

This additional HowTO information should be used when painting any powdercoat primed CS FOR DOORS® product.

Top coat procedure for powdercoat primed product

Introduction

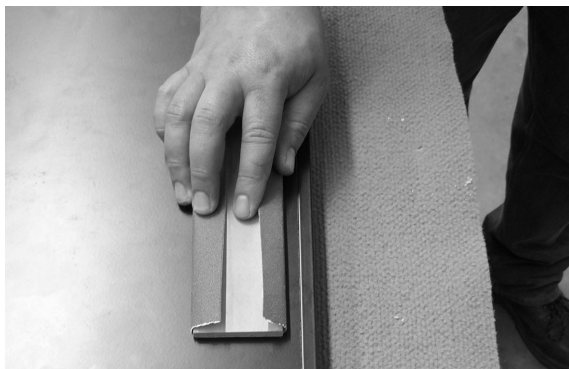
Many pre-finished powdercoated products available from CS FOR DOORS are also available in a primed state ready for top coating on site by a paint professional.

This information sheet contains detailed top coat preparation and application instructions as recommended by the manufacturer of the primer.

By following these instructions you will ensure a high quality finish that matches the product supplied!

Top coating with Dulux X10 or Aquanamel

The powdercoated surface should be given a thorough light sand using silica free P220 grit or similar.



After sanding, follow with a thorough clean using methylated spirits to remove all dust and contaminants.



Follow this preparation when using Dulux Aquanamel

Second and third coat: DULUX Aquanamel Semi Gloss Acrylic Enamel (brush, roller, conventional and airless spray).

Coat	Dry film thickness (microns)	Theoretical spreading rate (m ² /L)*	Recoat**
2nd	min 23	16.1	4 hrs
	max 23	16.1	
3rd	min 23	16.1	4 hrs
	max 23	16.1	

* Practical spreading rate will vary from the quoted theoretical spreading rate due to factors such as method and condition of application and surface roughness.
** Recoat times are quoted for 25°C and 50% relative humidity. These may vary under different conditions.

Follow this preparation when using Dulux Weathershield X10

Second and third coat: DULUX Weathershield X10 Semi Gloss Acrylic (brush, roller, conventional and airless spray).

Coat	Dry film thickness (microns)	Theoretical spreading rate (m ² /L)*	Recoat**
2nd	min 25	16.0	2 hrs
	max 25	16.0	
3rd	min 25	16.0	2 hrs
	max 25	16.0	

* Practical spreading rate will vary from the quoted theoretical spreading rate due to factors such as method and condition of application and surface roughness.
** Recoat times are quoted for 25°C and 50% relative humidity. These may vary under different conditions.

Important: please read

Top coating this primer with paint other than Dulux X10 or Aquanamel is not recommended by the manufacturer of the primer.

Equivalent paints may be used, but consider applying a test patch of top coat before full coverage is attempted.

For more technical information please phone Orica Powder Coatings: 09 441 8244 and quote product code *915 Line Titania Matt Primer*.

Disclaimer: Cavity Sliders Ltd. cannot be held responsible for any failed paint application.