

# Application Guidelines

## *Door Armor® 6000 Clear by Endur-Clad® Coatings.*

The *Door Armor® 6000 Clear* system is a clear rejuvenating sealer and protector that restores old faded doors to a near "like new" appearance. It provides an "automobile clear-coat" type hard shell finish that is easily cleaned, stands up to abuse, resists scratching & marring. Unlike other products that just penetrate and seal, *Door Armor® 6000 Clear* penetrates, seals AND provides a new surface enamel that won't re-chalk.

### ⇒ Things to Consider Before Starting a Job:

#### ◆ **Craftsmanship:**

- ◇ Worker experience and technique is one of the most important and influential factors in application efficiency and final job quality. However it is often overlooked and undervalued. Just remember, the better the painters, the better the job.

#### ◆ **Environmental Conditions:**

- ◇ Temperature, climate, and job site conditions play a big role on how well a job turns out. Is it the right time of the year to refinish?

#### ◆ **Tenant Access:**

- ◇ Keep in mind that tenants will not be able to access their units while being refinished, usually a 4-6 hour window.
- ◇ Consider the facilities hours of operation, times of the month that are busiest, and what type of advance notice should be given to the tenants when scheduling the work to be done.

#### ◆ **Type of Surface that is Being Refinishing:**

- ◇ The *Door Armor® 6000 Clear* system normally adheres to most surfaces when properly prepared. However If the existing surface is extremely glossy or for whatever other reason there are questions concerning the suitability, an adhesion test should be performed prior to proceeding.

#### ◆ **Condition of the Doors:**

- ◇ If chips or scratches are touched up with a pigmented paint prior to application then caution needs to be use to assure the color matches. Brush apply a small amount of product over the touch-up and on the surrounding surface to compare before touching up property wide. Remember The *Door Armor® 6000 Clear* system restores the surface to a Like new" finish so what matches before may not match after re-finished
- ◇ The *Door Armor® 6000 Clear* system should not be used on peeling doors. In some cases adding another layer of paint on top of one that is peeling can cause the old layer to peel even faster.
- ◇ Where there are questions concerning doors suitability for refinishing, several test areas should be performed to determine if *Door Armor® 6000 Clear* is suitable for your situation.

⇒ Step # 1 – Cleaning, Etching and Protection:

◆ **Cleaning and Etching:**

- ◇ Remove any loose or peeling paint.
- ◇ A complete surface scrub using *Etch-n-Clean®* abrasive cleaning system:
  - \* Pre-wet the door with the pressure washer rinsing off all surface dust and dirt.
  - \* While the door is still fully wet, apply a small amount of the mixed *Etch-n-Clean®* solution to the end of “RV” brush with minimum 3 1/2” long Soft “Tampico” or natural bristles. (Do not use a Polyester or plastic bristle brush).
  - \* Scrub horizontally along the corrugation of the door. Pay special attention to the top, bottom, edges, and around the hasp. All dirt, grease, chalk, including any lubricants applied around the hasp area must be fully removed.
  - \* Before the etching solution dries on the door (while the door is still fully wet), perform a complete and full water rinse by a pressure washer that provides 3000 P.S.I. and a minimum 3.75 gallons of water a minute. All etching material, dirt, grease, and grime must be rinsed off thoroughly.
  - \* If the *Etch-n-Clean®* solution dries on a door, all steps must be repeated before proceeding any further.
  - \* To prevent water from being sprayed into the unit, the top portion on the door above the header should be wiped by hand.
- ◇ The surface must be a completely clean with no dust, chalk, dirt, or other surface contaminants.
- ◇ Because this is a clear product any dirt or debris will be lock into the surface and clearly visible. It can't be removed at a later time.



**Prior to applying any top coat re-inspect. If dust, chalk, or dirt remains, repeat the clean/etch process!**

◆ **Inspection:**

- ◇ Prior to proceeding with the coating of the doors, inspect all doors to verify they are clean and dry.
- ◇ Inspect all doors for damage, especially weather stripping and door seals to identify areas where paint could enter into the unit.

◆ **Masking and Protection:**

- ◇ *Door Armor® 6000 Clear* may be applied with reduced masking. However, although clear, it will add a shine to any surface it is applied to so care must be made not to overspray areas where it would be noticeable. In all cases preventing the clear from penetrating into storage units, getting onto nearby automobiles, glass, plastic, etc. is very important. The applicator is solely responsible for any damage that results from anything being over-sprayed. So complete masking is advisable



◆ **Environmental Conditions:**

- \* Don't apply if the air, surface, or material temp. is above 90° F or if it will become so within 1 hour.
- \* Avoid painting in direct sunlight. Apply in the shade when temperatures exceed 70° F
- \* Don't apply when there is a risk of rain within 24 hours.
- \* Don't apply when relative humidity is above 80% or will become so within 24 hours.
- \* Don't apply if the air, surface, or material temp is below 50° F or if it will become so within 4 hours.
- \* Avoid spraying in windy conditions to reduce the risk of contaminants adhering to the surface.
- \* *Door Armor® 6000* will remain tacky for 1 – 2 hours depending on temperature and humidity

◆ **Handling:**

- ◇ Read all label warnings and data sheets prior to handling any paint or coating. *Door Armor® 6000* contains solvents and chemicals that can irritate skin. Always wear chemical resistant gloves when handling and avoid contact with the skin.
- ◇ Always use a properly fitted respirator that employs chemical cartridges while handling, mixing, or spraying *Door Armor® 6000*. Consult MSDS sheets for further warnings and information on the chemical composition of the *Door Armor®* products.

