



DATE:

CUSTOMER:

ADDRESS:

	ITEMS / CHECKLIST	YES	NO	REMARKS
<b>1.0.0 Paintline Requirements</b>				
1.1.0	Correct Spray Equipment			
1.1.1	Spray Booth			
1.1.2	Spray Gun (remote pot vs. gravity cup)			
1.1.3	Tip Size (1.8-2.2)			
1.1.4	Air Cap			
1.1.5	Mixing/ Gun Cleaning Station			
1.1.6	Hose Diameter (3/8 inch)			
<b>1.2.0 Quality Control Equipment</b>				
1.2.1	Cross hatch – for adhesion test			
1.2.2	Permacel Tape			
1.2.3	Draw down cards – to check color before painting			
1.2.4	Thickness gauge (wet and/or dry)			
1.3.0	Carts and Masking Tubes			
<b>2.0.0 Materials / Product Requirements</b>				
2.1.0	Color Matching			
2.2.0	Cleaning Product – Vinylkleen			
2.3.0	Prepping Product – Vinylprep , Door Prep			
2.4.0	Review Substrate to paint , other than Vinyl			
2.5.0	Coatings – D200, Aqua Ultra Base, Nu Stain			
2.6.0	Consumables - rags, scotch brite, filters, gloves, touch-up bottles, masking tape, exacto knife, sand paper			
2.7.0	Venting and Reinforcement			
<b>3.0.0 Product Storage Conditions ( temperature vs. viscosity)</b>				
3.1.0	Keep out of Sunlight			
3.2.0	Do not allow to Freeze			
3.3.0	Keep @ Room Temperature (approx.72 deg F/22 deg C)			
3.4.0	Mix Occasional or Turnover Cans			
<b>4.0.0 Application Process Stages (lineals or squares )</b>				
4.1.0	Receipt and Checking			
4.2.0	Cleaning of substrates			
4.3.0	Preparation of substrates			
4.3.1	Vinyl Masking (tape ? , tubes )			
4.3.2	Aluminum Screen Frame/Muntin Bar			
4.3.3	Flex and Pile			
4.3.4	Coating Preparation (mixing/filter/accelerator/viscosity?)			
<b>4.4.0 Application( fume coat, build coat, optimum flash time)</b>				
4.4.1	Gun Set Up (air/fluid mix, fan size, test atomisation)			
4.4.2	Wet Film Thickness verification (gauge)			
4.5.0	Drying and Curing			
4.5.1	Drying Methods (air, IR, oven), lots of air movement			
4.5.2	Time and Temperature (max temp 130 F)			
4.5.3	Humidity , Temperature Considerations			

	ITEMS / CHECKLIST	YES	NO	REMARKS
4.6.0	Testing			
4.6.1	Certification Retain Samples and Logs			
4.7.0	Packaging			
4.8.0	In-house rework			
4.9.0	Remedial On site Procedure (installation touch-up bottles)			
4.9.1	Home Owner Maintenance			

<b>5.0.0</b>	<b>Trouble Shooting</b>			
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5.1.0	Cleaning Silicon Contamination			
5.2.0	Spray Equipment Cleaning			
5.3.0	Degreasing			
5.4.0	Silicon Removal			
5.5.0	Static Removal			
5.6.0	Spray Techniques			
5.6.1	Poor Atomization			
	High Viscosity (material too cold) – allow material to warm up			
	Too little material at fluid tip – increase fluid flow			
	Dry spray – increase fluid pressure			
	Micro air in wet film – increase fluid pressure			
5.6.2	Runs			
	Too much product - apply light coats (passes)			
	Too little pressure or fan angle - re-adjust gun set-up			
5.6.3	Orange Peel			
	Slightly too much paint – re-adjust gun set-up			
	Product too thick - Check viscosity. If lid has been left off, product will thicken with dry particle formation. Use water to 3% maximum by volume, then filter			
5.6.4	Solvent Popping			
	Too much product applied too quickly – apply lighter coats			
	Too much heat applied too quickly – adjust heat control			
5.6.5	Cratering / Pinholing			
	Grease, dirt, or silicone contamination by improper cleaning - clean the parts			
	Cross contamination when using other solvents.			
5.6.6	Inclusions			
	Booth filters too dirty - change or clean filters			
	Grease, etc., in air lines - check seals on compressors and ensure air line filters are functioning properly			
	Particles in product—all paint should be filtered 55 microns before use			
5.6.7	Retarding Drying Time			
	Drying time may be increased in extremely warm conditions or when spraying certain shapes, which may result in excessive overspray. Generally proper air-ventilation should be used in order to decrease the drying time.			
5.6.8	Fish Eyes			
	poorly cleaned surface (silicone contamination), too much paint			
5.6.9	Edge Pull			
	Edges not cleaned properly, inadequate fume coat on edge, fume coat that didn't flash, too much coating			

<b>6.0.0</b>	<b>Handling of Painted Product</b>			
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	The following points must be adhered to:			
6.1.0	Handle with care immediately after application.			
6.2.0	Protective tape with low tack adhesive, (or simple wrapping) could be applied to prevent marks or scratching, but this should only be done when all solvents have evaporated and the component has cured. Check for hardness of the coating before packaging.			
6.2.1	Silicones must be kept well away from the initial assembly area for part fabricated frames. Gaskets must not be installed and all benches used must be entirely free of silicones. It is vital to ensure a silicone free area for assembly prior to spraying, or the job may require re-work.			

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<b>7.0.0 Housekeeping</b>				
7.1.0	Keep all floor areas regularly cleaned, and free of dust / overspray, which will be attracted to the components by static.			
7.2.0	Keep all jigs and trolleys (material handling equipment) clean from dust / overspray. Inspect daily and clean at least once weekly by scraping off overspray and washing down. Application of a tacky masking gel helps to reduce inclusions.			
7.3.0	Filter all products into pot before application, using a fine paint filter (use 55 Microns filters)			
7.4.0	Regularly replace air filters.			
7.5.0	Keep a positive pressure inside the booth / spraying area.			
7.6.0	Ban the use of silicones (especially aerosol types), from the plant, if practical, and restrict their use, if not.			
7.7.0	All airlines and filters must be free from moisture and oil.			
<b>8.0.0 Recommended Maintenance List for Paintline</b>				
8.1.0	<b>Filter Cleaning</b>			
	Inspect spray booth exhaust air filters daily			
	Inspect room air filters weekly			
	Inspect trolleys / jigs daily and clean weekly			
8.2.0	<b>Spray Guns</b>			
	Clean after each use with water			
	Disassemble, clean with alcohol, and reassemble monthly			
8.3.0	<b>Bake Oven (if required)</b>			
	Verify actual oven temperatures daily			
	Check oven air circulation system daily			
	Check fan / blower belts weekly			
	Check gas - air ratio monthly			
	Perform oven housekeeping / clean-up weekly			
8.4.0	<b>Safety</b>			
	Sprayers wear the proper respirator equipment daily			
	Check the respirator equipment is functioning properly daily			
	Check the electrical grounds of coatings and solvent containers daily			
	Inspect and clean the spray booth duct work and exhaust fans for removal of paint particle build-up weekly			

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