Technical Note 144

Paint Systems for MRTS88

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1 Introduction

This Technical Note provides a selection of paint systems that have successfully applied in the context of Queensland's climate. The state's high heat and humidity present specific challenges for coatings so specialised formulations are often required.

The systems described in this document have been assessed in accordance to Appendix A of MRTS88 Protective Coatings for New Work and may be used to complete Annexure MRTS88.1.

Paint systems which are not outlined in the technical note are not excluded from use, but must be assessed prior to use. If assessment confirms suitability, the system will then be added to this document.

Paint systems for steel and concrete substrate are included. Timber substrate will be included in future updates.

1.1 Paint systems

Paint systems should be selected and specified with a mind to suitability for the precise application intended. The paint systems described in this document are recommended for use but are not guaranteed to be universally suitable.

The paint systems are presented in this document in a structure that corresponds with the Annexure MRTS88.1.

1.2 Paint repair systems

Paint repair systems are required to be nominated by MRTS88 Protective Coating for New Work should repair of the coating be required during initial installation or during future maintenance. These repair systems are specific to the paint system installed.

2 Definitions

WFT – Wet Film Thickness
DFT – Dry Film Thickness
VS – Volume Solids
3 Summary of systems

The paint systems in the table below are described in detail in the next sections of this document.

<table>
<thead>
<tr>
<th>Manufacturer</th>
<th>Substrate</th>
<th>Top Coat</th>
<th>Intermediate Coat</th>
<th>Primer</th>
</tr>
</thead>
<tbody>
<tr>
<td>PPG</td>
<td>Steel</td>
<td>PSX 700</td>
<td>Amerlock 400</td>
<td>SigmaZinc 109HS</td>
</tr>
<tr>
<td>International</td>
<td>Steel</td>
<td>Interfine 878</td>
<td>Interplus 356</td>
<td>Interzinc 52</td>
</tr>
<tr>
<td>International</td>
<td>Steel</td>
<td>Interfine 878</td>
<td>Interplus 356</td>
<td>Interzinc 52</td>
</tr>
<tr>
<td>International</td>
<td>Steel</td>
<td>Interfine 878</td>
<td>Interplus 356</td>
<td>Interzinc 315</td>
</tr>
<tr>
<td>PPG</td>
<td>Steel</td>
<td>SigmaDur 550</td>
<td>SigmaCover 350</td>
<td>SigmaZinc 109HS</td>
</tr>
<tr>
<td>International</td>
<td>Steel</td>
<td>Interthane 870</td>
<td>Interplus 356</td>
<td>Interzinc 52</td>
</tr>
<tr>
<td>Carboline</td>
<td>Steel</td>
<td>Carbothane 134HG</td>
<td>Carbomastic 615</td>
<td>Carbozinc 859 EZ2</td>
</tr>
<tr>
<td>International</td>
<td>Steel</td>
<td>Intercure 99</td>
<td>N/A</td>
<td>Interzinc 52</td>
</tr>
<tr>
<td>Dulux</td>
<td>Steel</td>
<td>Weathermax HBR</td>
<td>Duremax GPE</td>
<td>Zincanode 402</td>
</tr>
<tr>
<td>Zinga</td>
<td>Steel</td>
<td>Zingaceram PU</td>
<td>Zingaceram HS</td>
<td>Zinga</td>
</tr>
<tr>
<td>International</td>
<td>Concrete</td>
<td>Interfine 878</td>
<td>N/A</td>
<td>Interplus 356</td>
</tr>
<tr>
<td>PPG</td>
<td>Concrete</td>
<td>PSX 700</td>
<td>N/A</td>
<td>SigmaCover 350</td>
</tr>
<tr>
<td>International</td>
<td>Concrete</td>
<td>Interfine 870</td>
<td>N/A</td>
<td>Interplus 356</td>
</tr>
<tr>
<td>PPG</td>
<td>Concrete</td>
<td>SigmaDur 550</td>
<td>N/A</td>
<td>SigmaCover 350</td>
</tr>
<tr>
<td>Dulux</td>
<td>Concrete</td>
<td>Weathermax HBR</td>
<td>N/A</td>
<td>Durebilt STE</td>
</tr>
<tr>
<td>Klaas</td>
<td>Concrete</td>
<td>Si-Rex03</td>
<td>Si-Rex03</td>
<td>Si-Prime</td>
</tr>
</tbody>
</table>
4 Steel substrates

4.1 Paint systems

4.1.1 PPG Paint System – Polysiloxane Top Coat

Storage of Paint Requirements and Shelf Life

12 months at 25°C. Subject to re-inspection thereafter. Store in dry, shaded conditions away from sources of heat and ignition.

Substrate Preparation

Abrasive blast corroded steelwork to remove rust and provide Class 2½ finish. If oxidation has occurred between blasting and application of the primer, the surface should be re-blasted to the specified visual standard.

Paint System

<table>
<thead>
<tr>
<th>Coat</th>
<th>Colour</th>
<th>Product</th>
<th>Binder</th>
<th>Thinters</th>
<th>Application Method</th>
<th>Volume Solids %</th>
<th>WFT (Microns)</th>
<th>DFT (Microns)</th>
<th>Over Coat Interval at 25°C</th>
<th>Pot Life at 25°C</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td>Grey</td>
<td>SigmaZinc 109HS</td>
<td>Zinc Rich Epoxy</td>
<td>91-92</td>
<td>Airless Spray, Brush &amp; Air Spray</td>
<td>66</td>
<td>115</td>
<td>75</td>
<td>3 Hours</td>
<td>5 Hours</td>
</tr>
<tr>
<td>2</td>
<td>Black</td>
<td>Amerlock 400</td>
<td>MIO High Solids Epoxy Mastic</td>
<td>#737</td>
<td></td>
<td>85</td>
<td>176</td>
<td>150</td>
<td>16 Hours</td>
<td>6 Hours</td>
</tr>
<tr>
<td>3</td>
<td>Final</td>
<td>PSX 700</td>
<td>Epoxy Siloxane</td>
<td>#140</td>
<td></td>
<td>89</td>
<td>140</td>
<td>125</td>
<td>3 Hours</td>
<td>3 Hours</td>
</tr>
</tbody>
</table>

Total DFT Thickness 350

Etching Process between coats

Clean the down between each coat with thinners to etch the coat before applying the next coat. Allow the thinners to dry before applying the protective coating.
Paint Procedure

1. Abrasive blast corroded steelwork to remove rust and provide Class 2½ finish. If oxidation has occurred between blasting and application of the primer, the surface should be re-blasted to the specified visual standard.

2. Stripe coat all edges, rivets, bolts and intersections with SigmaZinc 109HS.

3. Apply one coat of SigmaZinc 109HS with a dry film thickness of 75 microns.

4. Wait for the SigmaZinc 109HS to achieve the recoat time.

5. Etch previous coat with thinners before applying next coat.

6. Allow the thinners to dry before applying the protective coating.

7. Stripe coat all edges, rivets, bolts and intersections with Amerlock 400.

8. Apply one coat of Amerlock 400 with a dry film thickness of 150 microns.

9. Wait for the Amerlock 400 to achieve the recoat time.

10. Etch previous coat with thinners before applying next coat.

11. Allow the thinners to dry before applying the protective coating.

12. Stripe coat all edges, rivets, bolts and intersections with Ameron PSX 700.

13. Apply one coat of PSX 700 with a dry film thickness of 125 microns.

Paint Application

When applying paint by spray, low pressure and high volume spray systems shall be used, as these systems limit the risk of overspray.

Determination of Wet Film Thickness

The wet film thickness measurements supplied by the paint manufacturer is based on no thinners being added to the paint.

If thinners are added to the paint, then the following formula must be used to determine the wet film thickness.

\[ WFT = DFT \times \frac{100 + \% \text{ thinner added}}{\% \text{ VS}} \]
4.1.2 International Paint System – Polysiloxane Top Coat

Storage of Paint Requirements and Shelf Life

12 months at 25°C. Subject to re-inspection thereafter. Store in dry, shaded conditions away from sources of heat and ignition.

Substrate Preparation

Abrasive blast corroded steelwork to remove rust and provide Class 2½ finish. If oxidation has occurred between blasting and application of the primer, the surface should be re-blasted to the specified visual standard.

Paint System

<table>
<thead>
<tr>
<th>Coat</th>
<th>Colour</th>
<th>Product</th>
<th>Binder</th>
<th>Thinner</th>
<th>Application Method</th>
<th>Volume Solids %</th>
<th>WFT (Microns)</th>
<th>DFT (Microns)</th>
<th>Over Coat Interval at 25°C</th>
<th>Pot Life at 25°C</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td>Grey</td>
<td>Interzinc 52</td>
<td>Polyamide cured epoxy</td>
<td>GTA220</td>
<td>Airless Spray, Brush &amp; Air Spray</td>
<td>59</td>
<td>127</td>
<td>75</td>
<td>3 Hours</td>
<td>5 Hours</td>
</tr>
<tr>
<td>2</td>
<td>Black</td>
<td>Interplus 356</td>
<td>Polyamide adduct cured epoxy</td>
<td>GTA220</td>
<td></td>
<td>70</td>
<td>143</td>
<td>100</td>
<td>4 Hours - 24 Days</td>
<td>2 Hours</td>
</tr>
<tr>
<td>3</td>
<td>Final</td>
<td>Interfine 878</td>
<td>Polysiloxane</td>
<td>GTA007</td>
<td></td>
<td>72</td>
<td>104</td>
<td>75</td>
<td>4 Hours</td>
<td>2 Hours</td>
</tr>
</tbody>
</table>

| Total DFT Thickness | 250 |

Etching Process between coats

Clean the paint down between each coat with thinners to etch the coat before applying the next coat. Allow the thinners to dry before applying the protective coating.
Paint Procedure

1. Abrasive blast corroded steelwork to remove rust and provide Class 2½ finish. If oxidation has occurred between blasting and application of the primer, the surface should be re-blasted to the specified visual standard.

2. Stripe coat all edges, rivets, bolts and intersections with Interzinc 52.

3. Apply one coat of Interzinc 52 with a dry film thickness of 75 microns.

4. Wait for the Interzinc 52 to achieve the recoat time.

5. Etch previous coat with thinners before applying next coat.

6. Allow the thinners to dry before applying the protective coating.

7. Stripe coat all edges, rivets, bolts and intersections with Interplus 356.

8. Apply one coat of Interplus 356 with a dry film thickness of 100 microns.

9. Wait for the Interplus 356 to achieve the recoat time.

10. Etch previous coat with thinners before applying next coat.

11. Allow the thinners to dry before applying the protective coating.

12. Stripe coat all edges, rivets, bolts and intersections with Interfine 878.

13. Apply one coat of Interfine 878 with a dry film thickness of 75 microns.

Paint Application

When applying paint by spray, low pressure and high volume spray systems shall be used, as these systems limit the risk of overspray.

Determination of Wet Film Thickness

The wet film thickness measurements supplied by the paint manufacturer is based on no thinners being added to the paint.

If thinners are added to the paint, then the following formula must be used to determine the wet film thickness.

\[ WFT = DFT \times \left(100 + \% \text{ thinner added}\right) \div \% \text{ VS} \]
4.1.3 **International Paint System – Polysiloxane Top Coat with a Seal Coat**

Note: The coating System outlined below is for structures which have overlapping connections such as riveted members.

**Storage of Paint Requirements and Shelf Life**

12 months at 25°C. Subject to re-inspection thereafter. Store in dry, shaded conditions away from sources of heat and ignition.

**Substrate Preparation**

Abrasive blast corroded steelwork to remove rust and provide Class 2½ finish. If oxidation has occurred between blasting and application of the primer, the surface should be re-blasted to the specified visual standard.

