

CERAM-A-CRYL® II

Silicone-modified acrylic repaint finish



AkzoNobel

Tomorrow's Answers Today

Application guidelines for CERAM-A-CRYL® II, which is designed for use over primed, prepainted metal substrates and primed metal substrates.

For professional use only.

These guidelines are offered as a method to optimize the performance of the CERAM-A-CRYL® II repaint finish. CERAM-A-CRYL® II is recommended for repainting non-corroded, weathered metal building panels. The coating system is comprised of a Silicone-modified Acrylic coating, intended for use as two-coat material applied over factory prepainted panels.

CERAM-A-CRYL® II is not designed to be used as a one-coat over bare metal, or on non-metal substrates such as wood, glass or plastics.

CERAM-A-CRYL® II Coating is not recommended for application to masonry, PVC, fiberglass, concrete block, wood, and all other non-metallic substrates.

Surface preparation for bare metal substrates

Bare iron and steel: Minimum surface preparation is Hand Tool Cleaning per SSPC-SP2¹. Remove all oils and grease from the surface by Solvent Cleaning per SSPC-SP1². Test for adequate adhesion per Appendix A.

Galvanized metal: Allow to weather a minimum of 6 months prior to coating. Solvent clean per SSPC-SP1². When weathering is not possible

or the surface has been treated with chromates or silicates, first solvent clean and apply the coating to a test area, allowing paint to dry one week before testing adhesion. If adhesion is poor, brush blasting per SSPC-SP7³ is necessary to remove these treatments. Rusty galvanizing requires a minimum of Hand Tool Cleaning per SSPC-SP2¹. Test for adequate adhesion per Appendix A.

Aluminum: Because of the variety of aluminum compositions and treatments (e.g., alodine and anodizing) available, users must test for adhesion on their substrate before using. See Appendix A.

Surface preparation for prepainted metal substrates

Before painting your factory-finished building panels, great care must be taken to prepare the surface to be painted, and to carefully assess the adhesion of this AkzoNobel coating. The following four problem areas must be addressed before the repainting process can begin:

1.) Dirt and Mildew

Dirt, loose chalk and mildew must be removed before repainting can begin. Mild solutions of detergents or household ammonia will aid in the removal of most dirt, and the following are recommended levels:

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- a.) One cup of Tide, or other common household laundry detergents, which contain less than 0.5% phosphate, dissolved into five gallons of warm water. NOTE: The use of detergents containing greater than 0.5% phosphate is not recommended for use in general cleaning. Never blend cleansers or detergents with bleach.
- b.) One cup of household ammonia dissolved into five gallons of water (room temperature).

Use a well-soaked cloth, sponge, or brush (with very soft bristles). A low-pressure spray washer may also be used. We do not recommend the use of scouring powders or industrial solvents since these agents may damage the film. Solvent-containing cleaners such as Fantastic®, however, are very effective and can be used without concern. If mildew or other fungal growth is a problem and cannot be removed as outlined above, household bleach-mixed at a concentration of one cup of bleach to five gallons of water, along with one cup of a mild soap (e.g., Ivory®) to aid wetting, is recommended.

Heavier dirt accumulations which must be addressed prior to repainting may necessitate the use of a dilute solution of Spic and Span® (1 cup into 5 gallons of warm water). NOTE: Detergent containing greater than 0.5% phosphate is recommended only as a preparation prior to repainting. Do not use such detergents for routine cleaning. Always rinse the surface thoroughly to remove any of the agents used in the cleaning procedure. Residual cleaners left on the surface will damage the adhesion of the newly applied paint system.

2.) Surface Imperfections

Minor scratches, which have not left the metal substrate exposed, can be lightly sanded or buffed to create a smoother surface. Care must be taken, however, not to expose the metal substrate. Once this exposed condition exists, the likelihood for rusting is greatly increased. Should the metal substrate be observed during this operation, see the following paragraph.

3.) Exposed Metal and Rust

Exposed metal minimum surface preparation is Hand Tool Cleaning per SSPC-SP2¹ and use of a primer specifically designed to protect any exposed galvanized steel metal from corrosion¹. Care must be taken, however, not to destroy the galvanized surface. Before priming the metal building panel, test for adequate intercoat adhesion (see Appendix A). Allow sufficient time for the primer to dry before applying the topcoat.

For severely rusted building panels the recommended preparation is SSPC-SP7ⁱⁱ – Brush-Off Blast Cleaning. AkzoNobel's Water-Based Epoxy Maintenance Coat, or a maintenance primer designed for use on hot-dipped galvanize steel, is recommended to protect the metal building panel from further rusting.

4.) Additional Preparation Required for New Building Panels

There may still be a layer of factory-applied wax on the surface of the building if it has been installed within the last two years. This material is

used to protect the panels during fabrication and transit, and failure to remove this material will result in poor intercoat adhesion with resultant peeling or flaking of the new coating. To remove this wax, it will be necessary to lightly scuff the surface with a GRAY (not green) 3M Synthetic Steel Wool pad (equivalent to "000" steel wool) saturated with soapy water. A final wipe and rinse should be done with clean water only, to remove any loose dust or soap film.

