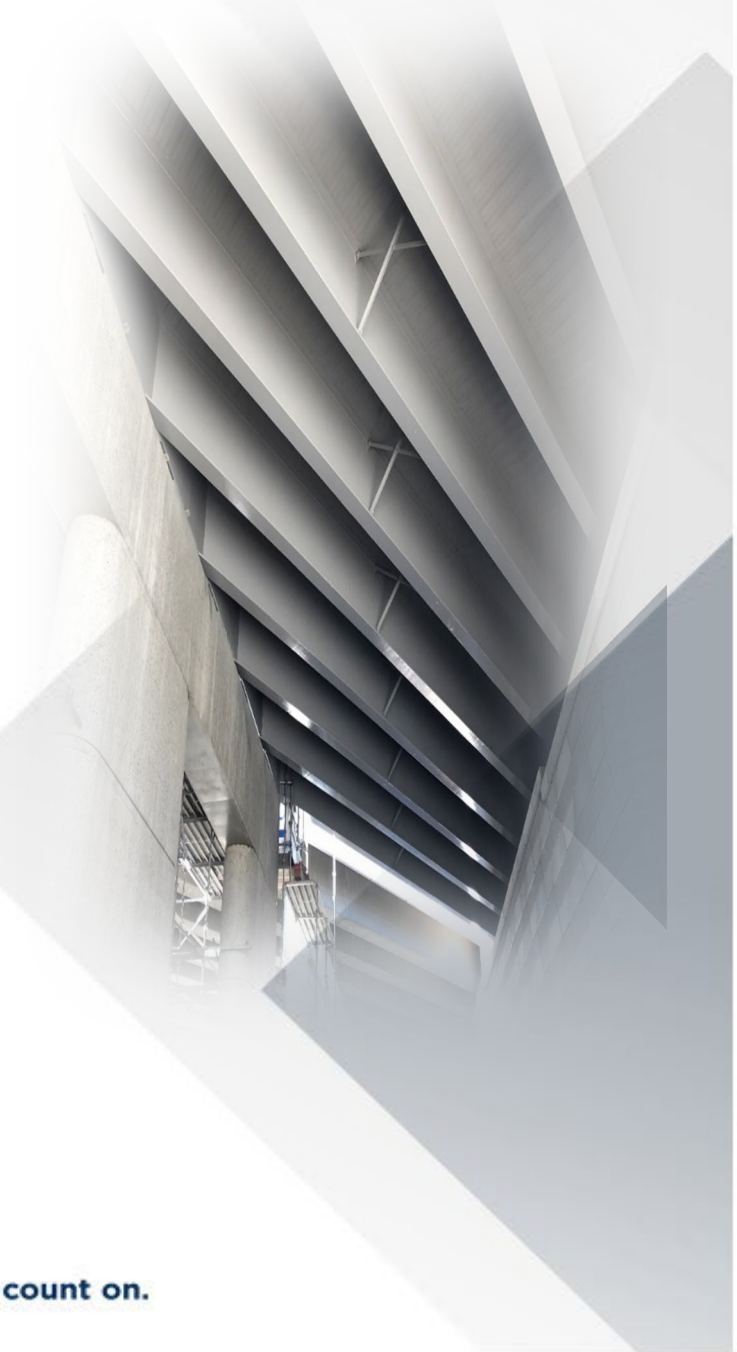
Dulux PROTECTIVE COATINGS

Dulux Protective Coating System Specifications for

MT. MACEDON MEMORIAL CROSS BALUSTRADE

Prepared for:

Name: Lucy Griffith
Company: Conservation Studio
Phone:
Email:
Project Address: Mt. Macedon, Victoria
Specification No: V24/685
Version Number: 1



Prepared by:
Name: Daniel McKeown
Company: Dulux Protective Coatings
Phone: 0423 024 287
Email: **daniel.mckeown@dulux.com.au**
Reviewed by: Chris Eldred
Date of Issue: 29/10/2024

Doc Version: 27/05/2024

Protection you can count on.

