluminium | -20 | 80 | 80 | | |
| Bituminous Black | -20 | 100 | 100 | | |
| Epicon F-HB | -60 | 150 | 150 | | |
| Epicon Marine Finish | -60 | 150 | 150 | | 70(1 Day) |
| Epicon T-500 Finish | -60 | 150 | 150 | 60 | 75(>10 Days) |
| Epicon T-800 Finish | -60 | 150 | 150 | 60 | 75(>10 Days) |
| Epicon Zinc Rich Primer B-2 | -60 | 60 | 150 | | |
| Evamarine Finish | -20 | 100 | 100 | | |
| Hydrobond 44 | -5 | 60 | 60 | | |
| Hydrogloss | -5 | 60 | 60 | | |
| Hydrosilk | -5 | 60 | 60 | | |
| LZI Primer HB | -20 | 100 | 100 | | |
| Metallic Zinc Rich Primer | -30 | 100 | 100 | | |
| NZ Primer S | -60 | 150 | 150 | | |
| Polibi T-1 | -30 | 80 | 80 | | |
| QD HR Aluminium 200°C | -20 | 200 | 200 | | |
| Silicon No. 400 Silver | -20 | 400 | 400 | | |
| Tuffcoat | -40 | 120 | 120 | | |
| Umeguard MT | -60 | 100 | 100 | | 75 |
| Umeguard SX | -60 | 100 | 100 | | 75 |
| Uny Marine | -60 | 150 | 150 | | |
| Vasbyt Single Pack Etch Primer | -40 | 150 | 150 | | |
| Vinyl AC HB | -30 | 80 | 80 | | |
| Walksafe | -20 | 80 | 80 | | |
| Wash Primer | -20 | 150 | 150 | | |

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# CONVERSION TABLES




| Conversion Factors | | |
|---|---|---|
| By | Multiply | To Obtain |
| 0.0254 | Inches | Metres |
| 0.305 | Feet | Metres |
| 6.00 | Fathoms | Feet |
| 6.086 | Feet | Nautical Mile |
| 5.28 | Feet | Statute Mile |
| 0.914 | Yards | Metres |
| 1608.00 | Miles | Metres |
| 1.609 | Miles | Kilometres |
| 0.03937 | Millimetres | Inches |
| 0.3937 | Centimetres | Inches |
| 39.37 | Metres | Inches |
| 3.281 | Metres | Feet |
| 1.094 | Metres | Yards |
| 0.621 | Kilometres | Miles |
| 645.137 | square inches | square Millimetres |
| 6.45 | square inches | square Centimetres |
| 0.0929 | square Feet | square metres |
| 0.836 | square Yard | square metres |
| 0.155 | square Centimetres | square inches |
| 10.764 | Square Metres | Square Feet |
| 1.196 | square metres | square Yards |
| 0.2642 | Litres | US Gallons |
| 0.22 | Litres | Imperial Gallons |
| 3.78 | Gallons | Litres |
| 1.20 | Imperial Gallons | US Gallons |
| 4.55 | Imperial Gallons | Litres |
| 0.833 | US Gallons | Imperial Gallons |
| 35.314 | Cubic Metres | Cubic Feet |
| 2.40282 | Kilograms | Pounds (Lbs) |
| 28.3496 | Ounces | Grams |
| 0.45359 | Pounds | Kilograms |

| Film Thicknesses | |
|---|---|
| 1 microns = 0.0394mil | 1 mil = 25.4 microns |

| Calculation Tables | |
|---|---|
| Theoretical spreading rate (m²/litre) | = 10 x Volume % of solids in paint / D.F.T. (microns) |
| Theoretical paint consumption (litre) | = D.F.T. (microns) x Surface area m² / 10 x Volume % of solids in paint |
| Theoretical cost per square metre | = D.F.T. (microns) x Price per litre / 10 x Volume % of solids in paint |

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# GENERAL INSTRUCTIONS FOR SURFACE PREPARATION & PAINTING

## General Instructions for Surface Preparation & Painting

### Surface Preparation

In protecting steel with paint, careful surface preparation is of utmost importance. If this surface preparation is neglected, the performance of the paint cannot be ensured.

