

P/N:

N/A

DESIGNATION

N/A

Prepared by: Marta Guerrero Ramos

Date: 28-04-2010

Aproved by:

Date: 09-06-2010

DESCRIPTION:

PREPARATION AND APPLICATION OF CHO-SHIELD 2002 (IFMA 389, IFMA 447-40, IFMA 310)

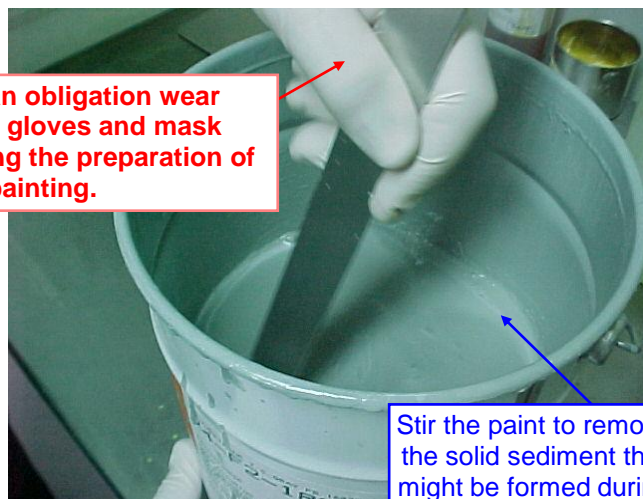
Verify compliance with the ambient conditions in the storage room and paint mixing. And verify that the shelf life of material hasn't expired.

Shake component A (filled resin) for 3 minutes

Temperature: 10°C-30°C
Relative humidity: 40%-70%

It is an obligation wear latex gloves and mask during the preparation of the painting.

The door of the paint preparation box should be closed. Check that the cooling and ventilation systems of the paint box are working.



Stir the paint to remove the solid sediment that might be formed during the storage.

Proportions by weight

		Ratio
Base:	2002 / A	100 g
Hardener:	2002 / B	10,34 g
Thinner:	2002 / C	42,18 g

BASE	HARDENER	THINNER
100	10,34	42,18
50	5,17	21,09
25	2,585	10,545
10	1,034	4,218

The components (base, hardener and thinner) are delivered as kit. Do not mix up several kits each other.

Shake component A (filled resin) for 3 minutes. Pour component C (thinner) into component A and blend again for 3 min. Add component B (hardener) and mix compound for 3 minutes.

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At 20°C, "Pot life" of CHO-SHIELD is **2 hours** maximum.

Add thinner to get the right viscosity with Afnor Cup nº 4 (16-19 seconds at 20°C)

The time of mixing and the lifetime should be reported on all pots.

The mixture must be rejected when their "Pot life" has expired.



Painter is the responsibility of checking the viscosity of the mixing.



Clean the cover and the seating area to close.

Fill out all data required in Mixing Register:



- a) Mixing number
- b) Paint Type
- c) Batch number
- d) Batch expiry date
- e) Mix ratio
- f) Date / time of mixing
- g) Pot life expiry time
- h) Relative humidity
- i) Temperature
- j) Maturing time of paint
- k) Viscosity
- l) Operator number or operator name

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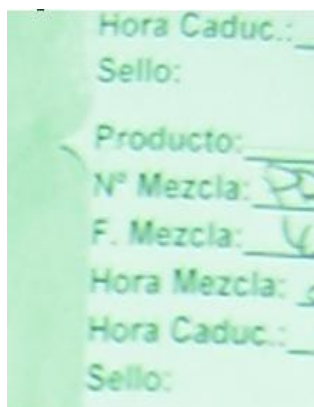
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Each pot of mixed material shall be identified with:

- Product
- Mixing number
- Date of mixing
- Time of mixing
- Pot life expiry time
- Seal

Before application, it is highly advised to **filter the mixing**.



Fill out all data required in Application Register:

- Mixing number
- Date / Time of application start
- Product
- Touch-up
- Paint type
- Relative Humidity
- Temperature
- End time of application
- Time of application start drying
- End time of application drying
- Drying temperature
- Operators (painter) sign
- Verification of thickness and paint adhesion
- inspectors

Apply the mixture in two coats.

Time between coats: 15 minutes

Thickness of dry film is **60-120 µm**

Application is done with nozzle diameter between 1.2 mm and 1.6mm, air pressure: 3 to 5bars.

Between each coat, thoroughly blend compound remaining in gun.

Drying conditions at 20°C:

Tack-free	30 min
Touch dry	1 hour
Maskable (adhesive tape)	24 hours

Completely dry 7 days or 3 days at 45°C