**Paint System**

<table>
<thead>
<tr>
<th>Coat</th>
<th>Colour</th>
<th>Product</th>
<th>Binder</th>
<th>Thinners</th>
<th>Application Method</th>
<th>Volume Solids %</th>
<th>WFT (Microns)</th>
<th>DFT (Microns)</th>
<th>Over Coat Interval at 25°C</th>
<th>Pot Life at 25°C</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td>Grey</td>
<td>Interzinc 52</td>
<td>Polyamide cured epoxy</td>
<td>GTA220</td>
<td>Airless Spray, Brush &amp; Air Spray</td>
<td>59</td>
<td>127</td>
<td>75</td>
<td>3 Hours</td>
<td>5 Hours</td>
</tr>
<tr>
<td>2</td>
<td>Clear</td>
<td>Ceilcote 680M</td>
<td>Polyamide cured epoxy</td>
<td>Ceilcote</td>
<td>Stripe Brush</td>
<td>85</td>
<td>N/A</td>
<td>N/A</td>
<td>5 Hours - 4 Weeks</td>
<td>45 Minutes</td>
</tr>
<tr>
<td>3</td>
<td>Black</td>
<td>Interplus 356</td>
<td>Polyamide adduct cured epoxy</td>
<td>GTA220</td>
<td>Airless Spray, Brush &amp; Air Spray</td>
<td>70</td>
<td>143</td>
<td>100</td>
<td>4 Hours 24 Days</td>
<td>2 Hours</td>
</tr>
<tr>
<td>4</td>
<td>Final</td>
<td>Interfine 878</td>
<td>Polysiloxane</td>
<td>GTA007</td>
<td>Airless Spray, Brush &amp; Air Spray</td>
<td>72</td>
<td>104</td>
<td>75</td>
<td>4 Hours</td>
<td>2 Hours</td>
</tr>
</tbody>
</table>

**Total DFT Thickness 250**
Etching Process between coats

Clean the paint down between each coat with thinners to etch the coat before applying the next coat. Allow the thinners to dry before applying the protective coating.

Paint Procedure

1. Abrasive blast corroded steelwork to remove rust and provide Class 2½ finish. If oxidation has occurred between blasting and application of the primer, the surface should be re-blasted to the specified visual standard.

2. Stripe coat all edges, rivets, bolts and intersections with Interzinc 52.

3. Apply one coat of Interzinc 52 with a dry film thickness of 75 microns.

4. Wait for the Interzinc 52 to achieve the recoat time.

5. Stripe coat all edges, rivets, bolts and intersections with Ceilcote 680M.

6. Wait for the Ceilcote 680M to achieve the recoat time.

7. Etch previous coat with thinners before applying next coat.

8. Allow the thinners to dry before applying the protective coating.

9. Stripe coat all edges, rivets, bolts and intersections with Interplus 356.

10. Apply one coat of Interplus 356 with a dry film thickness of 100 microns.

11. Etch previous coat with thinners before applying next coat.

12. Allow the thinners to dry before applying the protective coating.

13. Stripe coat all edges, rivets, bolts and intersections with Interfine 878.

14. Apply one coat of Interfine 878 with a dry film thickness of 75 microns.

Paint Application

When applying paint by spray, low pressure and high volume spray systems shall be used, as these systems limit the risk of overspray.
Determination of Wet Film Thickness

The wet film thickness measurements supplied by the paint manufacturer is based on no thinners being added to the paint.

If thinners are added to the paint, then the following formula must be used to determine the wet film thickness.

\[ \text{WFT} = DFT \times \left(100 + \% \text{ thinner added}\right) \div \% \text{ VS} \]
4.1.4 International Paint System – Polysiloxane Top Coat

Storage of Paint Requirements and Shelf Life
12 months at 25°C. Subject to re-inspection thereafter. Store in dry, shaded conditions away from sources of heat and ignition.

Substrate Preparation
Abrasive blast corroded steelwork to remove rust and provide Class 2½ finish. If oxidation has occurred between blasting and application of the primer, the surface should be re-blasted to the specified visual standard.

Paint System

<table>
<thead>
<tr>
<th>Coat</th>
<th>Colour</th>
<th>Product</th>
<th>Binder</th>
<th>Thinnens</th>
<th>Application Method</th>
<th>Volume Solids %</th>
<th>WFT (Microns)</th>
<th>DFT (Microns)</th>
<th>Over Coat Interval at 25°C</th>
<th>Pot Life at 25°C</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td>Grey</td>
<td>Interzinc 315</td>
<td>Polyamide cured epoxy</td>
<td>GTA220</td>
<td>Airless Spray, Brush &amp; Air Spray</td>
<td>69</td>
<td>109</td>
<td>75</td>
<td>2 – Ext Hours</td>
<td>2 Hours</td>
</tr>
<tr>
<td>2</td>
<td>Black</td>
<td>Interplus 356</td>
<td>Polyamide adduct cured epoxy</td>
<td>GTA220</td>
<td></td>
<td>70</td>
<td>143</td>
<td>100</td>
<td>4 Hours - 24 Days</td>
<td>2 Hours</td>
</tr>
<tr>
<td>3</td>
<td>Final</td>
<td>Interfine 878</td>
<td>Polysiloxane</td>
<td>GTA007</td>
<td></td>
<td>72</td>
<td>104</td>
<td>75</td>
<td>4 Hours</td>
<td>2 Hours</td>
</tr>
</tbody>
</table>

Total DFT Thickness 250

Etching Process between coats
Clean the paint down between each coat with thinners to etch the coat before applying the next coat. Allow the thinners to dry before applying the protective coating.
Paint Procedure

1. Abrasive blast corroded steelwork to remove rust and provide Class 2½ finish. If oxidation has occurred between blasting and application of the primer, the surface should be re-blasted to the specified visual standard.

2. Stripe coat all edges, rivets, bolts and intersections with Interzinc 315.

3. Apply one coat of Interzinc 315 with a dry film thickness of 75 microns.

4. Wait for the Interzinc 315 to achieve the recoat time.

5. Etch previous coat with thinners before applying next coat.

6. Allow the thinners to dry before applying the protective coating.

7. Stripe coat all edges, rivets, bolts and intersections with Interplus 356.

8. Apply one coat of Interplus 356 with a dry film thickness of 100 microns.

9. Wait for the Interplus 356 to achieve the recoat time.

10. Etch previous coat with thinners before applying next coat.

11. Allow the thinners to dry before applying the protective coating.

12. Stripe coat all edges, rivets, bolts and intersections with Interfine 878.

13. Apply one coat of Interfine 878 with a dry film thickness of 75 microns.

Paint Application

When applying paint by spray, low pressure and high volume spray systems shall be used, as these systems limit the risk of overspray.

Determination of Wet Film Thickness

The wet film thickness measurements supplied by the paint manufacturer is based on no thinners being added to the paint.

If thinners are added to the paint, then the following formula must be used to determine the wet film thickness.

\[ WFT = DFT \times (100 + \% \text{ thinner added}) \div \% \text{ VS} \]
4.1.5 PPG Paint System – Polyurethane Top Coat

Storage of Paint Requirements and Shelf Life
12 months at 25°C. Subject to re-inspection thereafter. Store in dry, shaded conditions away from sources of heat and ignition.

Substrate Preparation
Abrasive blast corroded steelwork to remove rust and provide Class 2½ finish. If oxidation has occurred between blasting and application of the primer, the surface should be re-blasted to the specified visual standard.

Paint System

<table>
<thead>
<tr>
<th>Coat</th>
<th>Colour</th>
<th>Product</th>
<th>Binder</th>
<th>Thinners</th>
<th>Application Method</th>
<th>Volume Solids %</th>
<th>WFT (Microns)</th>
<th>DFT (Microns)</th>
<th>Over Coat Interval at 25°C</th>
<th>Pot Life at 25°C</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td>Grey</td>
<td>SigmaZinc 109HS</td>
<td>Zinc Rich Epoxy</td>
<td>91-92</td>
<td>Airless Spray, Brush &amp; Air Spray</td>
<td>66</td>
<td>115</td>
<td>75</td>
<td>3 Hours</td>
<td>5 Hours</td>
</tr>
<tr>
<td>2</td>
<td>Grey</td>
<td>SigmaCover 350</td>
<td>HS HB Polyamine cured epoxy</td>
<td>91-92</td>
<td>Airless Spray, Brush &amp; Air Spray</td>
<td>72</td>
<td>140</td>
<td>100</td>
<td>5 Hours - 14 Days</td>
<td>2.5 Hours</td>
</tr>
<tr>
<td>3</td>
<td>Final Colour</td>
<td>SigmaDur 550</td>
<td>Polyurethane</td>
<td>21-06</td>
<td>Airless Spray, Brush &amp; Air Spray</td>
<td>55</td>
<td>90</td>
<td>50</td>
<td>5 Hours</td>
<td>4 Hours</td>
</tr>
</tbody>
</table>

Total DFT Thickness 225

Etching Process between coats
Clean the paint down between each coat with thinners to etch the coat before applying the next coat. Allow the thinners to dry before applying the protective coating.
Paint Procedure

1. Abrasive blast corroded steelwork to remove rust and provide Class 2½ finish. If oxidation has occurred between blasting and application of the primer, the surface should be re-blasted to the specified visual standard.
2. Stripe coat all edges, rivets, bolts and intersections with SigmaZinc 109HS.
3. Apply one coat of SigmaZinc 109HS with a dry film thickness of 75 microns.
4. Wait for the Sigmazinc to achieve the recoat time.
5. Etch previous coat with thinners before applying next coat.
6. Allow the thinners to dry before applying the protective coating.
7. Stripe coat all edges, rivets, bolts and intersections with SigmaCover 350
8. Apply one coat of SigmaCover 350 with a dry film thickness of 100 microns.
9. Wait for the SigmaCover 350 to achieve the recoat time.
10. Etch previous coat with thinners before applying next coat.
11. Allow the thinners to dry before applying the protective coating.
12. Stripe coat all edges, rivets, bolts and intersections with SigmaDur 550.
13. Apply one coat of SigmaDur 550 with a dry film thickness of 50 microns.

Paint Application

When applying paint by spray, low pressure and high volume spray systems shall be used, as these systems limit the risk of overspray.

Determination of Wet Film Thickness

The wet film thickness measurements supplied by the paint manufacturer is based on no thinners being added to the paint.

If thinners are added to the paint, then the following formula must be used to determine the wet film thickness.

\[ WFT = DFT \times \left( \frac{100 + \% \text{ thinner added}}{\% \text{ VS}} \right) \]
4.1.6 International Paint System – Polyurethane Top Coat

Storage of Paint Requirements and Shelf Life

12 months at 25°C. Subject to re-inspection thereafter. Store in dry, shaded conditions away from sources of heat and ignition.

Substrate Preparation

Abrasive blast corroded steelwork to remove rust and provide Class 2½ finish. If oxidation has occurred between blasting and application of the primer, the surface should be re-blasted to the specified visual standard.

Paint System

<table>
<thead>
<tr>
<th>Coat</th>
<th>Colour</th>
<th>Product</th>
<th>Binder</th>
<th>Thinners</th>
<th>Application Method</th>
<th>Volume Solids %</th>
<th>WFT (Microns)</th>
<th>DFT (Microns)</th>
<th>Over Coat Interval at 25°C</th>
<th>Pot Life at 25°C</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td>Grey</td>
<td>Interzinc 52</td>
<td>Polyamide cured epoxy</td>
<td>GTA220</td>
<td>Airless Spray, Brush &amp; Air Spray</td>
<td>59</td>
<td>127</td>
<td>75</td>
<td>3 Hours</td>
<td>5 Hours</td>
</tr>
<tr>
<td>2</td>
<td>Black</td>
<td>Interplus 356</td>
<td>Polyamide adduct cured epoxy</td>
<td>GTA220</td>
<td></td>
<td>70</td>
<td>143</td>
<td>100</td>
<td>4 Hours - 24 Days</td>
<td>2 Hours</td>
</tr>
<tr>
<td>3</td>
<td>Final</td>
<td>Interthane 870</td>
<td>Polyurethane</td>
<td>GTA713</td>
<td></td>
<td>56</td>
<td>180</td>
<td>100</td>
<td>4 Hours</td>
<td>2 Hours</td>
</tr>
</tbody>
</table>

Total DFT Thickness 275

Etching Process between coats

Clean the paint down between each coat with thinners to etch the coat before applying the next coat. Allow the thinners to dry before applying the protective coating.
Paint Procedure

1. Abrasive blast corroded steelwork to remove rust and provide Class 2½ finish. If oxidation has occurred between blasting and application of the primer, the surface should be re-blasted to the specified visual standard.