◆ **Mixing:**

- ◇ *Door Armor® 6000 Clear* is mixed at a 4:1 ratio, 4 parts "Part A" resin to one part "Part B" activator.
- ◇ Pot life depends upon weather and temperature. Read the products labels to determine exact pot life. Mix up no more than what can be comfortably used in that time, and no more than what can be used in 2 hours.
- ◇ To mix:
  - \* Agitate "Part A" and "Part B" separately prior to mixing together.
  - \* Pour contents of Part A resin into clean chemical resistant 5 gallon bucket.
  - \* Slowly add "Part B" activator into "Part A" while mixing. Continue to mix a minimum 5 minutes prior to adding any reducer. If reducer is added, agitate another 2 minutes or until completely mixed.
  - \* If thinning is required to help in the application do so in small increments to avoid over-reduction. Over-reduction may affect gloss, clarity, longevity and increases the risk of runs and drips.
- ◇ There are 3 reducers available, slow for hot weather, medium (standard), and fast reducer for cold weather.
- ◇ When mixing a 2<sup>nd</sup> batch, never add "Part A" or "Part B" individually into an existing batch. Always combine "Part A" and "Part B" following the above directions in a separate container. Most importantly, never mix un-catalyzed with catalyzed material, always catalyze before mixing together otherwise it may not dry properly.

◆ **Preparing to Spray:**

◇ **Sprayer and Spray Equipment.**

- \* The sprayer, hoses and gun must be thoroughly clean. Always use a hose and gun that is dedicated for the spraying of solvent based products. Never use the same hose and gun for *Door Armor® 6000 Clear* that has been used for latex paint and visa-versa.

◇ **Adjusting for correct spraying pressure:**

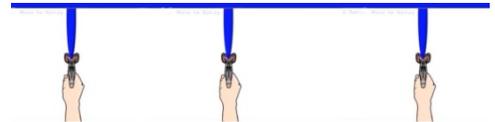
- \* This is very important! *Door Armor® 6000 Clear* should be sprayed at the minimum amount of pressure required to obtain a uniform spray pattern.
- \* To adjust to the proper pressure, using a **NEW “2-10” or “3-12” double orifice fine finish tip**, 1<sup>st</sup> back-off the pressure knob all the way and then screw it in about 1/3rd of the way. (Screwing in increases pressure on most sprayers). Point the gun at a piece of cardboard for testing and with your hand in motion, pull the trigger and spray a sample area.
- \* If you have “tails” (thick lines at the edge of the spray pattern, sometimes referred to as “fingers”), turn 1/8 at a time, until the tail is gone.
- \* Now you have the proper amount of pressure for the material you are spraying. (If no amount of pressure eliminates the tails, then the tip is worn or damaged).
- \* If you have to choose between too much pressure or not enough, always use the lesser amount. A very minimal amount of tailing is acceptable as long as it does not affect the overall quality of the spray pattern.
- \* If the material is further reduced you will need to adjust the pressure again.
- \* If you need more paint flow, increase the size of the tip, not the pressure. A re-adjustment of pressure is required after changing tips.



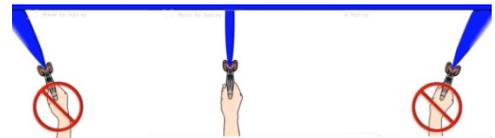
### Step # 3 - Application of Door Armor® 6000 Clear:

#### ◆ **Door Armor® 6000 Clear Spray Application Method:**

- ◆ Confirm the substrate is clean and dry per above specifications.
- ◆ Spray the *Door Armor® 6000 Clear*.
- ◆ Because it is clear, application technique becomes very important to assure complete and uniform coverage.
- ◆ Spray *Door Armor® 6000 Clear* in full strokes. Never stop spraying in one spot or part way across the panel.
- ◆ Start at the top of the door, holding the spray gun a constant distance from the surface, usually 6 to 8 inches. Start your first stroke pointing directly at the door, being careful not to spray up over the door into the unit. The next stroke should overlap the 1st by 50%, and each stroke thereafter overlapping the prior by the same 50%. Make full, long, and even strokes. Always maintain a wet edge overlapping each rib by 50%.
- ◆ Keep the gun precisely parallel to the door while spraying. Don't sweep the gun to an angle at the edges of the door or you'll end up with a wide arc of material on the edges and more concentration in the middle of the door. This will increase the risk of runs in the middle and/or holidays and flashing at the edges.
- ◆ Start your hand in motion first and then pull the trigger. Then release the trigger just before you reach the stopping point of your swing.
- ◆ Each pass should extend completely from one side of the door to the other.
- ◆ Each rib in the roll door requires a complete pass across the face overlapping the prior rib by 50% to obtain full coverage.
- ◆ By not having proper application technique, dry spray may occur resulting in areas that have no sheen, a rough texture, or a blotchy and inconsistent sheen. Again, always maintain a wet edge and overlap passes by 50%.
- ◆ If dry spray does, occur apply a second coat as explained above.
- ◆ If a second coat is required, wait 20-30 minutes, or until the first coat is tacky before applying a 2<sup>nd</sup> coat.
- ◆ Make a thorough inspection of all painted doors. Closely examine under the corrugation rails at the bottom of the doors and the top of corrugation rails at the upper part of the doors as these are the area's most commonly prone to holidays. Minor imperfections can be touched up with a high quality brush. Do not use a roller or pad applicator. Larger areas will need to be re-sprayed. When re-spraying a door, the entire door will need to be recoated as if it was being newly coated. Do not try and do "touch ups" with a sprayer, it will result in a blotchy finish.



Correct Spray Method, Keeping the Gun Perpendicular to the Wall



Incorrect Spray Method, Fanning the Gun Out At The Edges