Once this procedure is completed, perform the adhesion test in Appendix A to assure that acceptable adhesion is evident. If poor adhesion is still observed, repeat step #4.

It is imperative, of course, that the factory finish itself not be removed during this process. It is necessary to once again test the intercoat adhesion according to Appendix A. If the test results still indicate poor intercoat adhesion, do not proceed! Contact your builder immediately.

CERAM-A-CRYL® II preparation

Mix coating thoroughly before using. A mechanical mixer should be used. Improper mixing (such as hand mixing or stirring with a stick or spatula) may lead to improper color or gloss. To reduce for spray, add approximately one gallon of EXP5050 Reducing Solvent (or perchlorobenzotrifluoride solvent) per three gallons of CERAM-A-CRYL® II. More solvent may be needed, depending upon temperature and application equipment. For brush or roller application, reduction generally is not needed. NOTE: This coating is not well suited for brush or roller application.

CERAM-A-CRYL® II application

After mixing thoroughly, the material is ready to apply. For airless spray application, a 0.015" tip and 1,500 psi have been found to give a uniform wet film. Apply a uniform coat of 1.2 mils dry film thickness, minimum. Depending upon color and application conditions, two complete coats may be required in order to achieve uniform color and gloss.

Application precautions:

Apply only when air, surface and product temperatures are above 50°F (10°C) and surface temperature is at least 5°F (3°C) above the dew point. Application temperatures below 50°F (10°C) may cause poor adhesion and lengthen the drying and curing time. Application temperatures above 95°F (35°C) may cause dry spray, uneven appearance and poor adhesion. Do not apply to surfaces at temperatures of 120°F (71°C) or higher.

Avoid exterior painting late in the day when dew or condensation are likely to form or when rain is threatening. During the early stages of drying, the coating is sensitive to rain, dew, high humidity and moisture condensation. Plan painting schedules to avoid these conditions during the first 16-24 hours of curing.

Recoat

CERAM-A-CRYL® II is recoatable after approximately 4 hours. Apply all coats within one month.

Clean-up

Use EXP5050 Reducing Solvent to clean equipment.

U.S. EPA regulations

CERAM-A-CRYL® II as supplied and reduced with the recommended EXP5050 Reducing Solvent meets or exceeds the U.S. Environmental Protection Agency established limits for volatile organic compounds in architectural coatings.

V.O.C. limit

420 grams per liter (3.5 pounds per gallon).

Appendix A - evaluating intercoat adhesion

- 1.) After properly cleaning the surface to be repainted, paint a 4" x 4" area with the repaint material according to the manufacturer's instruction. Allow to dry completely before proceeding.
- 2.) Use a utility knife to cut a two inch "X" into the repaint coating.
- 3.) Place a three inch strip of Scotch® 610 tape over the "X" and rub 10 times with heavy pressure leaving a half inch of tape free for removal.
- 4.) Pull the tape back over itself at a 180° angle.
- 5.) Examine the tape and the building panel for any signs of paint removal.

If the tape removes more than 1/16" of the repaint material from the "x" cut, the intercoat adhesion is inadequate.

¹ AkzoNobel's Water-Based Epoxy Maintenance Coat, WA9C32800 / GW9C32796 or equivalent primer designed for adhesion to galvanized steel.

ⁱ SSPC-SP2 – Hand Tool Cleaning

Hand Tool Cleaning removes all loose mill scale, loose rust and other detrimental foreign matter. It is not intended that adherent mill scale, rust, and paint be removed by this process. Mill scale, rust and paint are considered adherent if they cannot be removed by lifting with a dull putty knife. Before hand tool cleaning, remove visible oil, grease, soluble welding residues, and salts by the methods outlined in SSPC-SP1ⁱⁱ. For complete instructions, refer to Steel Structures Paint Council Surface Preparation Specification No. 2

ⁱⁱ SSPC-SP7 - Brush-Off Blast Cleaning

A Brush-Off Blast Cleaned surface when examined without magnification, shall be free of all visible oil, grease, dirt, dust, loose mill scale, loose rust, and loose paint. Tightly adherent mill scale, rust, and paint may remain on the surface. Mill scale, rust, and coating are considered adherent if they cannot be removed by lifting with a dull putty knife. Before blast cleaning, visible deposits of oil or grease shall be removed by any of the methods specified in SSPC-SP1ⁱⁱⁱ or other agreed upon methods. For complete instructions, refer to Joint Surface Preparation Standard SSPC-SP7/NACE NO. 4.

ⁱⁱⁱ SSPC-SP1 – Solvent Cleaning

Solvent Cleaning is a method for removing all visible oil, grease, soil, drawing and cutting compounds, and other soluble contaminants. Solvent cleaning does not remove rust or mill scale. Change rags and cleaning solution frequently so that deposits of oil and grease are not spread over additional areas in the cleaning process. Be sure to allow adequate ventilation. For complete instructions, refer to Steel Structures Paint Council Surface Preparation Specification No. 1.

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