MT. MACEDON MEMORIAL CROSS BALUSTRADE

Table of Contents

MT. MACEDON MEMORIAL CROSS BALUSTRADE

Schedule of Coating Systems

Item	Substrate	Specification No.	Colour
New external galvanised steel surfaces	Galvanised Steel	**V24/685 /A**	To approved standard

Specification Document No. V24/685 /A

PROJECT: MT. MACEDON MEMORIAL CROSS BALUSTRADE	
SITE	**Mt. Macedon, Victoria**
EXPOSURE	AS/NZS 4312:2019 Category C2 (low corrosivity)
SUBSTRATE	Galvanised Steel
ITEM	New external galvanised steel surfaces
SCOPE	To provide long term aesthetic protection to new external galvanised steel surfaces.
REFERENCE	Meets AS2312.2:2014 System 4D

Surface Preparation

PREFERRED PREPARATION FOR GALVANISED STEEL: Remove grease, oil and all other contaminants in accordance with AS1627.1. If solvent cleaning is used, a recommended solvent is Duthin 020. If an alkaline detergent is to be used, a recommended detergent is Gamlen CA 1 and then rinse thoroughly with potable water. Repeat until the surface is clean. Follow all manufacturer's written instructions and all safety warnings. Dry abrasive sweep (brush) blast clean in accordance with AS 2312.2:2014, Section 7.5.3 with non metallic media to remove oxides and surface contamination and to lightly profile the surface taking care not to fully remove the galvanising layer. The brush blasted surface should appear uniformly dull with a surface profile suitable for coating adhesion.

Remove all spent abrasive and residual dust by dry compressed air, vaccuum or sweeping with a clean brush. Avoid handling brush blasted galvanised steel with bare hands. Inspect the surface prior to application to ensure a clean and defect-free surface, otherwise rectification is required before any coating is applied. Apply initial coating within 4 hours and before any surface deterioration occurs. All edges, bolts, nuts and difficult to coat areas require extra brushing-in & stripe coating to achieve adequate coating thicknesses.

PROFILE: Minimum 10 microns; Maximum 30 microns

Coating System

	Material	Product	Catalyst	Data Sheet	Thinner	Application	% Vol Solids# Spread Rate	Film Build	WFT**	DFT*
1st Coat	**DUREBILD STE**	**775-LINE**	**976-84539**	**PC565**	**EPOXY THINNER**	**B, R, CS or AS**	84%	MIN (REC)	185µm	**150µm**
							5.6 m²/l @ 150µm	MAX	240µm	**200µm**
				Min recoat time = 14 HOURS			**Max recoat time = 5 DAYS**			
2nd Coat	**DUREBILD STE**	**775-LINE**	**976-84539**	**PC565**	**EPOXY THINNER** 920 08925	**B, R, CS or AS**	84%	MIN (REC)	185µm	**150µm**
							5.6 m²/l @ 150µm	MAX	240µm	**200µm**
				Min recoat time = 14 HOURS			**Max recoat time = 5 DAYS**			
3rd Coat	**WEATHERMAX HBR**	**770-Line**	**976-84593**	**PC 405**	**DUTHIN 040** 965 42166	**B, R, CS or AS**	70%	MIN (REC)	115µm	**75µm**
							9.3 m²/l @ 75µm	MAX	180µm	**125µm**
				Min recoat time = 10 HOURS			**Max recoat time = 3 DAYS**			
4th Coat	**None**							MIN (REC)		
								MAX		
				Min recoat time =			**Max recoat time =**			

AAS = Air Assisted Spray, AS = Airless Spray, B = Brush, CS = Conventional Spray, HVLP = High Volume, Low Pressure Spray, R = Roller, T = Trowel
* If application is by brush or roller, further coats may be necessary to achieve the recommended DFT and full opacity.
** WFT is thickness of wet paint required to achieve the specified 'Dry Film Thickness' assuming no thinner is added. # %Vol Solids is of untinted White or Light Base
Dry & Recoat times apply to a single coat at 25ºC and 50% Relative Humidity. Dry times are longer at lower temperatures and/or higher humidity.

