



# OWNER'S MAINTENANCE MANUAL

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# Introduction

Thank you for your purchase of Metl-Span insulated metal panels. Our panels are designed to be a low maintenance, high performing and durable cladding system. To keep them in optimum condition and to ensure compliance with warranty requirements, please take a moment to read this maintenance manual. Should you have any questions, please contact Customer Relations at the address listed below.

# Chapter 1 – General Care

Visual Inspection – Twice a year, make a complete visual inspection of the panels and look for any changes in appearance including:

Paint finish - discoloration, fade, peeling, flaking or staining Panels - creases, bulges or bumps

Any irregularities observed during the panel warranty period should be reported immediately to Customer Relations.

**Foliage** - Contact with wall panels can produce scratches in the paint surface. Keep bushes and trees trimmed back from panel surfaces.

**Loose Trim** – Loose trim should be reattached to the building using stitch fasteners or pop rivets as required. Replacement fasteners should be of the same type and finish, and are available from Customer Relations.

**Damaged Trim** – Trim at wall openings (such as overhead doors etc.) can be damaged by vehicle traffic etc. Replacement trim can be obtained by contacting Customer Relations.

**Sealants** – Inspect exposed sealants for damage and repair/replace as required – contact Customer Relations for color matched sealants.

**Weep Holes** – Aluminum extrusions located at the top of window/door openings or at the bottom of walls likely contain weep holes that should be checked annually to make sure they remain open.

This is necessary to make sure water properly drains out of the panel assembly.

#### Avoid contact with other materials

- Do not allow stored materials to come in contact with panels.
- Do not allow panels to come in contact with wood, lead or copper, or runoff from any of these materials as they may stain the panels and damage the paint finish.
- Do not allow air conditioning condensation water to drain onto panels.
- Do not allow concrete or mortar splatter to contact panels, as this will be extremely difficult to remove without damaging the paint finish.

# Chapter 2 – Cleaning

NOTE: the cleaning instructions in this chapter apply to standard paint finishes only. Contact Customer Relations for specific instructions on cleaning Tuff Wall<sup>®</sup> or Tuff-Cast<sup>™</sup> panels.

**Routine Washing** – Roofing and siding should be washed with soap and water as necessary to maintain appearance. Carwash soap or a 5% solution of mild laundry detergent (such as Tide) works well for general cleaning. Use a cloth, sponge or a soft bristle brush for application. Cleaning should be done in the shade or on a mild cloudy day to minimize streaking. *Always rinse thoroughly with water.* 

*Do not* use wire brushes, steel wool, sandpaper, abrasives or similar cleaning tools which can mechanically abrade the paint surface.

Be sure to remove all dirt, debris and metal filings from panels. Debris traps moisture against the metal causing premature corrosion. Metal filings oxidize, causing unsightly rust stains and damaging the panel finish as well the metal facings.

**Sealant Removal** (butyl, urethane) – Excess sealant should be removed with a solvent such as WD-40, denatured alcohol or mineral spirits. *Caution: test solvents on a small, inconspicuous area first. Apply solvent to a clean cotton rag – and only wipe the areas of excess sealant. Do not allow solvent to soak into panel joints or flashing areas as this may damage the sealant and associated weather seals.* 

**Rust** - Panels should be inspected for rust once a year. If rust or rust stains are found, determine the source, such as steel filings from drilled holes and remove them. Rust stains are typically removed using one of the following methods: soap and water, Soft Scrub<sup>®</sup>, Rid O' Rust<sup>®</sup> or a mild automotive polishing compound. Careful not to use pressure or film spread may happen.

**Concrete/mortar splatter** - must be washed off immediately with a high pressure wash and mild detergent. *Warning - scrubbing the panels while mortar is present will likely result in scratches to the paint finish!* 

#### Graffiti Removal:

Valspar has endorsed a graffiti removal system by Graffiti Removal Services, Portland, OR. Please visit the following website for more details:

http://www.grssupplies.com/collections/valspar

Depending on the nature of the graffiti paint, as well as the amount of time the graffiti has remained on the panels, removal may be unsuccessful. For these situations, repainting, overlayment or replacement of the affected panels may be required.

