



Spraying PVCu



How our product works.

Firstly it is important to understand how our product works as it is different to most 2K products that are normally baked on after application. Our product produces a chemical reaction with the substrate to which you are applying onto, thus saving the time and cost of baking the coating on, making this product very quick and cost effective in use.

This means that if there are any contaminants left on the surface of the PVCu the chemical reaction will not take place and the coating will not adhere to the substrate. Providing that the PVCu is clean, the chemical reaction will take place and there will be no problem with the adhesion which is exceptionally good.



TUTORIAL



PREPARATION

Remove protective low tack tape only from the side to be coated.

Always check the general condition of components.
I.e. cracks, marks, surface contamination, dirt, grease, silicones and any other defects.

Masking is usually required when less than 2 faces are to be sprayed.
This can be achieved using standard masking tape.

Mask open hollow channels in extrusions.

If co-extruded glazing gasket is required to be masked, there are tapes other than standard masking tape that will adhere to these. Please ask AVKO technical department about these products.





It is advisable to spray a dip card for each job with the paint colour you are using, remembering to include a batch number so that it has traceability or for colour matching of any future continuation jobs.



Cards can be taped somewhere in the booth to be painted.



CLEANING

These products should be cleaned with a 100% cotton lint-free cloth soaked in the AVKOTE cleaners. It is particularly important to ensure that all surfaces to be coated are prepared correctly. This is because the coating adheres to the PVCu by way of a chemical reaction with the surface, so if there are any contaminants (such as soaps and waxes) left from the extrusion process, the coating will sit on top of them and the chemical reaction will not take place and the coating will not adhere. Providing the surface is cleaned properly, the coating will adhere every time and will never come off. The product should be cleaned first with AVKOTE 153b, which is then removed with AVKOTE 154 cleaner.



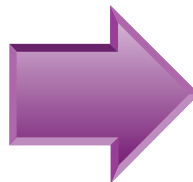


FINAL PREPARATION BEFORE SPRAYING

Always make sure that your spray equipment is clean and ready to use with the correct jet and air cap size (1.4 -1.8mm will be suitable). The paint always needs to be mixed well before pouring. This can be done in a shaker or by hand with a mixing stick.

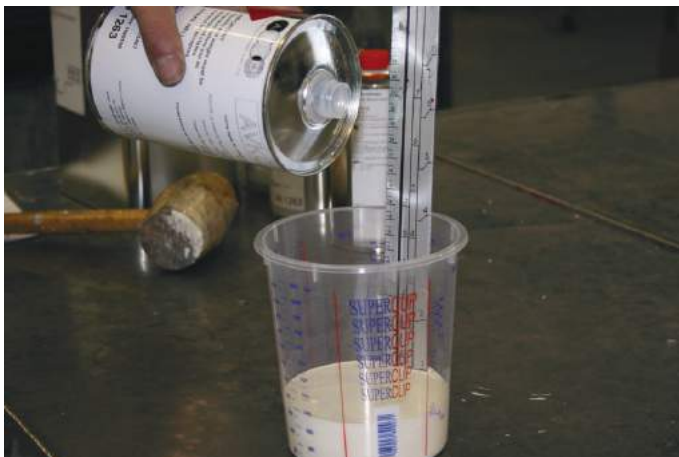
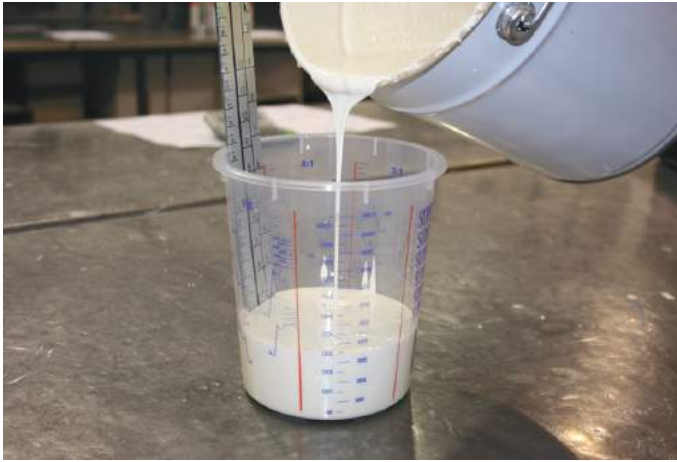


The first part of the mixing process is to pour out the stirred or shaken paint into the appropriate container. Mixing in the hardener can be done by weight on a set of scales.



This can also be done by volume in a measuring jug or in a container with a measuring stick. It is imperative that the correct amount of hardener is put in as this affects the drying time, the adhesion, the gloss level, the elasticity and longevity of the product. Please refer to the TDS sheet for the mixing ratio.

