



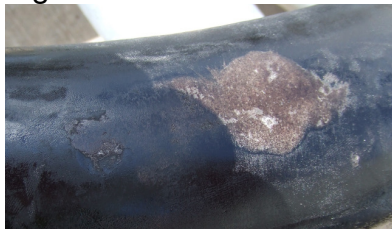


Page 1 of 2	<h1>Mallatite Ltd</h1>	P.P.E Req:	Hi-vis clothing, Solvent resistant gloves, Eye protection & Respiratory protection (solvents)
Date Updated: <b>13/05/09</b>	Standard Operating Procedure: <b>Repairing Powder coating (Holes)</b>	Tools Req:	Stanley knife, P38 / P40 filler and applicator, Stiff brush, Very fine sand paper, mentholated spirits, lint free cloth & required spray paint
Main Steps:	Description		Information
<ol style="list-style-type: none"> <li>1. Safety</li> <li>2. Cleaning the area</li> <li>3. Removing damaged coating</li> <li>4. Surface preparation</li> <li>5. Filling the hole</li> </ol>	<p><b>Important!!</b> In case of emergency or if at any time you require assistance contact a supervisor</p> <p>Clean area around damage with a stiff brush removing all debris.</p> <p>Take a knife and cut off any damaged coating that is not flush with the column (see fig 1)</p> <p>Using clean water and stiff brush clean area to be filled / painted.</p> <p>Using very fine sand paper, sand the surface to be painted to leave a smooth surface, being careful not to remove excess amounts of galvanising. (See fig 2)</p> <p>Ensure that you put on the gloves before proceeding to the next step</p> <p>Mix the required amount of filler</p> <p>Apply to the damaged area only (see fig 3)</p> <p>Allow to dry /harden (this should take approximately 15mins)</p> <p>Ensure that you put on the respirator before proceeding to the next step</p>		<p>Fig 1</p>  <p>Fig 2</p>  <p>Fig 3</p> 

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Main Steps:	Operation Description		Information
<p>6. Painting preparation</p> <p>7. Applying paint</p>	<p>Using very fine sand paper, sand the excess filler off and to leave a smooth surface (see fig 4)</p> <p>Using a cleaning fluid (methlytated spirits) and cloth clean around the surface that will be filled / painted.</p> <p>Using the required RAL colour spray paint</p> <p>Spray a thin layer over the required area (not to much or the paint will run) (fig 5)</p> <p>Allow to dry (this should take only a few minutes)</p> <p>Repeat this process to build up approximately 5 layers</p> <p>Then allow to dry (see manufactures instructions) (see fig 6)</p>		<p>Fig 4</p>  <p>Fig 5</p>  <p>Fig 6</p> 