

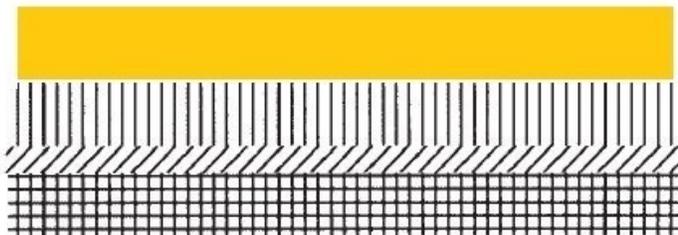
Walls & Imaging System 401-WI

An Economical Single Component Water-Based System for all substrates including wood, masonry, and metal Using *Endura-crylic*

An excellent system for facility branding & wall panels.

Walls & Imaging System 401-WI was developed specifically for re-painting metal, wood and masonry walls and panels. It can be used where spraying hazardous materials on interior substrates is not suitable but good service life is desired. It is an appropriate system for painting over multiple substrates including masonry & wood. It is available in the 24 standard self-storage colors plus unlimited colors can be produced.

This system involves the proper cleaning and preparation of the substrate including the creation of a surface profile on glossy or smooth and slick substrates, and then the application of *Endura-crylic*.



- Endura-crylic Gloss
- Bonding Primer (if Required)
- Existing Coating (if previously painted)
- Metal, Wood or Masonry Substrate

This provides a durable surface that is easily cleaned with water and resists chalking and fading. This economical system comes with a 4-year warranty.

Walls & Imaging System 401-WI Specifications Overview

Average Service Life ----- 4-5 years	Color retention ----- 4
Composition ----- 100% water borne modified acrylic	Gloss retention ----- 3
Reduction ----- Water	Clean-ability ----- 3
VOC Level ----- Less than 100 gpl / .80 lb	Scratch resistance ----- 3
Sheen level ----- Gloss	Hardness ----- 2
Application Temp Range ----- 50°F to 100°F	Chemical resistance ----- 3
Dry to handle ----- 1-2 hour	Corrosion resistance ----- 3
Application process duration - Single day	Ease of application ----- 6
Self-Priming ----- Primer required on new SMP or bare metal	Ease of touch-up ----- 6
Versatility over substrates ---- Self-priming on most previously painted surfaces	
Minimum dry mil thickness --- 2 mil dry	
Cost, material per sq/ft -- As low as \$0.15	

6= Superior, 5= Excellent, 4= Good,
3= Fair, 2= Marginal, 1= Poor

Evaluating surfaces to determine if they are candidates for coating with the Image Walls & Imaging System 401-WI

Walls & Imaging System 401-WI is designed to be applied to substrates that are sound and show no signs of peeling or adhesion failure. If there are any concerns or questions about the surface integrity then an adhesion test should be performed. This can help determine which Walls & Imaging system to use.

Walls & Imaging System 401-WI is designed to be used on most existing previously painted surfaces. Previously unpainted SMP coated doors or doors that are slick or glossy should be primed with Chem-bake Bonding primer. All rusting or exposed bare steel should be spot primed with a corrosion resistant steel primer.

Surface Preparation. Surfaces to be painted should be clean, dry and free from wax, grease, dust, silicone, scaling paint, oil and excessive chalk. Remove rust, loose or peeling paint and all foreign matter.

Clean all surfaces using Sand & Scrub cleaning mixture per label instructions or clean all surfaces with a degreasing agent such as TSP diluted at 8 oz per gallon. Care should be taken to remove lubricant sprayed around door lock areas and vents.

Glossy or smooth hard surfaces must be dulled and/or abraded using Sand & Scrub cleaning mixture, silicon carbide sandpaper, Scotch-Brite® or other abrading medium to de-gloss and create a surface profile. If a complete abrading and de-glossing of the surface is not achieved then *Chem-Bake®* bonding primer should be used.

A completely clean and sound substrate with no dust, chalk, or other surface contaminants must be obtained prior to applying any coating or primer. If dust, chalk, or dirt remains, repeat the cleaning process.

Any coating failure resulting from inadequate surface preparation or failure to follow manufacturer's recommendations and specifications are the sole responsibility of the Contractor to remedy.

Inspection: Inspect the areas to be coated for damage, especially areas like vents and door seals to identify areas where paint could enter the building.