(1) Surface Preparation of Bare Steel (Pre-Fabrication Treatment)

(a) Remove oil and grease by solvent cleaning after scraping away firmly adhering impurities.
(b) Corrosive salts and any sulphates on steel surface are to be removed with fresh-water washing. The surface is then to be dried with dry waste cloth or dry compressed air.
(c) All mill scale, rust and foreign matter is to be removed by shot-, grit- or sand-blasting. Finally, the surface should be cleaned by blowing down with compressed air.

Treated bare steel surfaces rust rapidly when exposed to the air, and therefore should be painted with a shop primer as soon as possible in order to prevent re-rusting during storage, fabrication and fitting out. The main function of shop primers is to provide steel with temporary protection against rusting during fabrication and fitting out. Consequently, rapid drying so as to permit handling in a short time after application and welding or gascutting properties are required for the shop primer.
Shop primers must also be compatible with any subsequent paint.

(2) Surface Preparation of Shop Primed Surface
(Secondary Surface Preparation or Post-Fabrication Treatment)

Water and moisture, oil and grease, white rust, chalk marks, unsuitable marking paint and other contaminants should be removed by solvent cleaning and/or suitable degreasing. If the shop primed surface has been damaged during rolling, cutting or welding, or suffered mechanical abrasion in storage, handling and transport, the affected areas should be cleaned by wire brush or disc sander and touched-up. The entire surface must be cleaned by washing, if necessary, before subsequent paints are applied.

(3) Surface preparation for Old Paint Film

The surface must be cleaned by scraping and/or solvent wiping and/or fresh water washing to remove salt, dirt, oil and grease and other impurities. All rust, oil, loose paint film and other impurities should be removed by disc sander, wire brush or other suitable method after which a specified paint system should be applied.

# GENERAL INSTRUCTIONS FOR SURFACE PREPARATION & PAINTING

(4) Dry Abrasive Blast Cleaning

These guidance notes are intended to be a tool for the visual assessment of preparation grades by means of dry abrasive blast cleaning.

The surface finish achieved by means of dry abrasive cleaning depends on the original surface condition as well as the type of abrasive blasting equipment, size, hardness, type and abrasive shape.

The original surface conditions of steel may be one of four of the following rust grades:

A Steel surface largely covered with adhering mill scale, but little, if any rust.

B Steel surface which is beginning to rust and the mill scale is starting to flake.

C Steel surface on which the mill scale has rusted away or from which it can be scraped and with slight pitting visible under normal vision.

D Steel surface on which the mill scale has rusted away and on which general pitting is visible under normal vision.

(5) Preparation grades for dry abrasive blast cleaning.

Surface cleanliness is divided into four grades, designated by the letters ‘Sa’.

Sa 1 Light blast cleaning or brush-off.
Sa 2 Thorough blast cleaning or commercial blast.
Sa 2.5 Very thorough blast cleaning or near white metal.
Sa 3 Blast cleaning to visually clean steel or white metal.

The most ideal preparation is blast cleaning, however this may not always be possible due to environment, prevailing factors, cost issues, etc. Although coatings and coating systems have been prepared, care should be taken with the type of mechanical pre-treatment methods use.

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# GENERAL INSTRUCTIONS FOR SURFACE PREPARATION & PAINTING

**Preparation grades for Mechanical Cleaning:**

St 2 Thorough hand and power tool cleaning
St 3 Very thorough hand and power tool cleaning

**Types of Mechanical Cleaning:**

Hand Scraping
Hand Brushing
Wire Brushing
Disc-grinding
Needle chipping
De-scaling
Chisel Hammering

The results produced from the above mechanical cleaning may result in poor surface preparation and the danger of polishing or chipping the surface area.

**Painting**

(1) Weather Conditions

Full advantage should be taken of weather conditions to carry out painting when the weather is favourable.
Paint should never be applied on to a wet surface. Not only should painting be avoided in rain, sleet or fog, but attention must be paid to the presence of condensation on the surface.
Generally, painting should be done at over 5$^{o}$C and below 85% Relative Humidity (R.H.).
Painting should not be carried out when the surface temperature is less than 3$^{o}$C above the dew point, no matter what the R.H. is at the time.
NB. Observe instructions for application of epoxy coatings, epoxy tank coatings or inorganic zinc coatings.

# GENERAL INSTRUCTIONS FOR SURFACE PREPARATION & PAINTING

(2) Preparation and Storage

(a) Some paint components, although perfectly stable at normal temperature, will react together at higher temperatures, causing thickening, etc. Some paints such as water based paint should not be stored where temperatures fluctuate excessively.

