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CELWAVE

PAINT

PROCEDURES

POLANE T-PLUS

FOR EXTERIOR USE
ON ANTENNAS INCLUDING RADOMES

NEW - MEETS EPA VOC REQUIREMENTS
UNDER 3.5 VOC

CELWAVE RF MARLBORO NJ 0774

PROCEDURE FOR SPRAY PAINTING ANTENNA PARTS USING SHERWIN WILLIAMS **POLANE T PLUS** URETHANE PAINT

PROCEDURES

POLANE T PLUS
ON BARE ALUMINUM, STAINLESS STEEL, GALVANIZED STEEL

STEP 1 The surface must be clean, oil free and dry. If necessary. clean with a suitable solvent.

STEP 2 Prime with **P60 G 2 WASH PRIMER** catalyzed and reduced with **R7 K 44 CATALYST/ REDUCER** (1 TO 1-1/2)

Apply one light coat to about 0.3 mils dry thickness. Working pot life is about 4 hours.

STEP 3 Allow prime coat to dry 10 to 20 minutes, but not over one hour. (If prime coat is not topcoated within one hour, apply another prime coat after the first prime coat has dried for four hours.)

STEP 4 Topcoat with one coat of **POLANE T PLUS URETHANE PAINT** of the proper color, prepared as follows:

4 parts **POLANE T PLUS URETHANE PAINT**
1 part **V66 V 29 POLANE EXTERIOR CATALYST**
1 part **R7 K 84 POLANE REDUCER**

Apply 1-1/2 to 2 mil dry film thickness.
Working pot life is 4 hours at 77 F°

Note - Must keep the reducer in the same percentage as above or it will not meet EPA restrictions on Volatile Organic Compounds (VOC)

STEP 5 Dry overnight. (Allow two hours before handling)

DO NOT PACKAGE IN AIR TIGHT PLASTIC BAGS. **POLANE T PLUS** REQUIRES SEVERAL WEEKS TO RELEASE ORGANIC SOLVENTS BEFORE BECOMING COMPLETELY CURED. THE BUILD UP OF THESE SOLVENTS COULD CAUSE IMPROPER CURE AND ADHESIVE FAILURE IN USE.

POLANE T PLUS
ON ALUMINUM WITH CHROMATE CONVERSION FINISH
(Chem Rite, Alodyne, Iridite)

STEP 1 The surface must be clean, oil free and dry. If necessary. clean with a suitable solvent.

STEP 2 **POLANE T PLUS** does not require a primer on Chromate Conversion finish.

STEP 3 Topcoat with one coat of **POLANE T PLUS URETHANE PAINT** of the proper color, prepared as follows:

4 parts **POLANE T PLUS URETHANE PAINT**
1 part **V66 V 29 POLANE EXTERIOR CATALYST**
1 part **R7 K 84 POLANE REDUCER**

Note - Must keep the reducer in the same percentage as above or it will not meet EPA restrictions on Volatile Organic Compounds (VOC)

Apply 1-1/2 to 2 mil dry film thickness.
Working pot life is 4 hours at 77 F°

STEP 4 Dry overnight. (Allow two hours before handling)

DO NOT PACKAGE IN AIR TIGHT PLASTIC BAGS. **POLANE T PLUS** REQUIRES SEVERAL WEEKS TO RELEASE ORGANIC SOLVENTS BEFORE BECOMING COMPLETELY CURED. THE BUILD UP OF THESE SOLVENTS COULD CAUSE IMPROPER CURE AND ADHESIVE FAILURE IN USE.

POLANE T PLUS
ON FIBERGLASS (EPOXY AND POLYESTER TYPE)
(When the rough surface is to be left unsanded.)

STEP 1 The surface must be clean, oil free and dry.

STEP 2 **POLANE T PLUS** does not require a primer on fiberglass.

STEP 3 Wipe the surface with IPA (Isopropyl Alcohol) or a solution of 10% MEK (= R6 K 10) and 90% water.

STEP 4 Topcoat with one coat of **POLANE T PLUS URETHANE PAINT** of the proper color, prepared as follows:

4 parts **POLANE T PLUS URETHANE PAINT**
1 part **V66 V 29 POLANE EXTERIOR CATALYST**
1 part **R7 K 84 POLANE REDUCER**

Note - Must keep the reducer in the same percentage as above or it will not meet EPA restrictions on Volatile Organic Compounds (VOC)

Apply 1-1/2 to 2 mil dry film thickness.
Working pot life is 4 hours at 77 F°

STEP 5 Dry overnight. (Allow two hours before handling)

DO NOT PACKAGE IN AIR TIGHT PLASTIC BAGS. **POLANE T PLUS** REQUIRES SEVERAL WEEKS TO RELEASE ORGANIC SOLVENTS BEFORE BECOMING COMPLETELY CURED. THE BUILD UP OF THESE SOLVENTS COULD CAUSE IMPROPER CURE AND ADHESIVE FAILURE IN USE.