2. Stripe coat all edges, rivets, bolts and intersections with Interzinc 52.

3. Apply one coat of Interzinc 52 with a dry film thickness of 75 microns.

4. Wait for the Interzinc 52 to achieve the recoat time.

5. Etch previous coat with thinners before applying next coat.

6. Allow the thinners to dry before applying the protective coating.

7. Stripe coat all edges, rivets, bolts and intersections with Interplus 356.

8. Apply one coat of Interplus 356 with a dry film thickness of 100 microns.

9. Etch previous coat with thinners before applying next coat.

10. Wait for the Interplus 356 to achieve the recoat time.

11. Allow the thinners to dry before applying the protective coating.

12. Stripe coat all edges, rivets, bolts and intersections with Interthane 870.

13. Apply one coat of Interthane 870 with a dry film thickness of 75 microns.

Paint Application

When applying paint by spray, low pressure and high volume spray systems shall be used, as these systems limit the risk of overspray.

Determination of Wet Film Thickness

The wet film thickness measurements supplied by the paint manufacturer is based on no thinners being added to the paint.

If thinners are added to the paint, then the following formula must be used to determine the wet film thickness.

\[ WFT = DFT \times \frac{100 + \% \text{ thinner added}}{\% \text{ VS}} \]
4.1.7 Carboline Paint System – Polyurethane Top Coat

Storage of Paint Requirements and Shelf Life
12 months at 25°C. Subject to re-inspection thereafter. Store in dry, shaded conditions away from sources of heat and ignition.

Substrate Preparation
Abrasive blast corroded steelwork to remove rust and provide Class 2½ finish. If oxidation has occurred between blasting and application of the primer, the surface should be re-blasted to the specified visual standard.

Paint System

<table>
<thead>
<tr>
<th>Coat</th>
<th>Colour</th>
<th>Product</th>
<th>Binder</th>
<th>Thinners</th>
<th>Application Method</th>
<th>Volume Solids %</th>
<th>WFT (Microns)</th>
<th>DFT (Microns)</th>
<th>Over Coat Interval at 25°C</th>
<th>Pot Life at 25°C</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td>Green</td>
<td>Carbozinc 859 EZ2</td>
<td>Zinc Rich Epoxy</td>
<td>#2</td>
<td>Brush &amp; Spray</td>
<td>70</td>
<td>107</td>
<td>75</td>
<td>90 Minutes - 90 Days</td>
<td>3 Hours</td>
</tr>
<tr>
<td>2</td>
<td>Aluminium</td>
<td>Carbomastic 615</td>
<td>Phenalkamine Epoxy</td>
<td>#2</td>
<td>Airless Spray, Brush &amp; Air Spray</td>
<td>80</td>
<td>250</td>
<td>200</td>
<td>4 Hours - 10 Days</td>
<td>1.5 Hours</td>
</tr>
<tr>
<td>3</td>
<td>Final Colour</td>
<td>Carbothane 134HG</td>
<td>Acrylic epoxy Polyurethane</td>
<td>#25</td>
<td></td>
<td>70</td>
<td>100</td>
<td>70</td>
<td>4 Hours</td>
<td>3 Hours</td>
</tr>
</tbody>
</table>

Total DFT Thickness 345

Etching Process between coats
Clean the paint down between each coat with thinners to etch the coat before applying the next coat. Allow the thinners to dry before applying the protective coating.
Paint Procedure

1. Degrease in accordance with MRTS88 to remove all soluble contamination.
2. Abrasive blast corroded steelwork to remove rust and provide Class 2½ finish. Blast profile should be between 35 µm to 50 µm. If oxidation has occurred between blasting and application of the primer, the surface should be re-blasted to the specified visual standard.
3. Stripe coat all edges, rivets, bolts and intersections with Carbozinc 859.
4. Apply one coat of Carbozinc 859 with a dry film thickness of 75 microns.
5. Wait for the Cabozinc 859 to achieve the recoat time.
6. Clean the coat down with thinners to etch the coating before applying the next coat.
7. Allow the thinners to dry before applying the protective coating.
8. Stripe coat all edges, rivets, bolts and intersections with Carbomastic 615.
9. Apply one coat of Carbomastic 615 with a dry film thickness of 200 microns.
10. Wait for the Carbomastic 615 to achieve the recoat time.
11. Clean the coat down with thinners to etch the coating before applying the next coat.
12. Allow the thinners to dry before applying the protective coating.
13. Stripe coat all edges, rivets, bolts and intersections with Carbothane 134HG
14. Apply one coat of Carbothane 134HG with a dry film thickness of 70 microns.
15. Wait for the Carbothane 134HG to achieve the recoat time.
16. Clean the coat down with thinners to etch the coating before applying the next coat.
17. Allow the thinners to dry before applying the protective coating.
18. Apply part coat of Carbothane 134HG to areas where the coating thickness is low.
**Paint Application**

When applying paint by spray, low pressure and high volume spray systems shall be used, as these systems limit the risk of overspray.

**Determination of Wet Film Thickness**

The wet film thickness measurements supplied by the paint manufacturer is based on no thinners being added to the paint.

If thinners are added to the paint, then the following formula must be used to determine the wet film thickness.

\[ WFT = DFT \times \left(\frac{100 + \% \text{ thinner added}}{\% \text{ VS}}\right) \]
4.1.8 International Paint System – Polyaspartic Top Coat

Storage of Paint Requirements and Shelf Life
12 months at 25°C. Subject to re-inspection thereafter. Store in dry, shaded conditions away from sources of heat and ignition.

Substrate Preparation
Abrasive blast corroded steelwork to remove rust and provide Class 2½ finish. If oxidation has occurred between blasting and application of the primer, the surface should be re-blasted to the specified visual standard.

Paint System

<table>
<thead>
<tr>
<th>Coat</th>
<th>Colour</th>
<th>Product (Binder)</th>
<th>Thinners</th>
<th>Application Method</th>
<th>Volume Solids %</th>
<th>WFT (Microns)</th>
<th>DFT (Microns)</th>
<th>Over Coat Interval at 25°C</th>
<th>Pot Life at 25°C</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td>Grey</td>
<td>Interzinc 52</td>
<td>Polyamide cured epoxy</td>
<td>GTA220</td>
<td>Airless Spray, Brush &amp; Air Spray</td>
<td>59</td>
<td>127</td>
<td>75</td>
<td>3 Hours</td>
</tr>
<tr>
<td>2</td>
<td>Final Colour</td>
<td>Intercure 99</td>
<td>Polyaspartic</td>
<td>GTA713</td>
<td></td>
<td>80</td>
<td>250</td>
<td>225</td>
<td>1.5 Hours</td>
</tr>
</tbody>
</table>

Etching Process between coats
Clean the paint with thinners to etch each coat before applying the next coat. Allow the thinners to dry before applying the protective coating.
Paint Procedure

1. Degrease in accordance with MRTS88 to remove all soluble contamination.
2. Abrasive blast corroded steelwork to remove rust and provide Class 2½ finish. Blast profile should be between 40 µm and 70 µm. If oxidation has occurred between blasting and application of the primer, the surface should be re-blasted to the specified visual standard.
3. Stripe coat all edges, rivets, bolts and intersections with Interzinc 52
4. Apply one coat of Interzinc 52 with a dry film thickness of 75 microns.
5. Wait for the Interzinc 52 to achieve the recoat time.
6. Clean the coat down with thinners to etch the coating before applying the next coat.
7. Stripe coat all edges, rivets, bolts and intersections with Intercure 99.
8. Apply one coat of Intercure 99 with a dry film thickness of 225 microns.

Paint Application

When applying paint by spray, low pressure and high volume spray systems shall be used, as these systems limit the risk of overspray.

Determination of Wet Film Thickness

The wet film thickness measurements supplied by the paint manufacturer is based on no thinners being added to the paint.

If thinners are added to the paint, then the following formula must be used to determine the wet film thickness.

\[ WFT = DFT \times \frac{100 + \% \text{ thinner added}}{\% \text{ VS}} \]
4.1.9 Dulux Paint System – Polyurethane Top Coat

Storage of Paint Requirements and Shelf Life

12 months at 25 °C. Subject to re-inspection thereafter. Store in dry, shaded conditions away from sources of heat and ignition.

Substrate Preparation

Abrasive blast corroded steelwork to remove rust and provide Class 2½ finish. If oxidation has occurred between blasting and application of the primer, the surface should be re-blasted to the specified visual standard.

Paint System

<table>
<thead>
<tr>
<th>Coat</th>
<th>Colour</th>
<th>Product</th>
<th>Binder</th>
<th>Thinners</th>
<th>Application Method</th>
<th>Volume Solids %</th>
<th>WFT (Microns)</th>
<th>DFT (Microns)</th>
<th>Over Coat Interval at 25°C</th>
<th>Pot Life at 25°C</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td>Green / Grey</td>
<td>Zincanode 402</td>
<td>Zinc-rich epoxy</td>
<td>Dulux Epoxy Thinner</td>
<td>Airless Spray, Brush &amp; Air Spray</td>
<td>48</td>
<td>155</td>
<td>75</td>
<td>5 Hours</td>
<td>8 Hours</td>
</tr>
<tr>
<td>2</td>
<td>Grey</td>
<td>Duremax GPE</td>
<td>Polyamine adduct cured epoxy</td>
<td>Dulux Epoxy Thinner</td>
<td></td>
<td>72</td>
<td>280</td>
<td>200</td>
<td>3 Hours – 4 Weeks</td>
<td>90 Minutes</td>
</tr>
<tr>
<td>3</td>
<td>Final Colour</td>
<td>Weathermax HBR</td>
<td>Polyurethane</td>
<td>Duthin 040</td>
<td></td>
<td>70</td>
<td>145</td>
<td>100</td>
<td>10 Hours</td>
<td>2 Hours</td>
</tr>
</tbody>
</table>

Total DFT Thickness 375

Etching Process between coats

Clean the paint with thinners to etch each coat before applying the next coat. Allow the thinners to dry before applying the protective coating.
Paint Procedure

1. Abrasive blast corroded steelwork to remove rust and provide Class 2½ finish. If oxidation has occurred between blasting and application of the primer, the surface should be re-blasted to the specified visual standard.
2. Stripe coat all edges, rivets, bolts and intersections with Zincanode 402.
3. Apply one coat of Zincanode 402 with a dry film thickness of 75 microns.
4. Wait for the Zincanode 402 to achieve the recoat time.
5. Etch previous coat with thinners before applying next coat.
6. Allow the thinners to dry before applying the protective coating.
7. Stripe coat all edges, rivets, bolts and intersections with Duremax GPE.
8. Apply one coat of Duremax GPE with a dry film thickness of 200 microns.
9. Wait for the Duremax GPE to achieve the recoat time.
10. Etch previous coat with thinners before applying next coat.
11. Allow the thinners to dry before applying the protective coating.
12. Stripe coat all edges, rivets, bolts and intersections with Weathermax HBR.
13. Apply one coat of Weathermax HBR with a dry film thickness of 100 microns.

Paint Application

When applying paint by spray, low pressure and high volume spray systems shall be used, as these systems limit the risk of overspray.

Determination of Wet Film Thickness

The wet film thickness measurements supplied by the paint manufacturer is based on no thinners being added to the paint.

If thinners are added to the paint, then the following formula must be used to determine the wet film thickness.

\[ WFT = DFT \times (100 + \% \text{ thinner added}) \div \% \text{ VS} \]
4.1.10 Zinga Paint System – Polyurethane Top Coat

Storage of Paint Requirements and Shelf Life
12 months at 25°C. Subject to re-inspection thereafter. Store in dry, shaded conditions away from sources of heat and ignition.

Substrate Preparation
Round off all sharp edges and corners leaving a 2 mm radius. All areas to be cleaned thoroughly, as required, to remove oil, grease, salts and contamination etc. in accordance to AS 1627.1 2003. All areas to be abrasive blast cleaned to AS 1627.4 Class Sa 2½. (Jagged angular profile of 50 – 70 µm is required). Commence application before the surface preparation quality deteriorates and in any event within 4 hours. If any rust back has occurred between blasting and application of the primer, the surface should be re-blasted to the specified visual standard.

