



HMG Powder Coatings Limited

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Cleaning & Maintenance

Architectural Powder Coatings are organic coatings that need to be cleaned and maintained regularly to ensure that the decorative and protective properties of the coating are retained.

For any particular region or territory, there may be local regulations or local requirements to be met in order to achieve conformance to certain published quality labels or standards. It is the users' responsibility to be aware of such standards.

Frequency

The frequency of such cleaning will depend on many factors including:

- The geographical location of the building
- The environment surrounding the building, i.e., marine, swimming pool, industrial, or a combination of these environments, etc.
- Levels of atmospheric pollution
- Prevailing wind
- Protection of the building by other buildings
- Possibility of airborne debris e.g. sand/dust etc. causing erosive wear of the coating
- If the environmental circumstances change during the lifetime of the building (e.g. rural becomes industrial)

The best method of cleaning is by regular washing of the coating using a solution of warm water and mild detergent. All surfaces should be cleaned using a soft cloth or sponge, using nothing harsher than natural bristle brushes. Cleaning of window sections etc. can be conveniently carried out at the same time as glazing cleaning.

If the atmospheric pollution has resulted in heavy soiling of the coating, then nothing harsher than the white spirit should be used for cleaning.

The frequency of cleaning depends in part on the standard of appearance that is required and also the requirements to remove deposits that could, during prolonged contact with either the powder film or the metal substrate (if exposed) cause damage.

In hazardous environments the normal frequency of cleaning should be at a maximum of three monthly intervals. However where there is high atmospheric pollution or an extremely hazardous atmosphere (i.e. a combination of factors above or others) the period between cleaning should be reduced.

Where the atmosphere is deemed to be non-hazardous, e.g., rural or a "normal" urban environments, then the period between cleaning can be extended up to a maximum of 12 months. However if heavy soiling occurs, more regular cleaning is required.

Records of all cleaning schedules and frequencies should be kept and maintained.

Typical Cleaning and Inspection Frequencies

Normal Environment	Clean and check every 12 months
Marine Environment	Clean and check every 3 months
Industrial Environment	Clean and check every 3 months
Marine & Industrial Environment	Clean and check every 3 months
Swimming & Leisure Pools	Clean and check every 3 months

Do not under any circumstances use strong solvents or solutions containing:

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- Chlorinated Hydrocarbons
- Esters
- Ketones
- Abrasive Cleaner or polish

Repair Procedure

Damage to powder coatings may be caused during transportation, installation or as a result of the action of other trades (e.g. scaffold damage) on site.

For on-site rectification of small damaged areas a two pack polyurethane topcoat, matched for colour and gloss to the appropriate powder coating shade should be used.

Where damage has exposed the metal, the prepared metal only should be primed with a Two Pack Chromate (or Chromate-Free) Etch Primer.

Use of the liquid coatings should be in accordance with the paint manufacturer's instructions.

Method 1: Minimum requirements to repair small isolated areas (approx. 5-6cm²) and scratch damage:

- (a) Clean all surfaces to be painted with a solvent-based degreaser by applying liberally using a clean lint-free cloth and wipe dry using lint-free cloths physically removing all sealants and mastics, etc.
- (b) Abrade all areas to be coated with abrasive paper up to 320/400 grade to ensure a suitable keyed surface, ready to be coated, then wipe clean using lint free tac-rags.
- (c) Apply by brush to exposed metal surfaces only one thin coat of Two Pack Chromate-Free Etch Primer and allow to dry.
- (d) Apply by brush or spray one coat of Two Pack Polyurethane Topcoat, matched to shade and gloss.

Method 2: Minimum requirements to repair larger areas of damage:

- (a) Mask all surrounding surfaces of the damaged areas to the edge of the panel or a suitable breakline.
- (b) Clean all surfaces to be coated with a solvent based degreaser by applying liberally using a lint free cloth, and wipe dry using lint free cloths, physically removing all sealants and mastics etc.
- (c) Abrade all areas to be coated with abrasive paper, up to 320/400 grade to ensure a suitable keyed surface, ready to be coated, then wipe clean using lint free tac-rags.
- (d) Apply by brush or spray to the exposed metal surface only one thin coat of a Two Pack Chromate-Free Etch Primer and allow to cure as recommended. Apply by spray a minimum of 40 microns the Two Pack Polyurethane Topcoat matched to shade and gloss.

Method 3: Minimum requirements for complete re-sprays on site.

Substrate Preparation

- (a) Clean all surfaces using a solvent based degreaser and physically remove all sealant and mastics products. Degrease all areas to be abraded using lint-free cloth. Inspect and remove all mastic sealant adjoining any surface to below 4mm of metal edges.
- (b) Apply protective masking to unaffected areas as required.
- (c) Mechanically abrade to sound substrate. Drilled holes to be countersunk and butt joints to be filled, the surface should be taper on the side for filling.
- (d) Abrade mechanically or by hand using 60/80 abrasive paper areas to receive filling media.
- (e) Clean down with vacuum or air, thoroughly degrease with a solvent based degreaser areas to be filled, physically removing any sealant mastics, etc. where necessary.

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- (f) Mix the components of the filling media as specified in the manufacturers recommendations and apply directly to the substrate. Work the material to remove any trapped air and finish to profile shape. Allow to fully curing as per manufacturer's recommendations.
- (g) Abrade with 80 abrasive paper to correct profile whether by hand or mechanical action. Repeat items (f) and (g) if required. Clean down after each operation to remove dust and debris.
- (h) Abrade all areas coated with abrasive paper up to 320/400 grade, if necessary, to ensure a suitable keyed surface, ready to be coated, then wipe clean using lint free tac-rags.
- (i) De-mask and clean down.

Recoating

- (j) Mask unaffected areas prior to painting. Degrease using solvent degreaser and lint-free cloth and remove all dust.
- (k) Apply one spray coat of a Two Pack Chromate-Free Etch Primer to any areas of exposed metal to a minimum of 5 microns dry film thickness. Allow curing as recommended and lightly key surface. Remove all debris and tac-rag surface.
- (l) Apply Two Pack Polyurethane Topcoat to a minimum dry film thickness of 40 microns allow to flash off and cure as detailed in the manufacturer's Data Sheet.
- (m) De-mask, clean down and remove debris, etc.
- (n) Re-apply sealant/mastic on required areas.
- (o) Present finished painted areas for inspection and approval of client.

The above information and repair methods/statements etc. are intended for guidance only. It is the client's responsibility to ensure that the products to be used are fit for purpose.

Repair paints may weather at different rates to the original powder coatings.



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