Specific Recommendations and Comments

The DFT of galvanising will vary depending in the gauge of steel, therefore DFT readings must be taken and recorded prior to application of coating in order to obtain accurate measurements of the individual coats and total paint system applied.

The use of Weathermax Part C Accelerator is permitted and recommended within this specification to improve drying times, resistance to moisture and throughput.

All products must be applied strictly in accordance with this specification and relevant Product Data Sheets and SDS (available from www.duluxprotectivecoatings.com.au) by experienced applicators. The applicator must ensure that all colours supplied match the approved standard prior to commencement. Specification details (such as hardener choice) depend on climatic conditions at application time and should be reviewed with your Dulux Representative prior to application. The asset manager is responsible for verifying the presence of lead and determining whether to remove or encapsulate; if lead is present, a customised specification must be obtained from Dulux Australia, and the work done in strict accordance with AS 4361 Parts 1 and 2 and Worksafe Australia guidelines.

Dulux Contacts

PREPARED BY: **Daniel McKeown** PHONE: **0423 024 287**

REVIEWED BY: **Chris Eldred** DATE: 29-Oct-24

Disclaimer

Please ensure you have read and understood the Disclaimer and all Explanatory Notes within this specification. Refer to the Explanatory Notes Page.

DULUX PROTECTIVE COATINGS SPECIFICATION

Project:	MT. MACEDON MEMORIAL CROSS BALUSTRADE

SPECIFICATION NO.	V24/685

Explanatory Notes

1 This specification should only be carried out by applicators experienced in applying these products.

2 This is an abridged specification and must be read and carried out according to the relevant product data sheets, detailed application instructions, Conditions of Specification, safety data sheets and relevant Australian Standards whether attached to this document or not.

3 All products must be applied strictly in accordance with the specification and relevant Product Data Sheets and SDS available from www.duluxprotectivecoatings.com.au.

4 The applicator must ensure that all colours supplied match the approved standard prior to commencement.

5 The use of a thinner other than that nominated herein must not be used without the written consent of your Dulux Protective Coatings Representative.

6 The coating should be protected from the elements and contamination during coating cure to achieve optimum performance and aesthetics.

7 System service life is dependent upon conditions.

8 Pay particular attention to edges to prevent edge corrosion. Sharp edges must be mechanically ground off to a minimum of 2mm radius. Edges must be stripe coated to achieve recommended DFT for optimum service life.

9 Practical spreading rates will vary from quoted theoretical figures depending on substrate roughness and porosity, overspray losses, application methods and environmental conditions (e.g. wind, temperature, humidity, etc).

10 Application techniques should be adjusted, or additional coats applied, in order to achieve the specified DFT. Thus if application is by brush or roller, additional coats are usually required to achieve the specified DFT.

11 Dry times apply to a single coat at 25ºC and 50% Relative Humidity. Dry times are generally longer at lower temperatures and/or higher humidity.

12 Do not apply paint if Relative Humidity is above 85% or if the surface temperature exceeds the maximum quoted on the technical data sheet or is within 3ºC of Dew Point.

13 Do not apply paint if the surface temperature is below 10ºC or likely to fall below 10ºC during the curing period unless otherwise stated, either in the data sheet or by your Dulux Protective Coatings Representative.

14 The specification(s) in this document have been selected by Dulux as being suitable for this project based upon the information given to Dulux by the customer or customer's authorised agent at the time of issue. Changes to the exposure environment and conditions, or changes to chemicals or their concentration in contact with the coating(s) may also change the expected performance of the coatings specified.

15 Specification details (such as choice of hardener) depend on several assumptions (such as climatic conditions at time of application). Dulux suggests that you review this specification with your Dulux Representative prior to application.