Paint System

<table>
<thead>
<tr>
<th>Coat</th>
<th>Colour</th>
<th>Product</th>
<th>Binder</th>
<th>Thinners</th>
<th>Application Method</th>
<th>Volume Solids %</th>
<th>WFT (Microns)</th>
<th>DFT (Microns)</th>
<th>Over Coat Interval at 25°C</th>
<th>Pot Life at 25°C</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td>Grey</td>
<td>Zinga</td>
<td>Type 2A thermoplastic</td>
<td>ZingaSolv</td>
<td>Airless, Brush, or Air spray</td>
<td>58</td>
<td>103</td>
<td>60</td>
<td>6 h</td>
<td>N/A</td>
</tr>
<tr>
<td>2</td>
<td>Grey</td>
<td>Zingaceram HS</td>
<td>Epoxy</td>
<td>HS Thinner</td>
<td>Airless, Brush, Roller or Air spray</td>
<td>78</td>
<td>154</td>
<td>120</td>
<td>8 h</td>
<td>2.5 h</td>
</tr>
<tr>
<td>3</td>
<td>Final Colour</td>
<td>Zingaceram PU</td>
<td>Hydroxylated acrylic resins combined with aliphatic polyisocyanate</td>
<td>PU Thinner</td>
<td>Airless, Brush, Roller or Air spray</td>
<td>55</td>
<td>145</td>
<td>80</td>
<td>11 h</td>
<td>2.5 h</td>
</tr>
</tbody>
</table>

Total DFT Thickness 260

Etching Process between coats
Inter-coat etching is not required. Pressure washing is necessary if contamination has occurred.
Paint Procedure

1. After preliminary cleaning has been completed abrasive blast steelwork to provide Class Sa 2½ finish.
2. Surfaces shall be clean, dedusted according to the standard ISO 8502-3 (Class 2) and completely free of surface contamination, with no visible surface moisture before painting.
3. Allowable chloride levels must not exceed 40 mg/m².
4. All crevices, welds, bolts, rivets, holes and edges shall be stripe coated by brush.
5. Apply one coat of Zinga with a dry film thickness of 60 μm.
6. Ensure surface is free of contamination before application of intermediate coat. Respect minimum recoat time and ensure all areas have dried to a consistent light grey before application.
7. Apply one coat of Zingaceram HS using mist coat/full coat technique with a total dry film thickness of 120 μm.
8. Ensure surface is free of contamination before application of top coat. Respect minimum recoat time.
9. Apply one coat of Zingaceram PU with a dry film thickness of 80 μm.

The above must be read in conjunction with the Zinga and Zingaceram HS and PU Technical Data Sheets.

Paint Application

Brush, roller, airless or airspray. Refer to Zinga, Zingaceram HS and PU Technical Data Sheets for details.

Determination of Wet Film Thickness

The wet film thickness measurements supplied by the paint manufacturer is based on no thinners being added to the paint.

If thinners are added to the paint, then the following formula must be used to determine the wet film thickness.

\[ \text{WFT} = \text{DFT} \times (100 + \% \ \text{thinner added}) \div \% \ \text{VS} \]
4.2  Paint Repair Systems

4.2.1  PPG Paint Repair System – Polysiloxane Top Coat

Storage of Paint Requirements and Shelf Life
12 months at 25°C. Subject to re-inspection thereafter. Store in dry, shaded conditions away from sources of heat and ignition.

Substrate Preparation
Abrasive blast corroded steelwork to remove rust and provide Class 2½ finish. If oxidation has occurred between blasting and application of the primer, the surface should be re-blasted to the specified visual standard.

Paint System

<table>
<thead>
<tr>
<th>Coat</th>
<th>Colour</th>
<th>Product</th>
<th>Binder</th>
<th>Thinnners</th>
<th>Application Method</th>
<th>Volume Solids %</th>
<th>WFT (Microns)</th>
<th>DFT (Microns)</th>
<th>Over Coat Interval at 25°C</th>
<th>Pot Life at 25°C</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td>Grey</td>
<td>SigmaZinc 109HS</td>
<td>Zinc Rich Epoxy</td>
<td>91-92</td>
<td>Airless Spray, Brush &amp; Air Spray</td>
<td>66</td>
<td>115</td>
<td>75</td>
<td>3 Hours</td>
<td>5 Hours</td>
</tr>
<tr>
<td>2</td>
<td>Final</td>
<td>PSX 700</td>
<td>Epoxy Siloxane</td>
<td>#140</td>
<td></td>
<td>89</td>
<td>140</td>
<td>125</td>
<td>3 Hours</td>
<td>3 Hours</td>
</tr>
</tbody>
</table>

Total DFT Thickness 200

Etching Process between coats
Clean the paint down between each coat with thinners to etch the coat before applying the next coat. Allow the thinners to dry before applying the protective coating.
Paint Procedure

Method 1. Minor damage to topcoat, (i.e. no primer required)

1. All surfaces to be painted shall be cleaned by a degreasing or washing procedure (as per AS 1627.1) to remove all oils, salts, acids or any other contamination that may be present.
2. Sand the entire area smooth with 240 grit paper.
3. Remove sanding dust and then solvent wipe again with 140 Thinner.
4. Mix PSX 700 in accordance with the Product Data Sheet and allow to stand for 10 minutes before use.
5. Apply PSX 700 to achieve the specified dry film thickness using brush, roller or spray.

Method 2. Damage to topcoat and primer with bare metal exposed, (i.e. primer required)

1. All surfaces to be painted shall be cleaned by a degreasing or washing procedure (as per AS 1627.1) to remove all oils, salts, acids or any other contamination that may be present.
2. Corroded or damaged areas: Power Tool Clean in accordance with AS 1627.2 St 3 (min).
3. Any sharp edges shall have a radius of 2 mm diameter minimum. Weld spatter, weld irregularities, burr marks, laminations etc. must be removed.
4. Existing coating to be coated: abrade the entire surface to provide a roughened uniform matt appearance.
5. Feather all edges. Remove all preparation residue. Prepared surfaces shall be primed as soon as practical after preparation and before the surface deteriorates or becomes contaminated.
6. Spot prime prepared corroded areas with the specified primer overlapping existing sound coating by a minimum of 50 mm.
7. Prime and topcoat the total prepared area in accordance with the specification and the respective Product Data Sheets.

Note: Brush/roller application will require multiple coats to achieve the specified DFT requirements.

Paint Application

When applying paint by spray, low pressure and high volume spray systems shall be used, as these systems limit the risk of overspray.
**Determination of Wet Film Thickness**

The wet film thickness measurements supplied by the paint manufacturer is based on no thinners being added to the paint. If thinners are added to the paint, then the following formula must be used to determine the wet film thickness.

\[
WFT = DFT \times \frac{(100 + \% \text{ thinner added})}{\% \text{ VS}}
\]
4.2.2 International Paint Repair System - Polysiloxane Top Coat

Storage of Paint Requirements and Shelf Life

12 months at 25°C. Subject to re-inspection thereafter. Store in dry, shaded conditions away from sources of heat and ignition.

Substrate Preparation

Abrasive blast corroded steelwork to remove rust and provide Class 2½ finish. If oxidation has occurred between blasting and application of the primer, the surface should be re-blasted to the specified visual standard.

Paint System

<table>
<thead>
<tr>
<th>Coat</th>
<th>Colour</th>
<th>Product</th>
<th>Binder</th>
<th>Thinnners</th>
<th>Application Method</th>
<th>Volume Solids %</th>
<th>WFT (Microns)</th>
<th>DFT (Microns)</th>
<th>Over Coat Interval at 25°C</th>
<th>Pot Life at 25°C</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td>Black</td>
<td>Interplus 356</td>
<td>Polyamide adduct cured epoxy</td>
<td>GTA 220</td>
<td>Airless Spray, Brush &amp; Air Spray</td>
<td>70</td>
<td>150</td>
<td>100</td>
<td>4 Hours - 24 Days</td>
<td>2 Hours</td>
</tr>
<tr>
<td>2</td>
<td>Final</td>
<td>Interfine 878</td>
<td>Polysiloxane</td>
<td>GTA 007</td>
<td></td>
<td>72</td>
<td>104</td>
<td>75</td>
<td>4 Hours</td>
<td>2 Hours</td>
</tr>
</tbody>
</table>

Total DFT Thickness 175

Etching Process between coats

Clean the paint down between each coat with thinners to etch the coat before applying the next coat. Allow the thinners to dry before applying the protective coating.
Paint Procedure

1. All surfaces to be painted shall be cleaned by a degreasing or washing procedure (as per AS 1627.1) to remove all oils, salts, acids or any other contamination that may be present.

2. Sand the entire area smooth with 240 grit paper.

3. Remove sanding dust and then solvent wipe again with GTA220 Thinner.

4. Mix Interplus 356 in accordance with the Product Data Sheet and allow to stand for 10 minutes before use.

5. Apply Interplus 356 to achieve the specified dry film thickness using brush, roller or spray.

6. Mix Interfine 878 in accordance with the Product Data Sheet and allow to stand for 10 minutes before use.

7. Apply Interfine 878 to achieve the specified dry film thickness using brush, roller or spray.

Paint Application

When applying paint by spray, low pressure and high volume spray systems shall be used, as these systems limit the risk of overspray.

Determination of Wet Film Thickness

The wet film thickness measurements supplied by the paint manufacturer is based on no thinners being added to the paint.

If thinners are added to the paint, then the following formula must be used to determine the wet film thickness.

\[ WFT = DFT \times \frac{(100 + \% \text{ thinner added})}{\% \text{ VS}} \]
4.2.3 PPG Paint Repair System – Polyurethane Top Coat

Storage of Paint Requirements and Shelf Life

12 months at 25°C. Subject to re-inspection thereafter. Store in dry, shaded conditions away from sources of heat and ignition.

Substrate Preparation

Abrasive blast corroded steelwork to remove rust and provide Class 2½ finish. If oxidation has occurred between blasting and application of the primer, the surface should be re-blasted to the specified visual standard.

Where this is not practical, corroded or damaged areas must be Power Tool Cleaned in accordance with AS 1627.2 St 3 (min).

Paint System

<table>
<thead>
<tr>
<th>Coat</th>
<th>Colour</th>
<th>Product</th>
<th>Binder</th>
<th>Thinners</th>
<th>Application Method</th>
<th>Volume Solids %</th>
<th>WFT (Microns)</th>
<th>DFT (Microns)</th>
<th>Over Coat Interval at 25°C</th>
<th>Pot Life at 25°C</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td>Grey (various)</td>
<td>SigmaCover 350</td>
<td>HS HB Polyamine cured epoxy</td>
<td>91-92</td>
<td>Airless Spray, Brush &amp; Air Spray</td>
<td>72</td>
<td>140</td>
<td>100</td>
<td>5 Hours - 14 Days</td>
<td>2.5 Hours</td>
</tr>
<tr>
<td>2</td>
<td>Final</td>
<td>SigmaDur 550</td>
<td>Polyurethane</td>
<td>21-06</td>
<td></td>
<td>55</td>
<td>90</td>
<td>50</td>
<td>5 Hours</td>
<td>4 Hours</td>
</tr>
</tbody>
</table>

Total DFT Thickness 150

Etching Process between coats

Clean the paint down between each coat with thinners to etch the coat before applying the next coat. Allow the thinners to dry before applying the protective coating.
Paint Procedure

Method 1. Minor damage to topcoat (i.e. no primer required)

1. All surfaces to be painted shall be cleaned by a degreasing or washing procedure (as per AS 1627.1) to remove all oils, salts, acids or any other contamination that may be present.
2. Sand the entire area smooth with 240 grit paper.
3. Remove sanding dust and then solvent wipe again with 140 Thinner.
4. Mix SigmaDur 550 in accordance with the Product Data Sheet and allow to stand for ten minutes before use.
5. Apply SigmaDur 550 to achieve the specified dry film thickness using brush, roller or spray.

