

AVKOTE LE

Guide lines for the application of Avkote paint for use on PVCu, GRP, MDF, Metal, Aluminium, Steel and Powder coating.

1. MATERIALS

Cleaning Agent	AVKOTE 153 or 153b with 154 Cleaner
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COATING

Acrylic Top Coat Spray	AVKOTE 279 Hardener
KF Thickener / Hardener	Add up to 30% of KF
Contrasil / Anti-Silicone	add up to 1-3%/6-20grms / 1 red cap full=5grms

MIXING RATIO

100 parts by volume AVKOTE LE 10 parts by volume AVKOTE 279 Hardener (10/1) 30-35% gloss standard
 100 parts by volume AVKOTE LE 25 parts by volume AVKOTE 279 Hardener (25/1) 50% gloss approx.
 100 parts by volume AVKOTE LE/KF 25 parts by volume AVKOTE 279 Hardener (25/1) 35-45% gloss

COATING

PVC Lacquer	High Gloss - AVLACK 1490 95-100% gloss Gloss - AVLACK 1483 80-85% gloss Clear Coat - AVLACK 1485 30-35% gloss
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MIXING RATIO

100 parts by volume AVLACK 1490 (2/1) – 50 parts by volume AVKOTE 279 Hardener
 100 parts by volume AVLACK 1483/1485 (4/1) – 25 parts by volume AVKOTE 279 Hardener

PRIMER

Required when coating Aluminium, Steel, Metal and Powder Coating.	AVKOTE 2250 Primer AVKOTE 2243 Hardener AVKOTE 3000 Thinner
Waterbase AK	AVKOTE AK Primer
Required when coating MDF, Plywood and Timber general	AVKOTE 207 Sealer AVKOTE 1090 Spray Filler AVKOTE 13000 Thinner

MIXING RATIO

90 parts by volume AVKOTE 2250 Primer (9/1) - 10 parts by volume AVKOTE 2243 Hardener
 100 parts by volume AVKOTE 207 Sealer (2/1) – 50 parts by volume AVKOTE 1091 Hardener
 100 parts by volume AVKOTE 1090 Primer (4/1) – 25 parts by volume AVKOTE 1091 Hardener
 Thinners as required

2. APPLICATION

For Primer see separate Data Sheets 9008 for 2250, 9024 for 207 Sealer and 9025 for 1090.

Stage 1

Mask necessary areas and scotch any material that is not virgin top grade product, equalise any scratches with fine sandpaper.

Stage 2

Temperature to remain between 10-25°C, min 10°C (product and environment). Remove debris in holes with oil and water free compressed air.

Stage 3

Surfaces to be sprayed must be cleaned thoroughly using lint-free cloth soaked in AVKOTE 153 or 153b with 154 Cleaner, paying particular attention to the narrow edges (overlaps) which need spraying. Scan for contamination by wax, silicone and glues.

Stage 4

Application - When all preparation stages have been completed, spraying may commence in an appropriately heated and ventilated paint booth/area. Coverage required is approximately 30 microns. Normally only one coat is required.

Stage 5

Curing - Drying times are based at 20°C the minimum being 10°C and the maximum being 30°C

Tack free in 2-5 minutes, can be handled in 2 hours

Dry in 30 minutes

Total Cure in 24 hours, the product will cure at +10° C but will take approximately 12-24 hours.

3. RESTORATION

Note

Imperfections in the spray finish can be touched in using the techniques described below. Because of the high bonding strength and impact resistance of AVKOTE when applied in the correct way, such restoration should only be necessary if the surfaces are subjected to extreme physical or chemical damage. The following touching-in instructions cover paint restoration both prior to assembly and while on site.

Restoration prior to assembly or on site

a) Minor Scratches

Restore using AVKO touch-in applicator filled with AVKOTE paint. It is important to note that all AVKOTE paint used in these applicators are not mixed with AVKOTE 279 Hardener.

b) Major Damage

The procedure for touching-in work is the same as the original spraying.

- Cover the undamaged areas using masking tape
- Abrade the damaged area across the entire profile from edge to edge (including overlaps), using graded sanding paper.
- Clean the abraded surfaces thoroughly with AVKOTE 153 or 153b with 154 Cleaner
- Spray surfaces as before.
- Fillable spray aerosols are available from AVKO for small on site repairs

This information is a standard recommendation. The application should be adapted to local standards. No liability or claim can be made from this