Masking and Protection: Protect all areas not being painted including vents, windows and doors. Seal all areas around the doors to prevent paint from entering building. Check for nearby cars and trucks that might be at risk for overspray.

Environmental Conditions: Don't apply if the air, surface, or material temperature is above 100 degrees. Avoid painting in direct sunlight. Apply in the shade during warmer temperatures. Don't apply when there is a risk of rain or freezing temperatures within 12 hours after application. Don't apply when relative humidity is above 90% or will become so within 2 hours after application. Don't apply when the ambient or surface temperature is within 5 degrees of the dew point. Don't apply if the air, surface, or material temperature is below 50 degrees or if it will become so within 2 hours after application. Don't apply within 2 hours of sunset if the temperature is below 60 degrees.

Avoid spraying in windy conditions to reduce the risk of contaminants adhering to the surface.

Handling: Read all label warnings and data sheets prior to handling any paint or coating! Although the *Endura-crylic* system is considered environmentally friendly when used properly, as with any industrial coating it does contain certain chemicals that can irritate the skin and lungs. Always wear chemical resistant gloves when handling and avoid contact with the skin. Always use a properly fitted respirator that employs chemical cartridges while handling, mixing, or spraying any *Endura-crylic* product. Consult MSDS sheets for further warnings and information on the chemical composition.

Sprayer and Spray Equipment. Use only airless spray equipment that has low pressure capability, either hydraulic or have electronic pressure controls. The sprayer, hoses and gun must be thoroughly clean and flushed with water.

Always use a hose and gun that is dedicated for spraying water based coatings, separate from spraying solvent based products.

Adjusting for Correct Spraying Pressure:

- *Endura-crylic* should be sprayed at the least amount of pressure required to obtain a uniform spray pattern.
- To adjust to the proper pressure, using a NEW tip, back-off the pressure knob all the way and then screw it in about 1/3rd of the way. (Screwing in increases pressure on most sprayers). Point the gun at a piece of cardboard for testing and with your hand in motion, pull the trigger and spray a sample area.
- If you have thick lines at the edge of the spray pattern, sometimes referred to as “tails” or “fingers”, turn pressure knob 1/8 and spray again. Repeat until they are gone. Now you have the proper amount of pressure for the material you are spraying. (If no amount of pressure eliminates the tails, then the tip is worn or damaged).
- If you need more paint flow, increase the size of the tip, not the pressure. There should never be a cloud of spray-mist surrounding the person spraying, a sign of too much pressure!



Application of *Endura-crylic*:

Mixing: Mix contents of each container of *Endura-crylic* thoroughly to assure proper pigment disbursement. Box together all material that will be used that day to assure color consistency from container to container. Normally thinning is not required, however if thinning is needed to help with the application, use cool distilled water only. Reduce in small increments to avoid over-reduction. Do not exceed 5%

***Endura-crylic* Spray Application Method:** Confirm the substrate is clean, free of chalk, and de-glossed per above specifications. If spraying overtop a glossy or hard slick surface, 1st apply a coat of Chem-Bake® bonding primer and allow to dry for a minimum 3 hours.

- *Endura-crylic* should be applied in **two coats** at 3 mil wet per coat (533 sq ft per gallon no reduction) to achieve a minimum 2.5 mil dry film thickness.
- Use a new 2-10, 3-10, or 3-12 double orifice fine finish spray tip. Holding the spray gun approx. 4”, and no more than 6” from the surface, start at the top of the door and spray horizontally across the door following a corrugation “rib”.
- Start your hand in motion first and then pull the trigger. Release the trigger just before you reach the stopping point of your swing. Each pass should extend completely from the wet edge to the old coating.
- Improper technique can lead to “dry-spray” resulting in areas that have a rough texture, and a blotchy/inconsistent look. Always maintain a wet edge and overlap passes by 50%. If “dry spray” does occur, apply a 2nd coat.
- HELPFUL HINT: Keep all fluid lines, spray pump, and material out of the sun. Cooler material flows (smooth’s) out on the surface better.
- The final finish should be smooth and have no pinholes or stippling in the finish which may void the warranty.
- Make a thorough inspection of all painted surfaces. Closely examine top and bottom edges as these are the area’s most commonly prone to holidays. Minor imperfections can be touched up with a high-quality brush. Do not use a roller. Larger areas will need to be re-sprayed.



Incorrect: stipple/orange peel



Incorrect: pinholes



Correct: smooth finish no stipple