

How to paint PECOLIT flat sheets

Whether for decorative purposes, additional surface protection or in case of repairs, PECOLIT products with or without gelcoat can be painted with standard 2-component PUR or acrylic finish. The fact that PECOLIT is manufactured without wax or release agents minimizes cleaning effort and makes painting the surface easy (and enhances the quality of the finish).

Painting for surface sealing

Do you require special surface protection against the weather and are you planning a coat of paint? Choose a PECOLIT product with a gelcoat surface. The isophthalic acid resin used for the gelcoat already provides the protection you need. For PECOLIT products without gelcoat, you can find appropriate painting recommendations below.

Paint in fleet or logo colors, or for decorative purposes

Since PECOLIT offers flatsheet delivery in almost all available RAL colors, you can usually do without painting. (Contact our sales staff for special colors for your desired product.) In case of a multi-color finish, the paintwork on the body can easily be done by a specialized painting business or in a suitable workshop at your company.

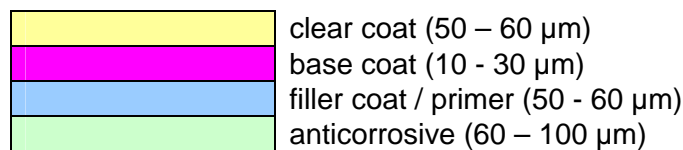
Paint in case of repairs

In our applications technology section we provide detailed (downloadable) information for repairs.

Paint layers with basecoat and clear coat

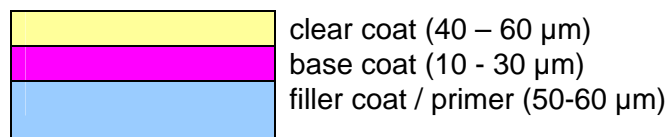
Standard paint layers for steel or aluminum sheets

fig 1:



Paint layers with PECOLIT products

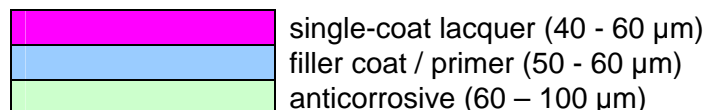
fig 2:



Paint layers with single-coat lacquer

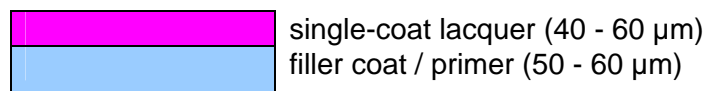
Standard paint layers for steel or aluminum sheets

fig 3:



Paint layers with PECOLIT products

fig 4:



With FRP it is possible to omit the anticorrosive layer needed for metal painting, which saves not only the material but also the time that would otherwise have been spent on the anticorrosive layer. It is worth mentioning, especially given current concerns about the environment, that this reduces thinner emissions and energy resources. Also worth mentioning is the fact that fillers, base coats and clear coats are now made of water-soluble or low solvent systems.

Painting procedure for PECOLIT products

The crucial precondition for a technically and visually flawless finish is cleaning and pre-treatment of the surface to be painted. You should always begin by cleaning the surface with standard solvent cleaning agents. When using fluids to clean surfaces, drying time is important in order to guarantee complete and residue-free evaporation. After that, gentle sanding of the surface with sandpaper or abrasive pads of increasingly fine grain followed by removal of any dust produced during sanding provides a perfect surface for painting. Unlike other plastics of low surface energy, PECOLIT flatsheets do not require the application of an adhesive agent. Primer and/or filler coat can be applied prior to the top coat in order to enhance the visual characteristics, but this is not a mandatory step. According to the manufacturer's instructions, elastification agents should be added to the paint you use. This brings the flexibility of the paint layer into line with the flexibility of the FRP. The 2-component top coat or base coat with clear varnish can dry overnight at room temperature or alternatively can be speed-dried in a drying chamber at 60 - 80°C (140 – 176° F). With this method, please ensure steady temperatures in order to avoid a possible warping of the parts.

The following points apply for any paint work:

- Painting requires a clean and dust-free work environment
- Silicones are among the main enemies of successful painting (Be aware of hidden silicones, for example in body care products such as hairspray or skin creams)
- Provide good and draft-free ventilation in the painting environment
- Be aware of the manufacturer's instructions concerning the mixing ratio
- Drying temperature must be below 80°C (176° F) (danger of "paint pops" and warp)
- Varnishing with 2-component paint from the bodywork sector is generally preferable. 1-component systems are less resistant to weather and UV light than 2-component systems.
- Work with coordinated paint and painting appliances

There are restrictions on how PECOLIT saf@fire should be painted. In order to preserve and ensure its fire-resistant quality, this product should not be re-coated with standard paint. If painting is absolutely necessary, you should use suitable fire-resistant paint products.

The following PECOLIT materials do not necessarily require a primer: Gelcoated material, such as PE-GE, PE-X2t, and PE-NT2. Due to its surface structure, PE-EMGE can only be painted without prior sanding.

PECOLIT material without gelcoat layer – such as PE-ST or PE-SP – must not be sanded with harsh abrasives before painting, as the removal of too much material can expose the unavoidable air pockets that are found in the laminate. These can cause pinholing or bubbles in the painting process. For painting material without gelcoat, we recommend gentle sanding with Scotch-Brite.