

PAINT SPECIFICATIONS**TECHNICAL DATA
SHEET No. 506****PRIME PAINT**

All Republic's doors and frames are thoroughly cleaned and phosphatized prior to painting. The prime paint used on Republic's doors is a Modified Water Based Alkyd melamine primer. Cure after painting is a forced drying via gas fired convection heating. This process assures maximize adhesion, hardness and strength. Republic's primers are capable of meeting the requirements as specified by ANSI A250.10, which, include but are not limited to the following:

ASTM B117	Method of Salt Spray (Fog) Testing (120 continuous hour exposure)
ASTM D4585	Standard Practice for Testing Water Resistance of Coating Using Controlled Condensation (240 continuous hour exposure)
ASTM D2794	Standard Test Method for Resistance of Organic Coatings to the Effects of Rapid Deformation (Impact) (20 in/lbs direct impact)
ASTM D3359	Standard Test Method for Measuring Adhesion by Tape Test

The gloss for Republic's primer is less than 18% reflectance measured using a 60° gloss meter.

FINISH PAINT

All Republic's doors and frames requiring finish paint are primed as specified above then coated with a Modified Water Based Alkyd melamine finish paint. The cure is a combination of Infra-red and gas fired convection heat sources. Republic's finish painted product is capable of meeting the requirements as specified by ANSI A250.3, which include but are not limited to the following:

ASTM B117	Method of Salt Spray (Fog) Testing (120 continuous hour exposure)
ASTM D4585	Standard Practice for Testing Water Resistance of Coating Using Controlled Condensation (480 continuous hour exposure)
ASTM D2794	Standard Test Method for Resistance of Organic Coatings to the Effects of Rapid Deformation (Impact) (20 in/lbs direct impact)
ASTM D3359	Standard Test Method for Measuring Adhesion by Tape Test

The gloss for Republic's finish paint is 20%, ± 5% reflectance, measured using a 60° gloss meter.

Republic's prime paint and finish paint comply with Public Law 91-695, Lead Based Paint.

The spray application is electrostatic by *ITW Ransburg's* Rotary Bells with feedback loops and digital process control. Automated alarms stop the line if the feedback system provides a low or high signal. The finished product is consistently coated with a uniform film build, free of voids or light spots to assure superior performance. This approach assures the most uniform coating available.

Revised 9/14



Primer



No. FP-3 Midnite Bronze



No. FP-4 Cream Buff



No. FP-5 Black



No. FP-7 Stone White

No. FP-9 White

OTHER COLORS ARE AVAILABLE ON REQUEST.

FIELD PAINTING RECOMMENDATIONS

Republic uses an industrial grade primer which is a modified ;water alkyd type product. The primer is intended to protect the surface for a reasonable time -until a finish paint can be applied. The primer also serves as a matrix for subsequent applications of finish paint.

When painting, always clean the product to be free of dirt, rust, debris and oil. A suitable and readily available cleaning product is "simple green" or similar that wipes on. Be sure to wipe dry. Do not let any product remain on the surface. Clean and dry is the basic requirement for paint adhesion.

Do not use lacquer thinner or any solvent that may react on the primer. Never use gasoline, kerosene, a strong base or an acid.

If there is any question about using a particular finish coat over the primed doors or frames, a small section of primed metal should be tested before painting the entire area.

For superior paint adhesion we recommend cleaning and lightly scuff sanding the door or frame to remove any foreign matter that may have accumulated onto the surfaces during construction. Often, scratches and dents will require sanding to metal and recoating with primer. Always use products made for metal substrates with rust inhibitive qualities and direct-to-metal application.

Sprayed, rolled or brushed most paint will adhere to the prime surface if properly cleaned and roughen by scuff sanding. The Direct to Metal products are recommended to avoid rust blooms from the microscopic areas of bare metal that may result during the sanding / cleaning process.

PHOSPHATIZING

A superior prime paint or finish paint process must initiate with a superior pretreat of the surface to be coated.

Republic doors and frames has such a superior pretreat system. During this phosphatizing process, the door or frame is thoroughly cleaned before the phosphatizing agent is applied to the surface.

Phosphatizing is a method of chemically producing a phosphate coating on steel that is composed of millions of microscopic crystals integrated with the metal.

Insoluble in water, this coating effectively retards corrosion resulting from moisture that may penetrate the paint film. It provides a foothold for the paint and prevents flaking or peeling. The phosphatized coating is softer than the base metal and is adherently etched into the metal surface.

NOTE: We reserve the right, without notice, to make changes in specifications, construction, design and details at any time, in such manner as we may consider necessary or advisable. Corrections to reflect any such changes shall be included in subsequent printing of this publication.