Application conditions

APPLICATION, COATING THICKNESS AND CURING

Coating of the objects must be carried out in one operation and in such a way that exposed surfaces receive a film thickness of at least 60 µm. Film thickness of the cured coating must, at no point, be less than 48 µm.

For objects or details, which are to be worked after coating (i.e. sawing, milling, and drilling), the coating thickness must not exceed 120 µm. Corro-Coat PE-SDF powder products covered by this warranty must be completely cured according to the corresponding Product Data Sheet guidelines.

Buyer is required to check the oven on a regular basis as described in Sections 4 and 5 in Exhibit 2.

CONTROL AND DOCUMENTATION

Prior to production runs or where re-starts follow temporary breaks in production, a sufficient number of test panels must be coated and cured for testing and control purposes.

Similarly, test panels must be coated and cured for testing at least once per shift. A test should also be run at least once per colour or per job, when the job requires less than 8-hour shift to be completed.

The test panels must be coated and cured for testing according to the tests in Sections 4 and 5 in Exhibit 2.

Test panels must be prepared (pre-treated and coated) under normal factory conditions and must be cured together with a normal series in the oven.

A written test log must be prepared and kept for the duration of the warranty period. At least one coated test panel from each test point must be retained for the same period.

Details of the operation and control of the pre-treatment process (including drying) must be logged and kept, as must records from control of oven parameters and curing conditions.
All documentation must be made available for inspection upon request.

HANDLING, MOUNTING AND MAINTENANCE

It is important that during construction and assembly work the coated Parts are protected from mechanical damage as well as cement and concrete spillage.

Special care must be taken when loading and unloading coated components. Corners and edges are especially susceptible to impact and should be protected.

Reasonable care must be taken during transportation and on site. Strict site discipline is the only effective way to prevent handling or installation damage.

Direct contact with unapproved tapes, adhesives, cleaning materials or other chemicals must be avoided.

Mounting techniques must be suitable for powder coated aluminium. The coated objects must not be in contact with materials or other substrates that may create galvanic corrosion.

Regular adhesive tapes must not be allowed to come into direct contact with objects coated with polyester powder coating. Should protective tape be required, then only a tape designed and suitable for protection of coated aluminium substrates shall be used.

Compliance, as well as ensuring that no residue, of any nature, is left on the coating, is The End User or Buyer's responsibility. It is the responsibility of The End User as well to ensure the necessary maintenance, for repairs of damages and general cleaning, cf. Exhibit 3.