Method 2. Damage to topcoat and primer with bare metal exposed (i.e. primer required)

1. All surfaces to be painted shall be cleaned by a degreasing or washing procedure (as per AS 1627.1) to remove all oils, salts, acids or any other contamination that may be present.
2. Corroded or damaged areas: Power Tool Clean in accordance with AS 1627.2 St 3 (min).
3. Existing coating to be coated: Abrade the entire surface to provide a roughened uniform matt appearance.
4. Feather all edges. Remove all preparation residue. Prepared surfaces shall be primed as soon as practical after preparation and before the surface deteriorates or becomes contaminated.
5. Mix SigmaCover 350 in accordance with the Product Data Sheet and allow to stand for ten minutes before use.
6. Spot prime prepared corroded areas with SigmaCover 350 to achieve the specified dry film thickness using brush, roller or spray overlapping existing sound coating by a minimum of 50 mm.
7. Mix SigmaDur 550 in accordance with the Product Data Sheet and allow to stand for ten minutes before use.
8. Apply SigmaDur 550 to achieve the specified dry film thickness using brush, roller or spray to the total prepared area in accordance with the specification and the respective Product Data Sheets.

Note: Brush / roller application will require multiple coats to achieve the specified DFT requirements.
Paint Application

When applying paint by spray, low pressure and high volume spray systems shall be used, as these systems limit the risk of overspray.

Determination of Wet Film Thickness

The wet film thickness measurements supplied by the paint manufacturer is based on no thinners being added to the paint.

If thinners are added to the paint, then the following formula must be used to determine the wet film thickness.

\[ WFT = DFT \times \left(100 + \% \text{ thinner added}\right) \div \% \text{ VS} \]
4.2.4 International Paint Repair System - Polyurethane Top Coat

Storage of Paint Requirements and Shelf Life
12 months at 25°C. Subject to re-inspection thereafter. Store in dry, shaded conditions away from sources of heat and ignition.

Substrate Preparation
Abrasive blast corroded steelwork to remove rust and provide Class 2½ finish. If oxidation has occurred between blasting and application of the primer, the surface should be re-blasted to the specified visual standard.

Paint System

<table>
<thead>
<tr>
<th>Coat</th>
<th>Colour</th>
<th>Product</th>
<th>Binder</th>
<th>Thinners</th>
<th>Application Method</th>
<th>Volume Solids %</th>
<th>WFT (Microns)</th>
<th>DFT (Microns)</th>
<th>Over Coat Interval at 25°C</th>
<th>Pot Life at 25°C</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td>Black</td>
<td>Interplus 356</td>
<td>Polyamide adduct cured epoxy</td>
<td>GTA 220</td>
<td>Airless Spray, Brush &amp; Air Spray</td>
<td>70</td>
<td>150</td>
<td>100</td>
<td>4 Hours - 24 Days</td>
<td>2 Hours</td>
</tr>
<tr>
<td>2</td>
<td>Final</td>
<td>Interthane 870</td>
<td>Polyurethane</td>
<td>GTA 713</td>
<td></td>
<td>56</td>
<td>180</td>
<td>100</td>
<td>4 Hours</td>
<td>2 Hours</td>
</tr>
</tbody>
</table>

Total DFT Thickness 200

Etching Process between coats
Clean the paint down between each coat with thinners to etch the coat before applying the next coat. Allow the thinners to dry before applying the protective coating.
Paint Procedure

1. All surfaces to be painted shall be cleaned by a degreasing or washing procedure (as per AS 1627.1) to remove all oils, salts, acids or any other contamination that may be present.
2. Sand the entire area smooth with 240 grit paper.
3. Remove sanding dust and then solvent wipe again with GTA220 Thinner.
4. Mix Interplus 356 in accordance with the Product Data Sheet and allow to stand for ten minutes before use.
5. Apply Interplus 356 to achieve the specified dry film thickness using brush, roller or spray.
6. Mix Interthane 870 in accordance with the Product Data Sheet and allow to stand for ten minutes before use.
7. Apply Interthane 870 to achieve the specified dry film thickness using brush, roller or spray.

Paint Application

When applying paint by spray, low pressure and high volume spray systems shall be used, as these systems limit the risk of overspray.

Determination of Wet Film Thickness

The wet film thickness measurements supplied by the paint manufacturer is based on no thinners being added to the paint.

If thinners are added to the paint, then the following formula must be used to determine the wet film thickness.

\[
WFT = DFT \times \frac{(100 + \% \text{ thinner added})}{\% \text{ VS}}
\]
4.2.5 Carboline Paint Repair System – Polyurethane Top Coat

Storage of Paint Requirements and Shelf Life

12 months at 25°C. Subject to re-inspection thereafter. Store in dry, shaded conditions away from sources of heat and ignition.

Substrate Preparation

Abrasive blast corroded steelwork to remove rust and provide Class 3 finish. If oxidation has occurred between blasting and application of the primer, the surface should be re-blasted to the specified visual standard.

Paint System

<table>
<thead>
<tr>
<th>Coat</th>
<th>Colour</th>
<th>Product</th>
<th>Binder</th>
<th>Thinner</th>
<th>Application Method</th>
<th>Volume Solids %</th>
<th>WFT (Microns)</th>
<th>DFT (Microns)</th>
<th>Over Coat Interval at 25°C</th>
<th>Pot Life at 25°C</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td>Green</td>
<td>Carbozinc 859 EZ2</td>
<td>Zinc eich epoxy</td>
<td>#2</td>
<td>Brush &amp; Spray</td>
<td>70</td>
<td>107</td>
<td>75</td>
<td>90 Minutes – 90 Days</td>
<td>3 Hours</td>
</tr>
<tr>
<td>2</td>
<td>Aluminium</td>
<td>Carbomastic 615</td>
<td>Phenalkamine epoxy</td>
<td>#2</td>
<td>Airless Spray, Brush &amp; Air Spray</td>
<td>80</td>
<td>250</td>
<td>200</td>
<td>4 Hours – 10 Days</td>
<td>1.5 Hours</td>
</tr>
<tr>
<td>3</td>
<td>Final</td>
<td>Carbothane 134HG</td>
<td>Acrylic epoxy polyurethane</td>
<td>#25</td>
<td></td>
<td>70</td>
<td>100</td>
<td>70</td>
<td>4 Hours</td>
<td>3 Hours</td>
</tr>
</tbody>
</table>

Total DFT Thickness 345

Etching Process between coats

Clean the paint down between each coat with thinners to etch the coat before applying the next coat. Allow the thinners to dry before applying the protective coating.
Paint Procedure

1. Degrease in accordance with MRTS88 to remove all soluble contamination.
2. Power tool clean the corroded or damaged area to provide Class 3 finish.
3. Feather back the edges to existing sound paint.
4. Spot prime with Carbozinc 859 with a dry film thickness of 75 microns.
5. Clean the coat down with thinners to etch the coating before applying the next coat.
6. Allow the thinners to dry before applying the protective coating.
7. Spot prime with Carbomastic 615 with a dry film thickness of 200 microns progressively lapping over original paint.
8. Clean the coat down with thinners to etch the coating before applying the next coat.
9. Allow the thinners to dry before applying the protective coating.
10. Spot paint with Carbothane 134HG with a dry film thickness of 70 microns progressively lapping over original paint.

Paint Application

When applying paint by spray, low pressure and high volume spray systems shall be used, as these systems limit the risk of overspray.

Determination of Wet Film Thickness

The wet film thickness measurements supplied by the paint manufacturer is based on no thinners being added to the paint.

If thinners are added to the paint, then the following formula must be used to determine the wet film thickness.

\[ WFT = DFT \times \left(100 + \% \text{ thinner added}\right) \div \% \text{ VS} \]
4.2.6 International Paint Repair System - Polyaspartic Top Coat

Storage of Paint Requirements and Shelf Life

12 months at 25°C. Subject to re-inspection thereafter. Store in dry, shaded conditions away from sources of heat and ignition.

Substrate Preparation

Abrasive blast corroded steelwork to remove rust and provide Class 2½ finish. If oxidation has occurred between blasting and application of the primer, the surface should be re-blasted to the specified visual standard.

Paint System

<table>
<thead>
<tr>
<th>Coat</th>
<th>Colour</th>
<th>Product</th>
<th>Binder</th>
<th>Thinner</th>
<th>Application Method</th>
<th>Volume Solids %</th>
<th>WFT (Microns)</th>
<th>DFT (Microns)</th>
<th>Over Coat Interval at 25°C</th>
<th>Pot Life at 25°C</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td>Grey</td>
<td>Interzinc 52</td>
<td>Zinc rich epoxy</td>
<td>GTA 220</td>
<td>Airless Spray, Brush &amp; Air Spray</td>
<td>59</td>
<td>127</td>
<td>75</td>
<td>3 Hours</td>
<td>5 Hours</td>
</tr>
<tr>
<td>2</td>
<td>Final</td>
<td>Intercur 99</td>
<td>Polyaspartic epoxy</td>
<td>GTA 713</td>
<td>Airless Spray &amp; Air Spray</td>
<td>80</td>
<td>250</td>
<td>225</td>
<td>1.5 Hours</td>
<td>45 Minutes</td>
</tr>
</tbody>
</table>

| Total DFT Thickness | 300 |

Etching Process between coats

Clean the paint with thinners to etch each coat before applying the next coat. Allow the thinners to dry before applying the protective coating.
Paint Procedure

1. Degrease in accordance with MRTS88 to remove all soluble contamination.
2. Power tool clean the corroded or damaged area to provide Class 3 finish.
3. Feather back the edges to existing sound paint.
4. Spot prime with Interzinc 52 with a dry film thickness of 75 microns.
5. Clean the coat down with thinners to etch the coating before applying the next coat.
6. Spot repair with Intercure 99 with a dry film thickness of 225 microns progressively lapping over original paint.

Paint Application

When applying paint by spray, low pressure and high volume spray systems shall be used, as these systems limit the risk of overspray.

Determination of Wet Film Thickness

The wet film thickness measurements supplied by the paint manufacturer is based on no thinners being added to the paint.

If thinners are added to the paint, then the following formula must be used to determine the wet film thickness.

\[ WFT = DFT \times \left(100 + \% \text{ thinner added}\right) \div \% \text{ VS} \]
4.2.7 Dulux Paint Repair System – Polyurethane Top Coat

Storage of Paint Requirements and Shelf Life
12 months at 25°C. Subject to re-inspection thereafter. Store in dry, shaded conditions away from sources of heat and ignition.

Substrate Preparation
Abrasive blast corroded steelwork to remove rust and provide Class 2½ finish. If oxidation has occurred between blasting and application of the primer, the surface should be re-blasted to the specified visual standard.

Paint System

<table>
<thead>
<tr>
<th>Coat</th>
<th>Colour</th>
<th>Product</th>
<th>Binder</th>
<th>Thinners</th>
<th>Application Method</th>
<th>Volume Solids %</th>
<th>WFT (Microns)</th>
<th>DFT (Microns)</th>
<th>Over Coat Interval at 25°C</th>
<th>Pot Life at 25°C</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td>Green / Grey</td>
<td>Zincanode 402</td>
<td>Zinc-rich epoxy</td>
<td>Dulux Epoxy Thinner</td>
<td>Airless Spray, Brush &amp; Air Spray</td>
<td>48</td>
<td>155</td>
<td>75</td>
<td>5 Hours</td>
<td>8 Hours</td>
</tr>
<tr>
<td>2</td>
<td>Grey</td>
<td>Duremax GPE</td>
<td>Polyamine adduct cured epoxy</td>
<td>Dulux Epoxy Thinner</td>
<td></td>
<td>72</td>
<td>280</td>
<td>200</td>
<td>3 Hours – 4 Weeks</td>
<td>90 Minutes</td>
</tr>
<tr>
<td>3</td>
<td>Final Colour</td>
<td>Weathermax HBR</td>
<td>Polyurethane</td>
<td>Duthin 040</td>
<td></td>
<td>70</td>
<td>145</td>
<td>100</td>
<td>10 Hours</td>
<td>2 Hours</td>
</tr>
</tbody>
</table>

**Total DFT Thickness 375**

Etching Process between coats
Clean the paint with thinners to etch each coat before applying the next coat. Allow the thinners to dry before applying the protective coating.
Paint Procedure

Method 1. Minor damage to topcoat (i.e. no primer required)

1. All surfaces to be painted shall be cleaned by a degreasing or washing procedure (as per AS 1627.1) to remove all oils, salts, acids or any other contamination that may be present.
2. Sand the entire area smooth with 240 grit paper.
3. Remove sanding dust and then solvent wipe again with Dulux Polyurethane Thinner.
4. Apply Weathermax HBR to achieve the specified dry film thickness using brush, roller or spray

Method 2. Damage to topcoat and primer with bare metal exposed (i.e. primer required)

1. All surfaces to be painted shall be cleaned by a degreasing or washing procedure (as per AS 1627.1) to remove all oils, salts, acids or any other contamination that may be present.
2. Corroded or damaged areas: Power Tool Clean in accordance with AS 1627.2 St 3 (min).
3. Remove sanding dust and then solvent wipe again with Dulux Epoxy Thinner.
4. Apply Zincanode 402 to bare substrate to achieve the specified dry film thickness of 75 microns using brush roller or spray.
5. Apply Duremax GPE to achieve the specified dry film thickness of 200 microns using brush roller or spray.
6. Apply Weathermax HBR to achieve the specified dry film thickness of 200 microns using brush roller or spray.