POLANE T PLUS
ON PVC (Polyvinyl Chloride)
ABS (Acrylonitrile-butadiene-styrene)

STEP 1 The surface must be clean, oil free and dry.

STEP 2 **POLANE T PLUS** does not require a primer on PVC or ABS.

STEP 3 Topcoat with one coat of **POLANE T PLUS URETHANE PAINT** of the proper color, prepared as follows:

4 parts **POLANE T PLUS URETHANE PAINT**
1 part **V66 V 29 POLANE EXTERIOR CATALYST**
1 part **R7 K 84 POLANE REDUCER**

Note - Must keep the reducer in the same percentage as above or it will not meet EPA restrictions on Volatile Organic Compounds (VOC)

Apply 1-1/2 to 2 mil dry film thickness.
Working pot life is 4 hours at 77 F°

STEP 4 Dry overnight. (Allow two hours before handling)

DO NOT PACKAGE IN AIR TIGHT PLASTIC BAGS. **POLANE T PLUS** REQUIRES SEVERAL WEEKS TO RELEASE ORGANIC SOLVENTS BEFORE BECOMING COMPLETELY CURED. THE BUILD UP OF THESE SOLVENTS COULD CAUSE IMPROPER CURE AND ADHESIVE FAILURE IN USE.

POLANE T PLUS
ON LEXAN (POLYCARBONATE)

STEP 1 The surface must be clean, oil free and dry. If necessary, wipe with a clean dry rag or paper. Do not use solvents. Lexan is permanently physically damaged by many common solvents.

STEP 2 **POLANE T PLUS** does not require a primer on Lexan.

STEP 3 Wipe the surface with Isopropyl Alcohol (IPA) or a solution of 10% MEK in 90% water. Do not use any other solvents.

STEP 4 Topcoat with one coat of **POLANE T PLUS URETHANE PAINT** of the proper color, prepared as follows:

4 parts **POLANE T PLUS URETHANE PAINT**
1 part **V66 V 29 POLANE EXTERIOR CATALYST**
1 part **R7 K 84 POLANE REDUCER**

Note - Must keep the reducer in the same percentage as above or it will not meet EPA restrictions on Volatile Organic Compounds (VOC)

Apply 1-1/2 to 2 mil dry film thickness.
Working pot life is 4 hours at 77 F°

STEP 5 Dry overnight. (Allow two hours before handling)

DO NOT PACKAGE IN AIR TIGHT PLASTIC BAGS. **POLANE T PLUS** REQUIRES SEVERAL WEEKS TO RELEASE ORGANIC SOLVENTS BEFORE BECOMING COMPLETELY CURED. THE BUILD UP OF THESE SOLVENTS COULD CAUSE IMPROPER CURE AND ADHESIVE FAILURE IN USE.

POLANE T PLUS
ON FIBERGLASS (EPOXY AND POLYESTER TYPE)
(When the rough surface is to be filled-in for sanding smooth)

STEP 1 The surface must be clean, oil free and dry.

STEP 2 Wipe the surface with IPA (isopropyl alcohol), or a solution of 10% MEK (= R6 K 10) and 90% water.

STEP 3 Prime with **D61 A 23 SPRAY FIL** catalyzed with **V66 V 27 INTERIOR CATALYST** (13 TO 1) Reduce with one part **R7 K 84 POLANE REDUCER**
or for lower VOC prime with **D61 H 70 SPRAY-FIL** catalyzed with **V66 V 44 interior catalyst** (4 to 1)

Apply one coat to make a smooth surface, about 2 to 4 mils dry film.

Working pot life is about 8 hours for the D61 A 23 and about 4 hours for the D61 H 70

STEP 4 Allow prime coat to dry one hour minimum.

STEP 5 Topcoat with one coat of **POLANE T PLUS URETHANE PAINT** of the proper color, prepared as follows:

4 parts **POLANE T PLUS URETHANE PAINT**
1 part **V66 V 29 POLANE EXTERIOR CATALYST**
1 part **R7 K 84 POLANE REDUCER**

Note - Must keep the reducer in the same percentage as above or it will not meet EPA restrictions on Volatile Organic Compounds (VOC)

Apply 1-1/2 to 2 mil dry film thickness.
Working pot life is 4 hours at 77 F°

STEP 6 Dry overnight. (Allow two hours before handling)

DO NOT PACKAGE IN AIR TIGHT PLASTIC BAGS. **POLANE T PLUS** REQUIRES SEVERAL WEEKS TO RELEASE ORGANIC SOLVENTS BEFORE BECOMING COMPLETELY CURED. THE BUILD UP OF THESE SOLVENTS COULD CAUSE IMPROPER CURE AND ADHESIVE FAILURE IN USE.