#### **Reference chart for Metl-Span paint systems:**

| Metl-Span Color Group                           | Туре                  | Valspar Brand Name               | Guide                                     |
|---|-----------------------|----------------------------------|---|
| Standard I, II                                  | PVDF                  | Fluropon®                        | Fluoropolymer Coatings                    |
| Premium I, II, III                              | PVDF                  | Fluropon®                        | Fluoropolymer Coatings                    |
|   |                       | Fluropon <sup>®</sup> Classic    |   |
|   |                       | Fluropon <sup>®</sup> Classic II |   |
| Standard SP                                     | Siliconized Polyester | -                                | Silicone Polyester Coatings               |
| Standard SP                                     | Siliconized Polyester | -                                | Silicone Polyester Coatings               |
| Polyester                                       | Polyester             | -                                | Polyester Coatings                        |
| Tuff Coat <sup>®</sup> , Cast Cote <sup>®</sup> | -                     | N/A                              | See Tuff Coat <sup>®</sup> cleaning guide |

# Valspar if it matters, we're on it.®

# **CLEANING AND MAINTENANCE GUIDE Fluoropolymer Coatings**

The molecules on the surface of Valspar's fluoropolymer coating systems are so tightly bound together that it makes them resistant to many elements found in the environment such as air pollution, acid rain and general airborne dirt.

Although Valspar factory-applied finishes are extremely durable, a periodic cleaning to remove build-ups of resins and other residue is a good idea to extend coating life. A variety of methods for removal of surface deposits are available. Simple washing with plain water using hoses or pressure spray equipment is usually adequate. When heavy deposits of dirt or other contaminants dull surfaces, stronger methods may be needed.

Two precautions: (1) do not use wire brushes, abrasives or similar cleaning tools which will mechanically abrade the coatings surface, and (2) certain cleaning agents listed below should be tested in an inconspicuous area before use on a large scale.

# **GROUP** A

#### Hot or Cold Detergent Solutions

A 5% solution in water of commonly used commercial (non-industrial detergents) will not have any destructive effect on a fluoropolymer surface. These solutions should be followed by an adequate rinse of water. Use a cloth or sponge for application.

# **GROUP B**

#### Solvents

Most organic solvents are flammable and/or toxic, and must be handled accordingly. Read the manufacturer's Material Safety Data Sheets (MSDS). Keep away from open flames, sparks and electrical motors. Use adequate ventilation, protective clothing, and goggles.

Solvents that may be used to remove non-water soluble deposits such as tar, grease, oil, paint, and graffiti from fluoropolymer surfaces include:

#### Alcohols

- Denatured alcohol (ethanol)
- Isopropyl (rubbing alcohol)

Typically, the above alcohols have no permanent effect on fluoropolymer surfaces.

# GROUP C

# Petroleum Solvents and Turpentine

- VM&P naphtha
- Mineral spirits
- Kerosene
- Turpentine (wood or gum spirits)

Typically, the above solvents have no permanent effect on fluoropolymer surfaces.

# GROUP D

# Aromatic and Chlorinated

- Xylol (Xylene)
- Toluol (Toluene)
- Perchlorethylene (Perclene)
- Tricholorethylene (Triclene)

The above solvents should be used with caution on a fluoropolymer surface. Limit contact with solvent to five minutes maximum and test before using.

# GROUP E

# Ketones, Esters, Lacquer Thinner, and Paint Remover

- Methyl isobutyl ketone (MIBK)
- Ethyl acetate (nail polish remover)
- Butyl acetate
- Lacquer thinner
- Paint remover (non-flammable)

The above solvents should be used cautiously on a fluoropolymer surface. Limit contact to fluoropolymer surface and test before using. Note: There are many formulations of paint remover on the market. It is possible that some will remove the fluoropolymer surface. Proceed very cautiously in use of paint remover. Metal suppliers and coating manufacturers are not responsible for damage from unrestricted use.

# Graffiti

Graffiti presents a special problem because of the many possible agents used, generally aerosol paint. It is best to try soap and water first. If this is not successful, then visit the following website to obtain a graffiti removal kit:

http://www.grssupplies.com/collections/valspar

If none of these methods are satisfactory, it may be necessary to resort to touch up, repaint or replacement.