Note: Brush/roller application will require multiple coats to achieve the specified DFT requirements.

Paint Application

When applying paint by spray, low pressure and high volume spray systems shall be used, as these systems limit the risk of overspray.

Determination of Wet Film Thickness

The wet film thickness measurements supplied by the paint manufacturer is based on no thinners being added to the paint.

If thinners are added to the paint, then the following formula must be used to determine the wet film thickness.

\[ WFT = DFT \times \frac{100 + \% \text{ thinner added}}{\% \text{ VS}} \]
4.2.8 Zinga Paint Repair System – Polyurethane Top Coat

Storage of Paint Requirements and Shelf Life

12 months at 25°C. Subject to re-inspection thereafter. Store in dry, shaded conditions away from sources of heat and ignition.

Substrate Preparation

Refer to step-by-step procedure below.

<table>
<thead>
<tr>
<th>Paint System</th>
</tr>
</thead>
<tbody>
<tr>
<td><strong>Coat</strong></td>
</tr>
<tr>
<td>1</td>
</tr>
<tr>
<td>2</td>
</tr>
<tr>
<td>3</td>
</tr>
<tr>
<td><strong>Total DFT Thickness</strong></td>
</tr>
</tbody>
</table>

Etching Process between coats

Inter-coat etching is not required. Pressure washing is necessary if contamination has occurred.
Paint Procedure

Method 1. Minor damage to topcoat, (i.e. no primer or intermediate coats required)

1. All surfaces to be painted shall be cleaned by degreasing or washing procedure (as per AS 1627.1) to remove all oils, grease, salts and any other contamination that may be present. This shall include an overlap area onto the sound existing coating. 50 mm is desirable.
2. Feather back any edges if present with 240 grit paper.
3. Remove sanding dust.
4. Apply Zingaceram PU to achieve the specified dry film thickness.

Method 2. Damage to topcoats with bare metal exposed, (i.e. primer required)

1. All surfaces to be painted shall be cleaned by a degreasing or washing procedure (as per AS 1627.1) to remove all oils, grease, salts or any other contamination that may be present.
2. Corroded or damaged areas: Power Tool Clean in accordance with AS 1627.2 St 3 (min).
3. Any edges shall have a radius of 2 mm minimum. Weld spatter, weld irregularities, burr marks, laminations etc. must be removed.
4. Surfaces shall be clean, dedusted according to the standard ISO 8502-3 (Class 2) and completely free of surface contamination, with no visible surface moisture before painting. Allowable chloride levels must not exceed 40 mg/m².
5. Commence primer application before the surface preparation quality deteriorates and in any event within 4 hours.
6. Apply one coat of Zinga with a dry film thickness of 60 μm to prepared areas overlapping existing sound primer coat by a minimum of 50 mm.
7. Ensure surface is free of contamination before application of intermediate coat. Respect minimum recoat time and ensure all areas have dried to a consistent light grey before application.
8. Apply one coat of Zingaceram HS using mist coat/full coat technique with a total dry film thickness of 120 μm to primed areas overlapping existing sound top coat by a minimum of 50 mm.
9. Ensure surface is free of contamination before application of top coat. Respect minimum recoat time.
10. Apply one coat of Zingaceram PU with a total dry film thickness of 80 μm to primed areas overlapping existing sound top coat by a minimum of 50 mm.
The above must be read in conjunction with the Zinga and Zingaceram HS and PU Technical Data Sheets.

Paint Application
Brush, roller, airless or airspray. Refer to Zinga, Zingaceram HS and PU Technical Data Sheets for details.

Determination of Wet Film Thickness
The wet film thickness measurements supplied by the paint manufacturer is based on no thinners being added to the paint.

If thinners are added to the paint, then the following formula must be used to determine the wet film thickness.

\[ WFT = DFT \times \left( \frac{100 + \% \text{ thinner added}}{\% \text{ VS}} \right) \]
5 Concrete substrates

5.1 Paint system

5.1.1 International Paint System - Polysiloxane Top Coat

Storage of Paint Requirements and Shelf Life

12 months at 25°C. Subject to re-inspection thereafter. Store in dry, shaded conditions away from sources of heat and ignition.

Substrate Preparation

Repair the concrete surface and allow concrete repair mortar to cure for three days.

Paint System

<table>
<thead>
<tr>
<th>Coat</th>
<th>Colour</th>
<th>Product</th>
<th>Binder</th>
<th>Thinnners</th>
<th>Application Method</th>
<th>Volume Solids %</th>
<th>WFT (Microns)</th>
<th>DFT (Microns)</th>
<th>Over Coat Interval at 25°C</th>
<th>Pot Life at 25°C</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td>Black</td>
<td>Interplus 356</td>
<td>Polyamide adduct cured epoxy</td>
<td>GTA 220</td>
<td>Airless Spray, Brush &amp; Air Spray</td>
<td>70</td>
<td>150</td>
<td>100</td>
<td>4 Hours - 24 Days</td>
<td>2 Hours</td>
</tr>
<tr>
<td>2</td>
<td>Final</td>
<td>Interfine 878</td>
<td>Polysiloxane</td>
<td>GTA 007</td>
<td></td>
<td>72</td>
<td>104</td>
<td>75</td>
<td>4 Hours</td>
<td>2 Hours</td>
</tr>
</tbody>
</table>

Total DFT Thickness 175

Etching Process between coats

Clean the paint down between each coat with thinners to etch the coat before applying the next coat. Allow the thinners to dry before applying the protective coating.
Paint Procedure

1. Repair of damaged concrete areas with Intercrete 4801, as per manufacturer’s recommendations.
2. Allow the repair mortar to cure for three days.
3. Apply one coat of Interplus 356 with a dry film thickness of 100 microns.
4. Etch previous coat with thinners before applying next coat.
5. Apply one coat of Interfine 878 with a dry film thickness of 75 microns.

Paint Application

When applying paint by spray, low pressure and high volume spray systems shall be used, as these systems limit the risk of overspray.

Determination of Wet Film Thickness

The wet film thickness measurements supplied by the paint manufacturer is based on no thinners being added to the paint.

If thinners are added to the paint, then the following formula must be used to determine the wet film thickness.

\[ WFT = DFT \times \left(100 + \% \text{ thinner added}\right) \div \% \text{ VS} \]
5.1.2 PPG Paint System - Polysiloxane Top Coat

Storage of Paint Requirements and Shelf Life
12 months at 25°C. Subject to re-inspection thereafter. Store in dry, shaded conditions away from sources of heat and ignition.

Substrate Preparation
Repair the concrete surface and allow concrete repair mortar to cure for three days.

Paint System

<table>
<thead>
<tr>
<th>Coat</th>
<th>Colour</th>
<th>Product</th>
<th>Binder</th>
<th>Thinners</th>
<th>Application Method</th>
<th>Volume Solids %</th>
<th>WFT (Microns)</th>
<th>DFT (Microns)</th>
<th>Over Coat Interval at 25°C</th>
<th>Pot Life at 25°C</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td>Grey</td>
<td>SigmaCover 350</td>
<td>HS HB Polyamine cured epoxy</td>
<td>91-92</td>
<td>Airless Spray, Brush &amp; Air Spray</td>
<td>72</td>
<td>140</td>
<td>100</td>
<td>5 Hours – 14 Days</td>
<td>2.5 Hours</td>
</tr>
<tr>
<td>2</td>
<td>Final</td>
<td>PSX 700</td>
<td>Epoxy Siloxane</td>
<td>#140</td>
<td></td>
<td>89</td>
<td>140</td>
<td>125</td>
<td>3 Hours</td>
<td>3 Hours</td>
</tr>
</tbody>
</table>

Total DFT Thickness 225

Etching Process between coats
Clean the paint down between each coat with thinners to etch the coat before applying the next coat. Allow the thinners to dry before applying the protective coating.
Paint Procedure

1. Repair of damaged concrete areas with proprietary filler as per manufacturer’s recommendations.
2. Allow the repair mortar to cure for three days.
3. Apply one coat of SigmaCover 350 with a dry film thickness of 100 microns.
4. Etch previous coat with thinners before applying next coat.
5. Apply one coat of PSX700 with a dry film thickness of 125 microns.

Paint Application

When applying paint by spray, low pressure and high volume spray systems shall be used, as these systems limit the risk of overspray.

Determination of Wet Film Thickness

The wet film thickness measurements supplied by the paint manufacturer is based on no thinners being added to the paint.

If thinners are added to the paint, then the following formula must be used to determine the wet film thickness.

\[ WFT = DFT \times (100 + \% \text{ thinner added}) \div \% \text{ VS} \]
5.1.3 International Paint System – Polyurethane Top Coat

Storage of Paint Requirements and Shelf Life
12 months at 25°C. Subject to re-inspection thereafter. Store in dry, shaded conditions away from sources of heat and ignition.

Substrate Preparation
Repair the concrete surface and allow concrete repair mortar to cure for three days.

Paint System

<table>
<thead>
<tr>
<th>Coat</th>
<th>Colour</th>
<th>Product</th>
<th>Binder</th>
<th>Thinners</th>
<th>Application Method</th>
<th>Volume Solids %</th>
<th>WFT (Microns)</th>
<th>DFT (Microns)</th>
<th>Over Coat Interval at 25°C</th>
<th>Pot Life at 25°C</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td>Black</td>
<td>Interplus 356</td>
<td>Polyamide adduct cured epoxy</td>
<td>GTA 220</td>
<td>Airless Spray, Brush &amp; Air Spray</td>
<td>70</td>
<td>150</td>
<td>100</td>
<td>4 Hours - 24 Days</td>
<td>2 Hours</td>
</tr>
<tr>
<td>2</td>
<td>Final</td>
<td>Interthane 870</td>
<td>Polyurethane</td>
<td>GTA 713</td>
<td></td>
<td>56</td>
<td>180</td>
<td>100</td>
<td>4 Hours</td>
<td>2 Hours</td>
</tr>
</tbody>
</table>

|   | Total DFT Thickness | 200 |

Etching Process between coats
Clean the paint down between each coat with thinners to etch the coat before applying the next coat. Allow the thinners to dry before applying the protective coating.
Paint Procedure

1. Repair of damaged concrete areas with Intercrete 4801, as per manufacturer’s recommendations.
2. Allow the repair mortar to cure for three days.
3. Apply one coat of Interplus 356 with a dry film thickness of 100 microns.
4. Etch previous coat with thinners before applying next coat.
5. Apply one coat of Interthane 870 with a dry film thickness of 100 microns.

Paint Application

When applying paint by spray, low pressure and high volume spray systems shall be used, as these systems limit the risk of overspray.

Determinant of Wet Film Thickness

The wet film thickness measurements supplied by the paint manufacturer is based on no thinners being added to the paint.

If thinners are added to the paint, then the following formula must be used to determine the wet film thickness.

\[ WFT = DFT \times \left(100 + \% \text{ thinner added}\right) \div \% \text{ VS} \]
5.1.4 PPG Paint System – Polyurethane Top Coat

Storage of Paint Requirements and Shelf Life

12 months at 25°C. Subject to re-inspection thereafter. Store in dry, shaded conditions away from sources of heat and ignition.

Substrate Preparation

Repair the concrete surface and allow concrete repair mortar to cure for three days.

