



Coating Specification 3282

Vitrethane coated Metal Composite Panel

Environment	Urban/External		
Location	N/A		
Substrate	Chemetal products: 703, 911 & others*		
Specification No	3282	Date	9/4/2015
Writer	Tom Williams		

(*an adhesion test is recommended for any other substrates not listed on this specification)

Overview:

This system is for the application of a durable, anti-graffiti coating system to Chemetal's metal Composite panels/sheeting.

Notes:

1. Product Data Sheets and Material Safety Data Sheets for all products must be strictly followed.
2. This specification is offered free of charge as a guide. Any warranty will be strictly limited to supply of replacement materials. No further liability for failure or associated costs will be borne by That Metal Company.
3. The dry film thicknesses quoted in this Recommendation are the minimum to be achieved. Do not exceed specified thickness by more than 30%. The specified film thickness for each coat shall be achieved prior to the application of the subsequent coat.

SURFACE PREPARATION

Clean in accordance with AS1627.1 to remove all degreasing products, grease, dirt, salts and other contaminants.



APPLICATION

1. Apply on coat of **Envelon 220 Clear Metal Primer** to achieve 10 microns DFT as per data sheet 330.
 2. Allow the Envelon 220 Primer to cure for a minimum of 1 hour. (Curing times may vary depending on temperature and humidity).
 3. Apply one top coat of **Vitrethane 644 Anti-Graffiti** exterior polyurethane finish to achieve 50 microns as per data sheet 055.
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- For colour and gloss level requirements consult with the That Metal Company team.



Single Page Specification Sheet 3282

Product	Data Sheet	Appn Method	Theoretical Spreading Rate M2/L	Dry Film Thickness Microns	Volume Solids	Mixing Ratio	Pot Life 25C	Thinner	Clean Up Solvent	Reco at Time 25C
Envelon 220	330	AS/CS	20	10	62	N/A	N/A	N/A	Thinners 5	1 hr
V644	055	AS	8.7	50	44	3:1	6 hrs	V111	V102	2-8 hours

TOTAL MINIMUM DRY FILM THICKNESS: 53 microns

APPLICATION METHOD

AS = Airless Spray, CS = Conventional Spray, AGS = Agitated Spray R = Roller, B = Brush

NOTES:

1. This specification should be read in conjunction with all relevant Product Data Sheets and Material Safety Data Sheets.
2. This specification is offered free of charge as a guide. Any warranty will be strictly limited to supply of replacement materials. No further liability for failure or associated costs will be borne by That Metal Company.
3. Being a generic spec, there may be situations or conditions not considered that could influence the performance or appearance of the finished product. If you have any query in this regard, you should request a Site Unique Specification.
4. Product usage rates and film build required will vary from project to project in reflection of the varying wear factors and substrate conditions.
5. In addition, Area Specific Instruction Sheets are available on request.