

CUT EDGE and SCRATCH – TOUCH UP PROCEDURE

1. Cut Edge

The cut edge can be performed by using any of the following, ensuring all swarfing is removed and a smooth cut edge is achieved, the cut should always point downward in direction to ensure no water or contaminant entrapment :

- Cold Cut Grinder
- Nibbler
- Guillotine

The direction of the cut can be either of the following :

- Across the width of the Flat or Profiled sheet (edge to edge)
- Along the length of the flat sheet coil (normally referred to as slitting)

If the Warranty document require edges to be touched up , the below applies and both primer and topcoat should be used.

- COLORPLUS – modified polyester : Edges exposed to the external environment. If the edges are protected by overlapping with no condensation, no touch up required.
- COLORPLUS – PVDF : Any cut edge (edge to edge and slitting)

If the Warranty document require edges to be touched up , the below applies and only clear topcoat is required.

- ZINCAL : Edges exposed to the external environment, If edges are Protected by overlapping with no condensation , no touch up required.

2. Paint Data (supplied by Akzonobel and Salcomix branch)

a. Primer Components – High Build Etch Primer – Yellow

- Primer: B-GL62-7610-0108
- Hardener: B-SC65-0731-0101

b. Top Coat Components – 2K Solvent Borne Polyurethane

- Top Layer Coloured Paint : 603 Or 650 Line for Gloss finish
728 Line for Matt finish
- Hardener: Recommended by Salcomix on order.

3. Paint Application Procedure

• *Surface Preparation*

- The area to be painted needs to be clean and dry. Ensure free of dirt , moisture, chalk, wax, grease , oil , mildew and any other contaminant.

- Wash the area with a light soap and water solution to remove contaminants
- Ensure the area dries well
- Use a “scotch bright pad” to lightly sand the edges for about 5 cm on both Top and Bottom surface. The residue formed , needs to be removed.

- **General Paint Application – Specific application can be supplied by Salcomix or other supplier**

- **COLORPLUS – Modified Polyester and PVDF products**

- *Brush (soft type) the prepared **primer** onto the prepared surface and allow 2 hours to dry.

- *Brushed area should be 5cm wide covering the cut edge.

- *Brushed area should cover both top and bottom surface.

- +Brush (soft type) the prepared **top coat** onto the dried primer area and allow to dry.

- +Brushed area should be 5 cm wide covering the cut edge.

- +Brushed area should cover both top and bottom surface.

- **ZINCAL Products**

- #Brush (soft type) the prepared top coat (clear) onto the prepared surface and allow to dry.

- #Brushed area should be 5cm wide covering the cut edge.

- #Brushed area should cover both top and bottom surface.

- **General**

- It is advised to use very light pressure when touch the brush to the surface.
- Avoid retouching the wet paint film with the brush after it is applied.
- When touching up COLORPLUS – modified polyester product , it is advised to match the colour.
- The factory applied coatings and brushed air dried touch up coatings can differ in colour and weathering of time.

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