Paint System

<table>
<thead>
<tr>
<th>Coat</th>
<th>Colour</th>
<th>Product</th>
<th>Binder</th>
<th>Thinner</th>
<th>Application Method</th>
<th>Volume Solids %</th>
<th>WFT (Microns)</th>
<th>DFT (Microns)</th>
<th>Over Coat Interval at 25°C</th>
<th>Pot Life at 25°C</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td>Grey</td>
<td>SigmaCover 350</td>
<td>HS HB Polyamine cured epoxy</td>
<td>91-92</td>
<td>Airless Spray, Brush &amp; Air Spray</td>
<td>72</td>
<td>140</td>
<td>100</td>
<td>5 hours – 14 Days</td>
<td>2.5 Hours</td>
</tr>
<tr>
<td>2</td>
<td>Final</td>
<td>SigmaDur 550</td>
<td>Polyurethane</td>
<td>21-06</td>
<td></td>
<td>55</td>
<td>90</td>
<td>50</td>
<td>5 Hours</td>
<td>4 Hours</td>
</tr>
</tbody>
</table>

Total DFT Thickness 150

Etching Process between coats

Clean the paint down between each coat with thinners to etch the coat before applying the next coat. Allow the thinners to dry before applying the protective coating.
Paint Procedure

1. Repair of damaged concrete areas with proprietary filler as per manufacturer’s recommendations.
2. Allow the repair mortar to cure for three days.
3. Apply one coat of SigmaCover 350 with a dry film thickness of 100 microns.
4. Etch previous coat with thinners before applying next coat.
5. Apply one coat of SigmaDur 550 with a dry film thickness of 50 microns.

Paint Application

When applying paint by spray, low pressure and high volume spray systems shall be used, as these systems limit the risk of overspray.

Determination of Wet Film Thickness

The wet film thickness measurements supplied by the paint manufacturer is based on no thinners being added to the paint.

If thinners are added to the paint, then the following formula must be used to determine the wet film thickness.

\[ WFT = DFT \times \left(100 + \% \text{ thinner added}\right) \div \% \text{ VS} \]
5.1.5 Dulux Paint System – Polyurethane Top Coat

**Storage of Paint Requirements and Shelf Life**

12 months at 25°C. Subject to re-inspection thereafter. Store in dry, shaded conditions away from sources of heat and ignition.

**Substrate Preparation**

Repair the concrete surface and allow concrete repair mortar to cure for three days.

**Paint System**

<table>
<thead>
<tr>
<th>Coat</th>
<th>Colour</th>
<th>Product</th>
<th>Binder</th>
<th>Thinnings</th>
<th>Application Method</th>
<th>Volume Solids %</th>
<th>WFT (Microns)</th>
<th>DFT (Microns)</th>
<th>Over Coat Interval at 25°C</th>
<th>Pot Life at 25°C</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td>Grey</td>
<td>Durebild STE</td>
<td>Polyamine cured epoxy</td>
<td>Dulux epoxy thinner</td>
<td>Airless Spray, Brush &amp; Air Spray</td>
<td>84</td>
<td>175</td>
<td>125</td>
<td>9 Hours – 4 Weeks</td>
<td>90 Minutes</td>
</tr>
<tr>
<td>2</td>
<td>Final</td>
<td>Weathermax HBR</td>
<td>Polyurethane</td>
<td>Duthin 040</td>
<td>70</td>
<td>145</td>
<td>100</td>
<td>10 Hours</td>
<td>2 Hours</td>
<td></td>
</tr>
</tbody>
</table>

**Etching Process between coats**

Clean the paint down between each coat with thinners to etch the coat before applying the next coat. Allow the thinners to dry before applying the protective coating.
Paint Procedure

1. All surfaces to be painted shall be cleaned by a degreasing or washing procedure (as per AS 1627.1) to remove oils, salts, acids or any other contamination the may be present.
2. Sand the entire area smooth with 240 grit paper.
3. Remove sanding dust and then solvent wipe again with Dulux Epoxy Thinner.
4. Mix Durebild STE in accordance with the Product Data Sheet and allow to stand for ten minutes before use.
5. Apply Durebild STE to achieve the specified dry film thickness of 125 microns using brush, roller or spray.
6. Mix Weathermax HBR in accordance with the Product Data Sheet and allow to stand for ten minutes before use.
7. Apply Weathermax HBR to achieve the specified dry film thickness of 100 microns using brush, roller or spray.

Paint Application

When applying paint by spray, low pressure and high volume spray systems shall be used, as these systems limit the risk of overspray.

Determination of Wet Film Thickness

The wet film thickness measurements supplied by the paint manufacturer is based on no thinners being added to the paint.

If thinners are added to the paint, then the following formula must be used to determine the wet film thickness.

\[
WFT = DFT \times (100 + \% \text{ thinner added}) \div \% \text{ VS}
\]
5.1.6 Klaas Coatings Paint System – Silicone Resin Top Coat

Storage of Paint Requirements and Shelf Life
Store in dry, shaded conditions away from sources of heat and ignition. Shelf life is two years.

Substrate Preparation
Pressure wash - remove any form release oil or efflorescence prior to application. Panels must be surface dry. Panel surface must be cohesive, free of dust, oil, grease or other contaminants.

Concrete panels must be older than 14 days. Panels less than 28 days require Si-Prime.

Paint System

<table>
<thead>
<tr>
<th>Coat</th>
<th>Colour</th>
<th>Product</th>
<th>Binder</th>
<th>Thinnners</th>
<th>Application Method</th>
<th>Volume Solids %</th>
<th>WFT (Microns)</th>
<th>DFT (Microns)</th>
<th>Over Coat Interval at 25°C</th>
<th>Pot Life at 25°C</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td>Clear</td>
<td>Si-Prime</td>
<td>Silane/ Siloxane/ Acrylic</td>
<td>Water</td>
<td>Spray/Brush/Roll</td>
<td>10</td>
<td>120</td>
<td>-</td>
<td>6 Hours</td>
<td>n/a</td>
</tr>
<tr>
<td>2</td>
<td>Final</td>
<td>Si-Rex03</td>
<td>Silicone Resin</td>
<td>Water</td>
<td></td>
<td>36</td>
<td>120</td>
<td>43</td>
<td>touch dry + 1 Hour</td>
<td>n/a</td>
</tr>
<tr>
<td>3</td>
<td>Final</td>
<td>Si-Rex03</td>
<td>Silicone Resin</td>
<td>Water</td>
<td></td>
<td>36</td>
<td>120</td>
<td>43</td>
<td>touch dry + 1 Hour</td>
<td>n/a</td>
</tr>
</tbody>
</table>

Total DFT Thickness 86

Etching Process between coats
Not required.
Paint Procedure

1. Confirm age of panels to receive application*.
2. Thoroughly mix paint.
3. Check colour is correct.
4. Check no rain is expected / forecast on day of application.
5. Confirm surface preparation is complete.
6. Ensure temperature and dew point is within parameters.
7. Determine surface area to required volume calculation.
8. Ensure all water / line preservative is removed from lines / tips (when spraying).
9. Spray / roll at required rate.
10. Confirm WFT at regular intervals to ensure required application rate.
11. Ensure material is 100% touch dry before second coat. Generally 15 minutes at 25°C and 50 RH when spraying or two hours post touch dry when rolling.
12. Spray in opposite direction to first coat.
13. Confirm WFT at regular intervals to ensure required application rate.
14. Clean up tools with water.

*Where panels are older than 14 days but younger than 28 days Si-Prime is required to be applied according to specification.

Paint Application

Airless spray or roll at 8 m²/L per coat to achieve 120 μm WFT. Two coats required.

Determination of Wet Film Thickness

The wet film thickness measurements supplied by the paint manufacturer is based on no thinners being added to the paint.
If thinners are added to the paint, then the following formula must be used to determine the wet film thickness.

\[
WFT = DFT \times \frac{100 + \% \text{ thinner added}}{\% \text{ VS}}
\]
5.2 **Paint Repair System**

5.2.1 **International Paint Repair System - Polysiloxane Top Coat**

**Storage of Paint Requirements and Shelf Life**

12 months at 25°C. Subject to re-inspection thereafter. Store in dry, shaded conditions away from sources of heat and ignition.

**Substrate Preparation**

Repair the concrete surface and allow concrete repair mortar to cure for three days.

**Paint System**

<table>
<thead>
<tr>
<th>Coat</th>
<th>Colour</th>
<th>Product</th>
<th>Binder</th>
<th>Thinners</th>
<th>Application Method</th>
<th>Volume Solids %</th>
<th>WFT (Microns)</th>
<th>DFT (Microns)</th>
<th>Over Coat Interval at 25°C</th>
<th>Pot Life at 25°C</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td>Black</td>
<td>Interplus 356</td>
<td>Polyamide adduct cured epoxy</td>
<td>GTA 220</td>
<td>Airless Spray, Brush &amp; Air Spray</td>
<td>70</td>
<td>150</td>
<td>100</td>
<td>4 Hours - 24 Days</td>
<td>2 Hours</td>
</tr>
<tr>
<td>2</td>
<td>Final</td>
<td>Interfine 878</td>
<td>Polysiloxane</td>
<td>GTA 007</td>
<td></td>
<td>72</td>
<td>104</td>
<td>75</td>
<td>4 Hours</td>
<td>2 Hours</td>
</tr>
</tbody>
</table>

**Total DFT Thickness**

175

**Etching Process between coats**

Clean the paint down between each coat with thinners to etch the coat before applying the next coat. Allow the thinners to dry before applying the protective coating.
Paint Procedure

1. All surfaces to be painted shall be cleaned by a degreasing or washing procedure (as per AS 1627.1) to remove all oils, salts, acids or any other contamination that may be present.

2. Sand the entire area smooth with 240 grit paper.

3. Remove sanding dust and then solvent wipe again with GTA220 Thinner.

4. Mix Interplus 356 in accordance with the Product Data Sheet and allow to stand for ten minutes before use.

5. Apply Interplus 356 to achieve the specified dry film thickness using brush, roller or spray.

6. Mix Interfine 878 in accordance with the Product Data Sheet and allow to stand for ten minutes before use.

7. Apply Interfine 878 to achieve the specified dry film thickness using brush, roller or spray.

Paint Application

When applying paint by spray, low pressure and high volume spray systems shall be used, as these systems limit the risk of overspray.

Determination of Wet Film Thickness

The wet film thickness measurements supplied by the paint manufacturer is based on no thinners being added to the paint.

If thinners are added to the paint, then the following formula must be used to determine the wet film thickness.

\[
WFT = DFT \times \left(100 + \% \text{ thinner added}\right) \div \% \text{ VS}
\]
5.2.2 PPG Paint Repair System - Polysiloxane Top Coat

Storage of Paint Requirements and Shelf Life
12 months at 25°C. Subject to re-inspection thereafter. Store in dry, shaded conditions away from sources of heat and ignition.

Substrate Preparation
Repair the concrete surface and allow concrete repair mortar to cure for three days.

Paint System

<table>
<thead>
<tr>
<th>Coat</th>
<th>Colour</th>
<th>Product</th>
<th>Binder</th>
<th>Thinners</th>
<th>Application Method</th>
<th>Volume Solids %</th>
<th>WFT (Microns)</th>
<th>DFT (Microns)</th>
<th>Over Coat Interval at 25°C</th>
<th>Pot Life at 25°C</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td>Grey</td>
<td>SigmaCover 350</td>
<td>HS HB Polyamine cured epoxy</td>
<td>91-92</td>
<td>Airless Spray, Brush &amp; Air Spray</td>
<td>72</td>
<td>140</td>
<td>100</td>
<td>5 Hours – 14 Days</td>
<td>2.5 Hours</td>
</tr>
<tr>
<td>2</td>
<td>Final</td>
<td>PSX 700</td>
<td>Epoxy Siloxane</td>
<td>#140</td>
<td></td>
<td>89</td>
<td>140</td>
<td>125</td>
<td>3 Hours</td>
<td>3 Hours</td>
</tr>
</tbody>
</table>

Total DFT Thickness 225

Etching Process between coats
Clean the paint down between each coat with thinners to etch the coat before applying the next coat. Allow the thinners to dry before applying the protective coating.
Paint Procedure

1. All surfaces to be painted shall be cleaned by a degreasing or washing procedure (as per AS 1627.1) to remove all oils, salts, acids or any other contamination that may be present.
2. Sand the entire area smooth with 240 grit paper.
3. Remove sanding dust and then solvent wipe again with 91-92 Thinner.
4. Mix SigmaCover 350 in accordance with the Product Data Sheet and allow to stand for ten minutes before use.
5. Apply SigmaCover 350 to achieve the specified dry film thickness using brush, roller or spray.
6. Mix PSX 700 in accordance with the Product Data Sheet and allow to stand for ten minutes before use.
7. Apply PSX 700 to achieve the specified dry film thickness using brush, roller or spray.