16 The asset manager is responsible for verifying the presence of lead and determining if removal or encapsulation is justified. If lead is present, the work shall be carried out in strict accordance with AS 4361 Parts 1 and 2 and Worksafe Australia guidelines.

17 Prior to a Project commencing, a Dulux representative must be notified in advance that a Dulux Coating System will be applied to the Project and a Warranty will be required. No Warranty will be issued if Dulux is notified after the commencement or completion of a Project

18 This specification is not a warranty document. A draft warranty document should be obtained from Dulux along with the specification prior to the work commencing.

Additional Notes common to all Specifications for this Project

Ensure that the recoat window is strictly adhered to for optimum intercoat adhesion. If topcoating outside the recoat window, the previous coating must be thoroughly abraded to provide the maximum intercoat adhesion possible.

Dulux recommends that chromate quenching not be used for surfaces that are to be painted.

The Applicator shall maintain records in accordance with AS3894 Parts 10, 11, 12, 13 & 14 or as required by the Project Manager. These records shall be made available for inspection at any time by the Project Manager or authorised Representative and submitted to the Principal Contractor upon completion of work.

Dulux Contacts

PREPARED BY:	**Daniel McKeown**	PHONE:	**0423 024 287**
REVIEWED BY:	**Chris Eldred**	DATE:	**29-October-2024**

Disclaimer

DULUX is a Quality Endorsed Company - International Standards ISO9001, ISO9002 & Australian Standards AS3901, AS3902.

DuluxGroup Australia Pty Ltd. A.B.N. 67000049427

DULUX PROTECTIVE COATINGS SPECIFICATION

Project:	MT. MACEDON MEMORIAL CROSS BALUSTRADE

SPECIFICATION NO.	**V24/685**

Additional Notes common to all Specifications for this Project

The coating shall be free from sagging, streaking, runs, dry spray, mud cracking and foreign bodies when viewed by the naked eye.

All areas damaged through handling, transportation and installation must be reinstated to the specified thicknesses. (Refer to the Coating Repair Guidelines in this specification for rectification details)

Dulux Contacts

PREPARED BY:	**Daniel McKeown**	PHONE:	**0423 024 287**
REVIEWED BY:	**Chris Eldred**	DATE:	**29-October-2024**

Disclaimer

DULUX is a Quality Endorsed Company - International Standards ISO9001, ISO9002 & Australian Standards AS3901, AS3902.

DuluxGroup Australia Pty Ltd. A.B.N. 67000049427

DULUX PROTECTIVE COATINGS SPECIFICATION

Project:	MT. MACEDON MEMORIAL CROSS BALUSTRADE

SPECIFICATION NO.	**V24/685**

Coating System Repair Procedure Notes

1 **General Comments:** As a general guide, for items where a high level of aesthetic finish is required, all repairs should be kept to a minimum in surface area, ie feathered out to approximately 10mm around the damaged area. A small brush may be necessary to apply the repair coats.

If the defects are numerous and scattered, it is recommended to apply the topcoat to a break (ie a weld or edge). Full lengths of beams and columns may need to be painted to ensure a uniform and even appearance. To achieve opacity and sufficient dry film thickness, multiple coats may be required of each layer.

2 **If only the finish coat has been damaged:** In the areas where only the finish coat is damaged, these areas are to be thoroughly washed to remove all surface contamination [refer AS 1627.1]. Damaged areas are to be hard sanded to remove any damaged coating and ensure all edges are feathered. Adjacent surfaces around the damaged area are also to be sanded to provide a key for the subsequent coatings. If the finish coat is outside its recoat window, a coat of primer will need to be applied. The finish coat is to be applied as per the original specification with the correct film thickness being achieved. The finish coat shall be applied to the next natural change of direction or where the recoating will not be noticeable. A minimum of 50mm overlap onto sound coating is required. Note: Brush and roller application will require multiple coats to achieve the specified dry film thickness in the original schedule. Refer to the original system for guidance on sequence and target film thicknesses.