# Valspar fluoropolymer coatings include:

• Flurothane<sup>®</sup> II

Flurothane<sup>®</sup> IV

Valflon<sup>®</sup>

• Flurothane<sup>®</sup> Coastal

- Fluropon<sup>®</sup>
- Fluropon Classic<sup>®</sup>
- Fluropon Classic<sup>®</sup> II
- Fluropon<sup>®</sup> Premiere
- Fluropon<sup>®</sup> Hardcoat

**Chemical Solutions** 

Mildew: In areas subjected to high humidity levels, dirt and spore deposits can permit mildew growth to occur. The following solution is recommended to remove mildew when necessary:

- 1/3 cup dry powdered laundry detergent (such as Tide®)
- 1 quart sodium hypochlorite 5% solution (such as Clorox<sup>®</sup>)
- 3 quarts water

Rust Stains: Hydrochloric, citric or muriatic acid, diluted with ten volumes of water, may assist in removing rust stains from fluoropolymer surfaces. Limit contact to five minutes. Oxalic acid solutions or acetic acid (vinegar) may be used for the same purpose. Flush with water. Caution: Acid solutions are corrosive and toxic. Flush all surfaces with copious amounts of water after use.

# Warranty

Misuse or abuse of any of the cleaning agents listed in this bulletin could result in a voiding of warranty.



# Valspar if it matters, we're

# **CLEANING AND MAINTENANCE GUIDE Silicone Polyester Coatings**

WeatherX<sup>™</sup> silicone polyester coatings are resistant to many elements found in the environment such as air pollution, acid rain, and general airborne dirt. However, if the need to clean or remove deposits from your coating does arise, a variety of methods for removal of surface deposits are available. Two precautions: (1) do not use wire, brushes, abrasives, or similar cleaning tools which will mechanically abrade the coatings surface, and (2) certain cleaning agents listed below should be tested in an inconspicuous area before use on a large scale.

# **GROUP** A

# Hot or Cold Detergent Solutions

A 5% solution in water of commonly used commercial (nonindustrial) detergents will not have any deleterious effect on a painted surface. These solutions should be followed by an adequate rinse of water. Use a cloth or a soft bristle brush forapplication.

# GROUP B

#### Solvents

Most organic solvents are flammable and/or toxic, and must be handled accordingly. Read the manufacturer's Material Safety Data Sheet (MSDS) on solvent used. Keep away from open flames, sparks and electrical motors. Use adequate ventilation, protective clothing, and goggles.

Solvents that may be used to remove on-water soluble deposits such as tar, grease, oil, paint, and graffiti from Coil Clad 10S and WeatherX surfaces include:

#### Alcohols

- Denatured alcohol (ethanol)
- Isopropyl (rubbing alcohol)

The above alcohols have no permanent effect on Coil Clad 10S and WeatherX surfaces.

# GROUP C

# Petroleum Solvents and Turpentine

- VM&P naphtha
- Mineral spirits
- Kerosene
- Turpentine (wood or gum spirits)

The above solvents have no permanent effect on Coil Clad 10S and WeatherX surfaces.

# GROUP D

#### Aromatic and Chlorinated

- Xylol (Xylene)
- Toluol (Toluene)

The above solvents should be used with caution on a silicone polyester surface. Limit contact of the Coil Clad 10S and WeatherX surfaces with solvent to five minutes maximum and test before using.

# GROUP E Ketones, Esters, Lacquer Thinner, and Paint Remover

- Methyl isobutyl ketone (MIBK)
- Ethyl acetate (nail polish remover)
- Butyl acetate
- Lacquer thinner
- Paint remover

The above solvents should not be used on a Coil Clad 10S or WeatherX surface.

# Graffiti

Graffiti presents a special problem because of the many possible agents used, generally aerosol paint. It is best to try soap and water first. If this is not successful, then visit the following website to obtain a graffiti removal kit:

http://www.grssupplies.com/collections/valspar

If none of these methods are satisfactory, it may be necessary to resort to touch up, repaint or replacement.

# Warranty

Misuse or abuse of any of the cleaning agents listed in this bulletin could result in a voiding of warranty.



# valspar

# **CLEANING AND MAINTENANCE GUIDE Polyester Coatings**

Polyester coatings are resistant to many elements found in the environment such as air pollution, acid rain, and general airborne dirt. However, if the need to clean or remove deposits from your coating does arise, a variety of methods for removal of surface deposits are available. Two precautions: (1) do not use wire brushes, abrasive, or similar cleaning tools which will mechanically abrade the coatings surface, and (2) certain cleaning agents listed below should be tested in an inconspicuous area before use on a large scale.

# **GROUP** A

# Hot or Cold Detergent Solutions

A 5% solution in water of commonly used commercial (nonindustrial) detergents will not have any deleterious effect on a painted surface. These solutions should be followed by an adequate rinse of water. Use a cloth or a soft bristle brush for application.

