

Guideline Instructions

For the spray application of Delvemade Delcote Architectural Silicone Coatings

Warning

The information supplied is to complement other information such as COSHH and spray equipment instruction data. Read all safety data, COSHH data and all spray equipment operator instructions before application.

Injection injury

Read all information regarding avoiding injection injury and the dangers of injection injury. Get into the habit of applying the safety catch when there is a pause in the spray application. Ask your spray equipment supplier about procedures to avoid injection injury.

Avoiding static sparks

All spray equipment should be earthed when using solvent based materials. Static build-up may cause static sparks capable of igniting solvent based materials. Ask your spray equipment supplier about procedures to avoid static build-up.

Important Information

This product is for application by professional applicators only. For health and safety reasons and dangers of high pressure injection injury, it is recommended that only trained personnel should attempt to apply these products. Spraytrain.com, can provide full and comprehensive training on the use of Delvemade silicone spray grade Delcote products.

Spray trials were undertaken using Delcote Albany & Slate colours. These recommendations will also be suitable for the spray application of most other Delcote colours including:- Goosewing Grey, Chocolate Brown and Mushroom. The colour containing metallic flake additions (Delcote Silver) require modified recommendations. If using Delcote Silver refer to Delvemade or Giromax Technology for further advice.

Delvemade Delcote Architectural Silicone Coating

Typical specification:

Petrol powered self-contained airless spray units

Graco Gmax 7900 petrol powered airless spray unit fitted with a 60 mesh filter (black), 100 foot 3/8" nylon braided hose, 42" nylon braided whip hose, compatible airless spray gun (remove any spray gun filters), XHD-519 spray tip.

Atomising pressure at gun :- 2000 psi – 2400 psi

Pressure loss with the above setup :- approximately 700-800 psi
Note: pressure loss can be dramatically reduced by removing the whip hose or using shorter hoses than the 100 foot used in the trial.

Air powered airless spray units

Graco NXT 45:1 or 60:1 NXT or King fitted with 60 mesh filter, 150 foot, 3/8" fluid hose, 6 foot whip hose, pressure compatible airless gun, XHD 519 tip, atomising pressure 2000 - 2400 psi, 1580 psi pressure drop, pressure at pump 3784 psi.

Compressor for air powered units

To power the above air powered unit, an air compressor of at least 150 cubic feet per minute (CFM) free air delivered (FAD) is required. Air supply hoses should be at least 3/4" internal diameter.

Material preparation

Remove any skin that has formed on the surface of the product before thoroughly stirring or agitating. If a powered agitator is used, avoid fast revolutions and do not allow the blades of the agitator to break the surface of the material. This will aerate the material and render it useless for airless spray application.

Flushing

It is recommended that all spray equipment be thoroughly flushed after use with recommended solvents (T503 Line Cleaner).

Purging

When using Albany (or colours as above) all the spray equipment should be purged with material for approximately 5 minutes per 50 foot of hose with the spray tip assembly removed. This will reduce the possibility of any tip blockages and save time during application.

Pressure Drop

Pressure drop can be affected by various factors including temperature, increased flow rate by using larger or worn tips other than those specified, longer or narrower hoses than the ones specified.

Injection injury

High pressure fluid injection injury can occur if any part of the body is placed in front of the spray tip or fluid leak during spray application or flushing procedure. Any such injury should be treated as an emergency and any operative suspected of receiving injection injury should be taken immediately to the accident and emergency department at the nearest hospital, along with health and safety data sheets on the material. It is recommended that contractors should have in place a procedure to deal with any injection injury incident.



Delvemade Limited

Specify our products by name

• Seamsil • Delcote • Delcote HPG • Delglaze

Technical Data

Delvemade Delcote - Architectural Coatings

Atomising pressure (at the spray tip)	2000 psi – 2400 psi
Spray tip aperture	0.019" (19 thou)
Spray fan angle	50 degrees
Viscosity (for pressure loss calculations) Albany	19 poise, Slate 22 poise,
Filter mesh size	60 American mesh
Filter Graco colour code (petrol units)	Black

The information in this document supersedes and replaces all previous technical information. Please do not add or change any of the information provided without first consulting Delvemade.

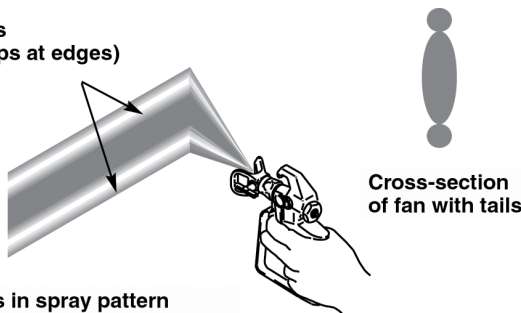
All trials have been carried out at 15 degrees centigrade. If spraying at temperatures below 15 degrees centigrade, shorter fluid hoses may be necessary to achieve atomisation.

Atomising pressure

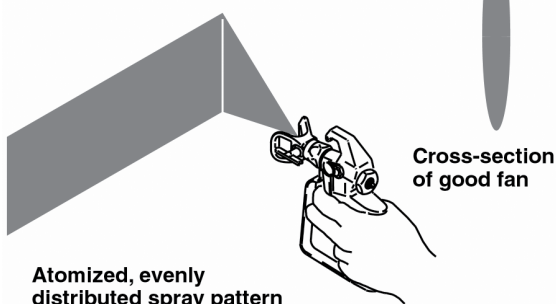
Atomising pressure is the fluid pressure required at the tip to completely atomise the material with no "tails" or "fingers" visible in the fan pattern. This may vary with weather conditions and tip wear. Remember to set the pressure just high enough to eliminate "tails" and "fingers".

Tip wear

tails
(gaps at edges)



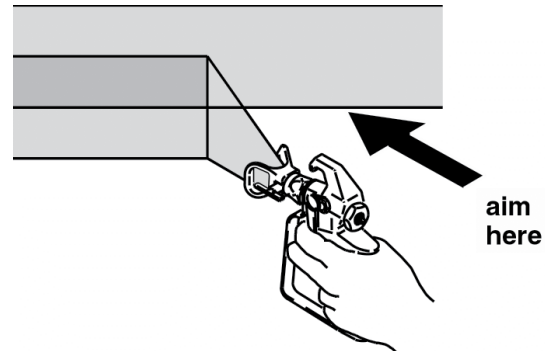
Tails in spray pattern
from low pressure



Spray tip wear is common with airless spray applications and any wear should be monitored and spray tips should be replaced when necessary. Using worn spray tips will increase pressure losses in spray hoses as well as applying heavier than recommended film thicknesses.

Spray method

To ensure a regular and even application, a 50% overlap is recommended (as illustrated below). The spray passes should be even. It is important to frequently check the wet film thickness throughout application.



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3. Spraytrain.com

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4. Sprayplant Limited

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Cutting Edge Technology

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