When the paint is ready for spraying, pour it into your spray gun using the appropriate paint filter. Always use all of the appropriate safety equipment and extraction for the product being used. Please follow the relevant safety data sheets for the product you are using.



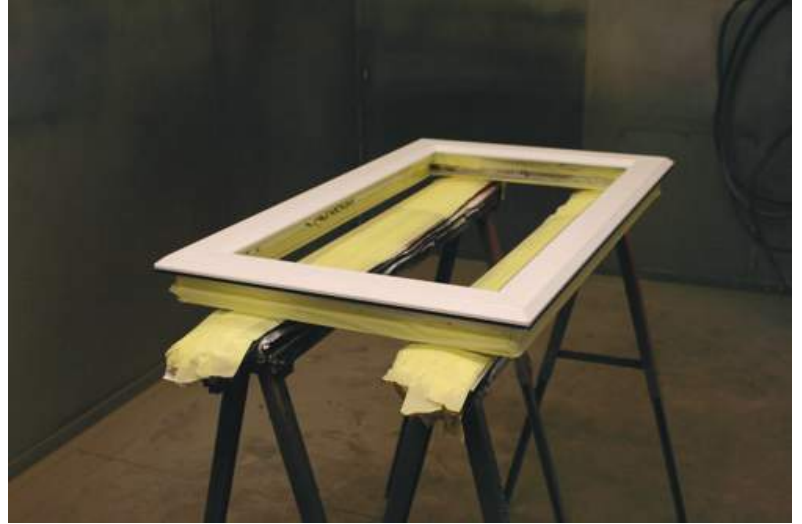
Before spraying blow down the product with an air gun using your other hand to rub off the particles as the PVCu is very static.





SET UP IN BOOTH. HANGING AND LAYING METHOD

The coating can be applied hung vertically or on trestles horizontally.





APPLICATION

When all preparation stages have been completed, spraying may commence in an appropriately heated booth. Use a quality HVLP spray gun.

A three-quarter coat and full topcoat are only required for most colours allowing the first coat to flash off before applying the top coat.

Allow the component to flash off for a period of about 2-3 minutes prior to applying a clear coat if required, or entering the curing stage.

If a catalytic dryer is being used, use 1484 lacquer and ensure that the satin clear coat finish has dried to a satin finish before putting it through the catalytic dryer otherwise it will dry glossy.

A special satin clear coat is available for use with catalytic dryers, which will give a satin finish. If you have any queries about this product please discuss this with the AVKO technical staff.

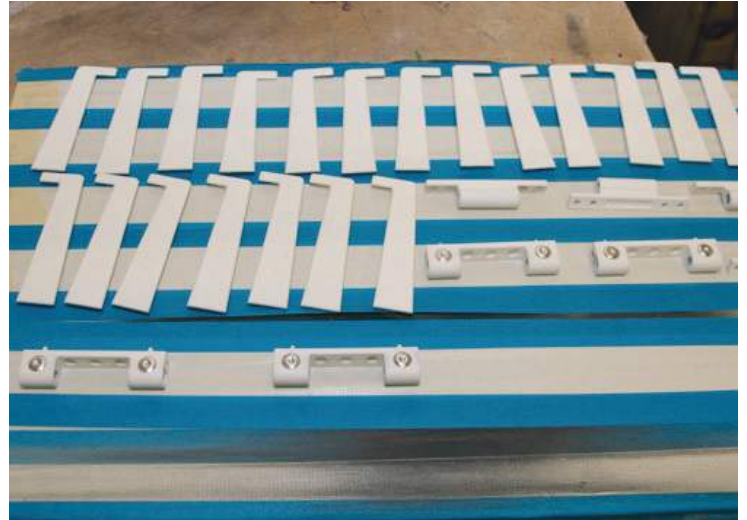




CURING AND DRYING

When spraying small parts these can be set up on boards with double sided tape to hold them down.

Allow the component to flash off for a period of about 2-3 minutes prior to entering the curing stage.



The material will be touch dry in 2-3 minutes.

The product does not need heat to cure so you can allow products to dry naturally on a racking system at a minimum of 10-15°C for at least 12 hours.

At 20-25°C the product will be 70% cured in about an hour and will be dry enough to handle. This product can be dried in temperatures up to 30°C.

The only thing that must be noted is that the coating must not be subjected to sub zero temperatures before it has a chance to cure as it will go brittle and will not cure properly.





PACKAGING

Once the sprayed components have cured they can be packed. Protective low tack high tack tape is applied to any raised or flat surface areas that have been sprayed. All goods and documentation are now ready for dispatch.



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