(b) Shelf life
If stored in normal conditions,

Oleo resinous
… 18 months maximum, subject to re-inspection thereafter

Modified Acrylic, Epoxy
… 12 months maximum, subject to re-inspection thereafter

Inorganic Zinc
… 6 months maximum, subject to re-inspection thereafter

(c) When paints are left standing they very often tend to separate slightly. This is caused by the different specific gravities of the ingredients. All paint must, therefore, be carefully stirred and mixed until homogenized before using. Stirring should be done from time to time in order to prevent such separation, while painting.
(d) Once opened, some paints rapidly form a skin on the surface. Generally the quick-drying types have this tendency, this being no fault of the paint, but is due to the natural process of drying. The skin must be removed before painting. This precaution should be applied particularly as the skin may clog the spray equipment.
(e) Most paints do not normally require adjustment but under conditions of excessively high or low temperature a small amount of appropriate thinner, not exceeding the amount specified by the manufacturer, may be added in order to ease brushing or to bring paint to spraying consistency.

(3) Film Thickness

The dry film thickness of shop primer on a blasted steel surface should be measured as follows:
Place a smooth steel panel on blasted steel surface, apply shop primer and measure the dry film thickness on the steel panel with an adequate electromagnetic thickness meter.

# GENERAL INSTRUCTIONS FOR SURFACE PREPARATION & PAINTING

(4) Application Method

(a) Brush
The paint should be applied on the surface by lengthwise and crosswise movements of the brush. Rough surfaces, rivet heads, edges and angles should be given special attention with the application of a stripe coat.
(b) Paint Roller
Cover the surface of the roller by spreading the paint. Paint at a slow and even pace up, down and across. Do not spread the paint excessively. Particular care should be taken when painting rivet heads and welding seams.
(c) Airless Spray
Most products can be applied by airless spray, which is still more effective and economic method than conventional spray, especially on large areas. The method is quicker with less spillage and the paint can be applied in thicker coats. The use of airless spray requires more of a routine than conventional spray and great caution must be exercised in handling the spray gun, which works with very high pressure.

(5) Cleaning of Tools

The tools should be cleaned immediately after use. This is particularly important when working with quick-drying or two component paints. Spray equipment should be cleaned after use by flushing with an adequate thinner. Special care should be taken in cleaning the nozzles.

(6) General Safety and Health Protection

Refer to the Safety and Health Protection page in this manual for all matters pertaining to the protection of skin and eyes as well as the dangers of ingestion and inhalation when using our paint products irrespective of the method of application.

# GENERAL INSTRUCTIONS FOR SURFACE PREPARATION & PAINTING

## Instructions for application of Epoxy

**Instructions for application of Epoxy and Epoxy Tank Coatings**

**Cleaning prior to Painting (Secondary Surface Preparation)**

In surface preparation and cleaning of the surface, special attention should be given to the welded parts and edges of steel construction. Dust, spatter, slag, etc. should be removed.

(1) Damaged parts

Rusty parts should be cleaned by disc sander or other suitable method to the grade SIS St 3.
Welding spatter, slag and other foreign matter should be removed by scraper, scaling hammer or suitable tools.
Areas burned by welding or other heat treatment, including adjacent areas, should be cleaned by disc sander or suitable tools to SIS St 3.
Welding Parts should be cleaned by power brush or other suitable method.

(2) Undamaged parts

Oil, moisture, dust or other foreign matter should be removed by thinner, power brush, disc sander, compressed air or vacuum cleaner, etc.
After cleaning, a subsequent coat should be applied as soon as possible.

**Mixing of Materials**

(1) Mixing

Base and hardener should be mixed in the specified proportions and ensure a homogeneous state.
Since poor mixing may impair its drying property, mixing should be done by a pneumatic mixing machine or the like.

(2) Thinning

Thinner may be added in spray application, but should never exceed the specified amount.

(3) Ageing (induction period)

When indicated necessary, the mixed material should not be aged longer than the specified period before application.
Insufficient ageing causes blooming.

# GENERAL INSTRUCTIONS FOR SURFACE PREPARATION & PAINTING

## Instructions for application of Epoxy

(4) Pot Life

The mixture should be used within the specified pot life.