3 **If the finish and intermediate coats have been damaged:** In the areas where the damage is back to finish and intermediate coats, these areas are to be thoroughly washed to remove all surface contamination [refer AS 1627.1]. Damaged areas are to be hard sanded to remove any damaged coating and ensure all edges are feathered. Adjacent surfaces around the damaged area are also to be sanded to provide a key for the subsequent coatings. The intermediate and finish coats are to be applied as per the original specification with the correct film thickness being achieved. The repairs shall be applied to the next natural change of direction or where the recoating will not be noticeable. A minimum of 50mm overlap onto sound coating is required. Note: Brush and roller application will require multiple coats to achieve the specified dry film thickness in the original schedule.

4 **If all layers in the system have been damaged:** In the areas where the damage is through all coats in the system, these areas are to be thoroughly washed to remove all surface contamination [refer AS 1627.1]. Damaged areas are to be hard sanded to remove any damaged coating and ensure all edges are feathered. Adjacent surfaces around the damaged area are also to be sanded to provide a key for the subsequent coatings. The primer, intermediate and finish coats are to be applied as per the original specification with the correct film thickness being achieved. The repairs shall be applied to the next natural change of direction or where the recoating will not be noticeable. A minimum of 50mm overlap onto sound coating is required. Note: Brush and roller application will require multiple coats to achieve the specified dry film thickness in the original schedule.

5 **If the damage is back to the substrate:** In the areas where the damage is back to the substrate, these areas are to be thoroughly washed to remove all surface contamination [refer AS 1627.1]. Substrate spot repairs need to be carried out to the originial specification. Refer to the specification writer if further clarification is required. Damaged areas are to be spot prepared using relevant power tool cleaning techniques. Existing coatings should be hard sanded to remove any damaged coating and ensure all edges are feathered. Adjacent surfaces around the damaged area are also to be sanded to provide a key for the subsequent coatings. The primer, intermediate and finish coats are to be applied as per the original specification with the correct film thickness being achieved. Any bare steel areas must be spot primed within 4 hours of surface preparation completion. The repairs shall be applied to the next natural change of direction or where the recoating will not be noticeable. A minimum of 50mm overlap onto sound coating is required. Note: Brush and roller application will require multiple coats to achieve the specified dry film thickness in the original schedule.

6 **Note: These recommendations are for general atmospheric service systems. If the exposure is related to immersion, chemical service a specific site refurbishment specification should be requested from the specification writer. For repairs on intumescent coating refer to point 16 on the page of intumescent coatings notes in this specification.**

Additional Coating Repair Notes

All areas damaged through handling, transportation and installation must be reinstated to the specified thicknesses. (Refer to the Coating Repair Guidelines in this specification for rectification details)

Specification conformance requires the dry film thickness targets to be met, NOT the number of coats applied. If the nominated dry film thickness for each coat in above table is not achieved in a single application, additional coats MUST be applied to ensure that the specified film thickness for each coat is achieved. Inadequate film thickness of one coat in the system cannot be rectified by increasing the thickness of successive coats in the system.

The DFT of the existing coating system will vary, therefore DFT readings must be taken and recorded prior to application of coating in order to obtain accurate measurements of the individual coats and total paint system applied.

Dulux Contacts

PREPARED BY:	**Daniel McKeown**	PHONE:	**0423 024 287**
REVIEWED BY:	**Chris Eldred**	DATE:	**29-October-2024**

Disclaimer

Please ensure you have read and understood the Disclaimer and all Explanatory Notes within this specification. Refer to the Explanatory Notes Page.

DULUX is a Quality Endorsed Company - International Standards ISO9001, ISO9002 & Australian Standards AS3901, AS3902.

DuluxGroup Australia Pty Ltd. A.B.N. 67000049427