

Procedure for surface preparation and painting of control panel

Material - Aluminium panel.

Painting Procedure:-

1. Chromatization of panel.
2. Wire brushing and abrading with emery paper.
3. Degreasing and drying.
4. Abrading with emery second time.
5. Application of etch primer. Base and hardener to be mixed in the ratio of 1:1 by volume
 - No. of coats -1
 - DFT: 10 microns (for each coat)
 - Minimum time for drying is 3-4 hours after application of etch primer.
6. Before application of zinc chromate primer Aluminium dust should be air blown.
7. Application of zinc chromate primer
 - No. of coats -2
 - DFT: 35-40 microns (for each coat)
 - Minimum time for drying is 16 hours after each coat of zinc chromate primer.
8. Application of fire retardant enamel pista green.
 - No. of coats -2
 - DFT: 35-40 microns (for each coat)
 - Minimum time for drying is 16 hours for each coat.

Note:

1. Photographs of the job at every stage of operation (i.e. before and after) are to be taken for record and verification.
2. Record the thickness reading after every operation (in microns) with date and time stamp.

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