

GUIDELINES ON CUT EDGES AND SCRATCHES ON SAFAL STEEL MATERIAL

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.

SALCOMIX Contact Details

Cape Town – Atlantic : 021 933 1770
Port Elizabeth – Dar : 041 453 8560
Johannesburg – Topcoat : 011 453 9600
Bloemfontein – Apex : 051 011 9068
Nelspruit – Apex : 013 590 9066

A member of the