**Painting**

Airless spray is most recommendable. With regard to spray application, cross spraying (double spraying) is recommended to obtain a uniform and specified film thickness. If film thickness is found insufficient, an additional coat should be applied on these parts. Edges, corners, welding seams, scallops, underside of longitudinal areas should be touched up prior to spraying.
In particular, underside of longitudinal areas must be painted carefully, for it is difficult to obtain sufficient film thickness.
Painting interval should be kept as specified. If the painting interval is over that specified, the surface to be coated should be roughened by sand paper, disc sander or other adequate tools before application of any further paint coating.

**Control of Film Thickness**

Film thickness should be controlled at the recommended mean value, unless otherwise specified.

**Weather condition and drying condition**

Generally, painting should be done over 5oC and below 85% R.H. Painting should not be carried out when the surface temperature is less than 3oC above the dew point, no matter what the R.H. is at the time.

**Protection of Paint Film**

(1) Painted surface should be kept free from water or other liquid during drying through period.
(2) Painted surface should be kept free from welding sparks or dirt during and before touch-free drying of the paint film.
(3) Painted surface should be cordoned-off to prevent possible damage by foot-steps in tank interior surfaces.

**Precautions for Fire Hazard and Health**

(1) Solvents are flammable, so attention must be given to prevent fire hazard. When painting is carried out in confined spaces such as a tanks' interior, sufficient ventilation should be provided during painting and during the drying process. (2) To prevent contamination of the skin by the paint, protective cream may be used for the painters. Should paint stain the skin, it should be wiped off with a suitable thinner and then washed with fresh warm water.

# GENERAL INSTRUCTIONS FOR SURFACE PREPARATION & PAINTING

## Instructions for application of Organic and Inorganic Zinc Coatings

**Instructions for Application of Organic and Inorganic Zinc Coatings**

**Cleaning Prior to Painting (Secondary Surface Preparation)**

The surface should be cleaned by grit blasting, sweep blasting or power tool cleaning after removing oil and grease.

Mixing of Materials

(1) Mixing

Zinc paste and activator or hardener should be mixed in the specified proportion as per the Data Sheet. Mixing should be done thoroughly to ensure proper mixing and a homogeneous condition. As the mixture tends to separate, mixing should be constantly carried out during painting. Prior to painting, it is recommended that the mixture be filtered through a 80 mesh screen.

(2) Ageing (induction period)

If indicated, specified time should be kept for ageing. When ageing is not sufficient, paint failures are likely to occur.

(3) Pot Life

The mixture should be used within the specified pot life. The quality will be impaired, if left longer than the pot life.

**Painting**

(1) Painting Equipment

Special care is needed for application of inorganic zinc coating. It is recommended to be applied by conventional spraying equipment using a pressurized pot or airless spray equipment. Always ensure that the correct nozzle tip and type are used as well as the recommended spray hose type and length as per the manufacturer's specification. Cross spraying (double spraying) is highly recommended to obtain a uniform and the specified film thickness. The painting equipment should be clean and kept in good condition.

(2) Additional Coat

If film thickness by application is found insufficient, an additional coat should be applied.

# GENERAL INSTRUCTIONS FOR SURFACE PREPARATION & PAINTING

## Instructions for application of Organic and Inorganic Zinc Coatings

(3) After painting

After application of Inorganic Zinc observe over-coating time as per relative Data Sheet.

**Control of Film Thickness**

Film thickness should be controlled at the recommended mean value, unless otherwise specified. Dry film thickness in excess of 120 microns per coat should be avoided, since mud cracking could occur. Film thickness should be measured by a wet and/or dry film thickness gauge.

**Weather Conditions**

Temperature 3 – 50oC
Humidity 50 – 95 % R.H.

**Touch Up**

Small damaged parts, holiday and cracking should be treated with scraper, disc sander or power brush to SIS ST 3, and be painted according to the recommended painting scheme, unless otherwise specified.

**Warning**

Organic and inorganic zinc coatings are flammable. Keep away from sparks and flames during application. Adequate ventilation should be provided during application and in the process of drying.

**Precautions for Fire Hazard and Health**

(1) Solvents are flammable, so attention must be given to prevent fire hazard. When painting is carried out in confined spaces such as a tanks' interior, sufficient ventilation should be provided during painting and during the drying process. (2) To prevent contamination of the skin by the paint, protective cream may be used for the painters. Should paint stain the skin, it should be wiped off with a suitable thinner and then washed with fresh warm water.