

Painting of GRP Distribution Cabinets

Scope: Distribution Cabinets in service or stored under outdoor conditions.

Target: Protective coating to avoid or retard glass blooming on cabinet's external surface.

Method: Painting the cabinets with suitable topcoat paint by brush, roller, air or air-less spraying.

Materials:

1. Polyurethane two components solvent-borne top coat paint suitable for outdoor resistance with Outstanding UV degradation resistance (e.g. car top coat paints).
2. Gap filler polyester has two components for surface repair (e.g. car body filler).
3. Acetone, MEK, or Butyl Acetate as degreaser solvent.
4. Household detergent as cleaner.
5. Scotch Brite or similar pads
6. Abrasive-coated paper 280 grit.
7. Tap water.

Painting Equipment:

According to the paint manufacturer's instructions.

Surface preparation:

CAUTION: BEFORE SURFACE PREPARATION, DISCONNECT ANY ELECTRICITY SOURCE

1. Wash the cabinet with a solution of detergent in tap water (about 2-3 % is enough) using a Scotch Brite pad. Remove posters or other glued materials using suitable tools.
2. Rinse with tap water to eliminate any loose dust and dirt.
3. Dry for 1-5 hours (depending on weather).
4. Repair and fill damaged areas with gap filler. Dry and abrade according to manufacturer instructions.
5. Slightly abrade the whole surface with 280-grit sandpaper to increase roughness.
6. Wipe with a clean cloth soaked with degreaser solvent. Make enough passes with the solvent-moistened cloth to remove all traces of contamination. After the final pass wipe with a dry cloth.
7. Cabinet is now ready to be painted.

**CAUTION: USE PROTECTIVE EQUIPMENT FOR HANDS, EYES AND RESPIRATORY TRACT PROTECTION.
THIS OPERATION INVOLVES THE USE OF FLAMMABLE MATERIALS.**

Painting the cabinet:

Follow topcoat paint manufacturer instructions for mixing, thinning, application and curing.

Inspection

Visual inspection: a smooth area without dirt, finger prints, porosity, liquidity, bubbles, or unstable plating.

Adhesion examination: conducted according to DIN 53151, on emitted a testimony when the requiring a rating of at least Gt1.

Examination of dry layer thickness: 20-50 microns.