

APPLICATION PROCEDURE

HEMPACRYL SOLFIX 26P02 VARNISH

1. INTRODUCTION

The aim of this procedure is to define the correct way to varnish Viroc® panels using HEMPACRYL SOLFIX 26P02 varnish from Hempel.

The side facing upward in the packaging is referred to as side A and this is the side that will be exposed and visible.

The rear side, which will be hidden from view, will be referred to as side B.

2. APPLICATION TEMPERATURE

The HEMPACRYL SOLFIX 26P02 varnish may only be applied when the temperature at the application site is between 5°C and 30°C.

3. RELATIVE HUMIDITY

The HEMPACRYL SOLFIX 26P02 varnish may only be applied when the relative humidity at the application site is lower than 80%.

4. DEW POINT

The HEMPACRYL SOLFIX 26P02 varnish may only be applied when the surface temperature of the Viroc panel is at least 3°C above the dew point.

5. COATING INTERVALS

The minimum interval between coats of HEMPACRYL SOLFIX 26P02 is **30 minutes** (at a temperature of 20°C).

When varnished in a workshop, the panels can only be packaged 72 hours (**3 days**) after the last coat of HEMPACRYL SOLFIX 26P02 varnish (at a temperature of 20°C), and they are wrapped in plastic film to separate the panels.

6. CLEANING THE VIROC PANEL

Clean side A of the Viroc® panel and remove any dirt, grease, dust or salts on the surface by softly polishing using a cleaning disc. Viroc Portugal has discs suitable for cleaning the panels.

Side B can be simply cleaned by brushing or sanding with fine sandpaper and subsequently removing any waste.

7. VARNISHING

Side B

Apply one coat of undiluted HEMPACRYL SOLFIX 26PO2 using a roller, layer **(1)**;
The purpose of this coat is to seal the pores of the panel.

Side A and Edges

Apply one coat of undiluted HEMPACRYL SOLFIX 26PO2 using a roller, layer **(2)**;
The purpose of this coat is to seal the pores of the panel.

Apply two coats of undiluted HEMPACRYL SOLFIX 26PO2 using a spray gun or roller, layers **(3)** and **(4)**;

Minimum thickness: 40 µm, (20 µm per coat).

8. QUALITY CONTROL

The painter should perform the following registration and quality control tasks before and during Viroc panel varnishing jobs.

- a) Check that the Viroc panels are not wet.
- b) Check that the panel temperature is **3°C** above the dew point.
- c) Measure the temperature and relative humidity of the location where the varnishing is to be performed. Record the readings on the painting record sheet.
Measurement frequency: 3 times per day during working hours (morning, noon and mid-afternoon).
- d) The batch numbers of the products used will be registered on the varnishing record sheet. The expiry date indicated on the packaging will also be recorded.
- e) Samples of minimum size 400x800 mm, and randomly arranged on the panel without ever forming a row, will be taken while the panels are being painted in order to control the quantity of varnish applied on the Viroc panel. Metal plates (one unit per panel), with a minimum dimension of 75x150 mm, will be placed on the samples and painted with the spray gun on the last two finishing coats, layers **(3)** and **(4)**.

- f) The number of samples to be taken will be one metal plate per 200 m².
The varnish thickness of layers **(3)** and **(4)** measured on the registration and control plates after drying may not be less than 40 µm.
- g) If it is found that the amount of varnish is lower than the above-indicated, additional coats are applied until the minimum thickness is measured.
The surface may be lightly sanded with No. 200 sandpaper to improve adhesion between coats.

9. MAINTENANCE

Remove all films that do not guarantee good adhesion.

Decontaminate and wash the surface with a high-pressure freshwater jet.

Leave to fully dry.

Apply the number of coats of HEMPACRYL SOLFIX 26P02 varnish that are necessary.

ANNEX:

Temperature and Relative Humidity of Air Record Sheet;

Thickness Control Record Sheet;

HEMPACRYL SOLFIX 26P02 technical datasheet. The attached datasheet may not be the latest version, therefore we recommend that it is downloaded from the site www.hempel.pt.

NB:

Viroc Portugal S.A. and HEMPEL Portugal Lda. reserve the right to change the information contained in this application procedure whenever they deem necessary.

TEMPERATURE AND RELATIVE HUMIDITY OF AIR RECORD SHEET

VARNISHING

JOB: _____

DATE: ____ / ____ / ____

Varnish Type: _____

Batch: _____ Expiry date: ____ / ____ / ____

Time: ____ : ____ Room temperature: _____ °C

Relative humidity of air: _____ %

Surface temperature: _____ °C

Dew point: _____ °C

.....
DATE: ____ / ____ / ____

Varnish Type: _____

Batch: _____ Expiry date: ____ / ____ / ____

Time: ____ : ____ Room temperature: _____ °C

Relative humidity of air: _____ %

Surface temperature: _____ °C

Dew point: _____ °C

.....
DATE: ____ / ____ / ____

Varnish Type: _____

Batch: _____ Expiry date: ____ / ____ / ____

Time: ____ : ____ Room temperature: _____ °C

Relative humidity of air: _____ %

Surface temperature: _____ °C

Dew point: _____ °C

.....
DATE: ____ / ____ / ____

Varnish Type: _____

Batch: _____ Expiry date: ____ / ____ / ____

Time: ____ : ____ Room temperature: _____ °C

Relative humidity of air: _____ %

Surface temperature: _____ °C

Dew point: _____ °C

THICKNESS CONTROL RECORD SHEET

VARNISHING

JOB: _____

DATE: _____ / _____ / _____

Varnish Type: _____

Sample 1: Thickness _____ μm

Sample 2: Thickness _____ μm

Sample 3: Thickness _____ μm

Sample 4: Thickness _____ μm

Sample 5: Thickness _____ μm

Sample 6: Thickness _____ μm

Sample 7: Thickness _____ μm

Sample 8: Thickness _____ μm

Sample 9: Thickness _____ μm

Sample 10: Thickness _____ μm

NB:

Varnishing with HEMPACRYL SOLFIX 26P02 VARNISH,
Minimum thickness of layers (3) and (4): 40 μm .

PAINTING OR VARNISHING CONDITIONS:

The Viroc panels must be completely dry.

Room temperature must be between 5°C and 30°C.

The relative humidity of the air will have to be less than 80%.

Painting or varnishing cannot be performed if it is foggy or raining.

The system can only be applied if the surface temperature of the panels is at least 3°C above the dew point.

		Room Temperature [°C]							
		0	5	10	15	20	25	30	35
Relative Humidity[%]	80								
	75		1.0	5.8	10.7	15.5	20.4	25.2	
	70		0.0	4.8	9.6	14.5	19.3	24.1	
	65		-1.0	3.8	8.6	13.3	18.1	22.9	
	60		-2.1	2.6	7.4	12.1	16.8	21.5	
	55		-3.3	1.4	6.1	10.7	15.4	20.1	
	50		-4.6	0.0	4.7	9.3	13.9	18.5	
	45		-6.0	-1.5	3.1	7.7	12.2	16.8	
	40		-7.6	-3.1	1.4	5.9	10.4	14.9	
	35		-9.3	-4.9	-0.5	4.0	8.4	12.8	
	30		-11.3	-6.9	-2.6	1.8	6.1	10.5	
	25								

Table No. 1 – Calculation of Dew Point [°C]

Example:

The dew point for a temperature of 25°C and relative humidity of 65%, is 18.1°C. Varnishing can only occur if the surface temperature of the panels is greater than 21.1°C (18.1+3.0).