Paint Application

When applying paint by spray, low pressure and high volume spray systems shall be used, as these systems limit the risk of overspray.

Determination of Wet Film Thickness

The wet film thickness measurements supplied by the paint manufacturer is based on no thinners being added to the paint.

If thinners are added to the paint, then the following formula must be used to determine the wet film thickness.

\[ WFT = \frac{DFT \times (100 + \% \text{ thinner added})}{\% \text{ VS}} \]
5.2.3 International Paint Repair System – Polyurethane Top Coat

Storage of Paint Requirements and Shelf Life
12 months at 25°C. Subject to re-inspection thereafter. Store in dry, shaded conditions away from sources of heat and ignition.

Substrate Preparation
Repair the concrete surface and allow concrete repair mortar to cure for three days.

Paint System

<table>
<thead>
<tr>
<th>Coat</th>
<th>Colour</th>
<th>Product</th>
<th>Binder</th>
<th>Thinners</th>
<th>Application Method</th>
<th>Volume Solids %</th>
<th>WFT (Microns)</th>
<th>DFT (Microns)</th>
<th>Over Coat Interval at 25°C</th>
<th>Pot Life at 25°C</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td>Black</td>
<td>Interplus 356</td>
<td>Polyamide adduct cured epoxy</td>
<td>GTA 220</td>
<td>Airless Spray, Brush &amp; Air Spray</td>
<td>70</td>
<td>150</td>
<td>100</td>
<td>4 Hours - 24 Days</td>
<td>2 Hours</td>
</tr>
<tr>
<td>2</td>
<td>Final</td>
<td>Interthane 870</td>
<td>Polyurethane</td>
<td>GTA 713</td>
<td></td>
<td>56</td>
<td>180</td>
<td>100</td>
<td>4 Hours</td>
<td>2 Hours</td>
</tr>
</tbody>
</table>

Total DFT Thickness 200

Etching Process between coats
Clean the paint down between each coat with thinners to etch the coat before applying the next coat. Allow the thinners to dry before applying the protective coating.
Paint Procedure

1. All surfaces to be painted shall be cleaned by a degreasing or washing procedure (as per AS 1627.1) to remove all oils, salts, acids or any other contamination that may be present.

2. Sand the entire area smooth with 240 grit paper.

3. Remove sanding dust and then solvent wipe again with GTA220 Thinner.

4. Mix Interplus 356 in accordance with the Product Data Sheet and allow to stand for ten minutes before use.

5. Apply Interplus 356 to achieve the specified dry film thickness using brush, roller or spray.

6. Mix Interthane 870 in accordance with the Product Data Sheet and allow to stand for ten minutes before use.

7. Apply Interthane 870 to achieve the specified dry film thickness using brush, roller or spray.

Paint Application

When applying paint by spray, low pressure and high volume spray systems shall be used, as these systems limit the risk of overspray.

Determination of Wet Film Thickness

The wet film thickness measurements supplied by the paint manufacturer is based on no thinners being added to the paint.

If thinners are added to the paint, then the following formula must be used to determine the wet film thickness.

\[ WFT = DFT \times \left(100 + \% \text{ thinner added}\right) / \% \text{ VS} \]
5.2.4 PPG Paint Repair System - Polyurethane Top Coat

Storage of Paint Requirements and Shelf Life
12 months at 25°C. Subject to re-inspection thereafter. Store in dry, shaded conditions away from sources of heat and ignition.

Substrate Preparation
Repair the concrete surface and allow concrete repair mortar to cure for three days.

Paint System

<table>
<thead>
<tr>
<th>Coat</th>
<th>Colour</th>
<th>Product</th>
<th>Binder</th>
<th>Thinners</th>
<th>Application Method</th>
<th>Volume Solids %</th>
<th>WFT (Microns)</th>
<th>DFT (Microns)</th>
<th>Over Coat Interval at 25°C</th>
<th>Pot Life at 25°C</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td>Grey</td>
<td>SigmaCover 350</td>
<td>HS HB Polyamine cured epoxy</td>
<td>91-92</td>
<td>Airless Spray, Brush &amp; Air Spray</td>
<td>72</td>
<td>140</td>
<td>100</td>
<td>5 Hours – 14 Days</td>
<td>2.5 Hours</td>
</tr>
<tr>
<td>2</td>
<td>Final</td>
<td>SigmaDur 550</td>
<td>Polyurethane</td>
<td>21-06</td>
<td></td>
<td>55</td>
<td>90</td>
<td>50</td>
<td>5 Hours</td>
<td>4 Hours</td>
</tr>
</tbody>
</table>

Total DFT Thickness 150

Etching Process between coats
Clean the paint down between each coat with thinners to etch the coat before applying the next coat. Allow the thinners to dry before applying the protective coating.
Paint Procedure

1. All surfaces to be painted shall be cleaned by a degreasing or washing procedure (as per AS 1627.1) to remove all oils, salts, acids or any other contamination that may be present.

2. Sand the entire area smooth with a grit paper.

3. Remove sanding dust and then solvent wipe again with 91-92 Thinner.

4. Mix SigmaCover 350 in accordance with the Product Data Sheet and allow to stand for ten minutes before use.

5. Apply SigmaCover 350 to achieve the specified dry film thickness using brush, roller or spray.

6. Mix SigmaDur in accordance with the Product Data Sheet and allow to stand for ten minutes before use.

7. Apply SigmaDur to achieve the specified dry film thickness using brush, roller or spray.

Paint Application

When applying paint by spray, low pressure and high volume spray systems shall be used, as these systems limit the risk of overspray.

Determination of Wet Film Thickness

The wet film thickness measurements supplied by the paint manufacturer is based on no thinners being added to the paint.

If thinners are added to the paint, then the following formula must be used to determine the wet film thickness.

\[ WFT = DFT \times \frac{(100 + \% \text{ thinner added})}{\% \text{ VS}} \]
5.2.5 Dulux Paint Repair System – Polyurethane Top Coat

**Storage of Paint Requirements and Shelf Life**
12 months at 25°C. Subject to re-inspection thereafter. Store in dry, shaded conditions away from sources of heat and ignition.

**Substrate Preparation**
Repair the concrete surface and allow concrete repair mortar to cure for three days.

**Paint System**

<table>
<thead>
<tr>
<th>Coat</th>
<th>Colour</th>
<th>Product</th>
<th>Binder</th>
<th>Thinners</th>
<th>Application Method</th>
<th>Volume Solids %</th>
<th>WFT (Microns)</th>
<th>DFT (Microns)</th>
<th>Over Coat Interval at 25°C</th>
<th>Pot Life at 25°C</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td>Grey</td>
<td>Durebild STE</td>
<td>Polyamine cured epoxy</td>
<td>Dulux epoxy thinner</td>
<td>Airless Spray, Brush &amp; Air Spray</td>
<td>84</td>
<td>175</td>
<td>125</td>
<td>9 Hours – 4 Weeks</td>
<td>90 Minutes</td>
</tr>
<tr>
<td>2</td>
<td>Final</td>
<td>Weathermax HBR</td>
<td>Polyurethane</td>
<td>Duthin 040</td>
<td></td>
<td>70</td>
<td>110</td>
<td>75</td>
<td>10 Hours</td>
<td>2 Hours</td>
</tr>
</tbody>
</table>

**Etching Process between coats**
Clean the paint down between each coat with thinners to etch the coat before applying the next coat. Allow the thinners to dry before applying the protective coating.
Paint Procedure

Method 1: Minor damage to topcoat (no primer required)

1. All surfaces to be painted shall be cleaned by a degreasing or washing procedure (as per AS 1627.1) to remove oils, salts, acids or any other contamination the may be present.
2. Sand the entire area smooth with 240 grit paper.
3. Remove sanding dust and then solvent wipe again with Dulux Polyurethane Thinner.
4. Mix Weathermax HBR in accordance with the Product Data Sheet and allow to stand for ten minutes before use.
5. Apply Weathermax HBR to achieve the specified dry film thickness of 75 microns using brush, roller or spray.

Note: Brush / roller application will require multiple coats to achieve the specified DFT requirements

Method 2: Damage to topcoat and primer with concrete exposed (primer required)

1. Repair damaged concrete areas with Luxepoxy Filler, as per manufacturer's recommendations.
2. Allow Luxepoxy Filler to cure for 13 hours (min) / 24 hours (max) @ 25°C
3. Apply one coat of Durebild STE with a dry film thickness of 125 microns.
4. Etch previous coat with thinners before applying next coat.
5. Apply one coat of Weathermax HBR with a dry film thickness of 75 microns.

Note: Brush/roller application will require multiple coats to achieve the specified DFT requirements

Paint Application

When applying paint by spray, low pressure and high volume spray systems shall be used, as these systems limit the risk of overspray.

Determination of Wet Film Thickness

The wet film thickness measurements supplied by the paint manufacturer is based on no thinners being added to the paint.

If thinners are added to the paint, then the following formula must be used to determine the wet film thickness.

\[ WFT = DFT \times \left(100 + \% \text{ thinner added}\right) \div \% \text{ VS} \]
5.2.6  Klaas Coatings Repair System – Silicone Resin Top Coat

Storage of Paint Requirements and Shelf Life
Store in dry, shaded conditions away from sources of heat and ignition. Shelf life is 2 years.

Substrate Preparation
Pressure wash - remove any form release oil or efflorescence prior to application.
If necessary patch repair concrete as directed, preferably with a polymer modified repair mortar compound. Ensure a similar surface texture to the surrounding area is achieved.
Panels must be surface dry. Panel surface must be cohesive, free of dust, oil, grease or other contaminants.

Paint System

<table>
<thead>
<tr>
<th>Coat</th>
<th>Colour</th>
<th>Product</th>
<th>Binder</th>
<th>Thinners</th>
<th>Application Method</th>
<th>Volume Solids %</th>
<th>WFT (Microns)</th>
<th>DFT (Microns)</th>
<th>Over Coat Interval at 25°C</th>
<th>Pot Life at 25°C</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td>Final</td>
<td>Si-Rex03</td>
<td>Silicone Resin</td>
<td>Water</td>
<td>Spray/Brush/Roll</td>
<td>36</td>
<td>120</td>
<td>43</td>
<td>touch dry + 1 Hour</td>
<td>n/a</td>
</tr>
<tr>
<td>2</td>
<td>Final</td>
<td>Si-Rex03</td>
<td>Silicone Resin</td>
<td>Water</td>
<td></td>
<td>36</td>
<td>120</td>
<td>43</td>
<td>touch dry + 1 Hour</td>
<td>n/a</td>
</tr>
</tbody>
</table>

Total DFT Thickness 86

Etching Process between coats
Not required.
Paint Procedure

1. Thoroughly mix paint.
2. Check colour is correct.
3. Check no rain is expected / forecast on day of application.
4. Confirm surface preparation is complete.
5. Ensure temperature and dew point is within parameters.
6. Determine surface area to required volume calculation.
7. Ensure all water / line preservative is removed from lines / tips (when Spraying).
8. Spray / Roll at required rate.
9. Confirm WFT at regular intervals to ensure required application rate.
10. Ensure material is 100% touch dry before second coat. Generally 15 minutes at 25°C and 50 RH when spraying or 2 hours post touch dry when rolling.
11. Spray in opposite direction to first coat.
12. Confirm WFT at regular intervals to ensure required application rate.
13. Clean up tools with water.

Paint Application

Airless spray or roll at 8 m²/L per coat to achieve 120 μm WFT. Two coats required.

Determination of Wet Film Thickness

The wet film thickness measurements supplied by the paint manufacturer is based on no thinners being added to the paint.

If thinners are added to the paint, then the following formula must be used to determine the wet film thickness.

\[
WFT = DFT \times \left(100 + \% \text{ thinner added}\right) \div \% \text{ VS}
\]
6 Timber substrates

6.1 Paint system

Paint system will be released with a future Technical Note update.

6.2 Paint repair system

Paint repair system will be released with a future Technical Note update.