# **GROUP B**

#### Solvents

Most organic solvents are flammable and/or toxic, and must be handled accordingly. Read the manufacturer's Material Safety Data Sheets (MSDS). Keep away from open flames, sparks and electrical motors. Use adequate ventilation, protective clothing, and goggles.

Solvents that may be used to remove on-water soluble deposits such as tar, grease, oil, paint and graffiti from polyester surfaces include:

#### Alcohols

- Denatured alcohol (ethanol)
- Isopropyl (rubbing alcohol)

The above alcohols have no permanent effect on polyester surfaces.

# **GROUP** C

## Petroleum Solvents and Turpentine

- VM&P naphtha
- Mineral spirits
- Kerosene
- Turpentine (wood or gum spirits)

The above solvents have no permanent effect on polyester surfaces.

# **GROUP D**

#### Aromatic and Chlorinated

- Xylol (Xylene)
- Toluol (Toluene)

The above solvents should be used with caution on a polyester surface. Limit contact of the polyester surfaces with solvent to five minutes maximum and test in an inconspicuous area before using.

# **GROUP E** Ketones, Esters, Lacquer Thinner, and Paint Remover

- Methyl isobutyl ketone (MIBK)
- Ethyl acetate (nail polish remover)
- Butyl acetate
- Lacquer thinner
- Paint remover

The above solvents have no permanent effect on polyestersurfaces.

# Graffiti

Graffiti presents a special problem because of the many possible agents used, generally aerosol paint. It is best to try soap and water first. If this is not successful, then visit the following website to obtain a graffiti removal kit:

http://www.grssupplies.com/collections/valspar

If none of these methods are satisfactory, it may be necessary to resort to touch up, repaint or replacement.

# Valspar polyester products include:

Krystal Kote, PolyKote and Alamo White coil coatings, Super Dynapon super durable polyester extrusion coating, and the Polylure family of polyester extrusion coatings. Krystal Kote, Super Dynapon, Polylure, and the Valspar logo are registered trademarks of The Valspar Corporation.

# **Chemical Solutions**

Mildew: In areas subject to high humidity levels, dirt and spore deposits can permit mildew growth to occur. The following solution is recommended to remove mildew when necessary:

- 1/3 cup dry powdered laundry detergent (such as Tide)
- 1 quart sodium hypochlorite 5% solution (such as Clorox)
- 3 quarts water

Rust Stains: Hydrochloric, citric, or muriatic acid, diluted with ten volumes of water, may assist in removing rust stains from polyester surfaces. Limit contact to five minutes. Oxalic acid solutions or acetic acid (vinegar) may be used for the same purpose. Flush with water. Caution: Acid solutions are corrosive and toxic. Flush all surfaces with copious amount of water after use.

# Warranty

Misuse or abuse of any of the cleaning agents listed in this bulletin could result in a voiding of warranty.



# Chapter 3 – Roof Maintenance and Inspections

# Safety Precautions

WALKING ON ANY ROOF IS DANGEROUS. ALWAYS USE FALL PROTECTION AND PERSONAL SAFETY EQUIPMENT REQUIRED BY OSHA AND OTHER REGULATORY AGENCIES. FAILURE TO FOLLOW THESE REGULATIONS CAN RESULT IN SERIOUS INJURY OR DEATH. YOU MAY ALSO BE SUBJECT TO SUBSTANTIAL FINES FOR NONCOMPLIANCE.

When performing roof maintenance or inspections, always remember the following:

- all maintenance personnel must be adequately trained in safety procedures
- verify safety equipment is in proper working order
- do not walk on roof flashings (gutter, rake, hip or ridge)
- do not walk on skylights or Light Transmitting Panels (LTPs)
- use extreme caution on steep slopes, near edges, where roof is wet or covered with ice/snow

Your new insulated metal panel roof is designed to provide years of protection with very little maintenance. However, no roof is immune to severe weather or completely maintenance free. To keep your roof performing as it should, a maintenance program should be implemented.

**Annual Roof Check** - check the joints in roof panels and associated trims for proper seals and loose fasteners. For repairs, contact the original installing contractor or Metl-Span for the names of qualified contractors in your area.

**Gutter And Downspouts** – Clear all debris (leaves, dirt, etc.) from gutters and downspouts as required. At the minimum, this cleaning should be done twice a year.

#### **Check Drainage**

Proper drainage is critical to roof performance:

- Keep roof free of debris and obstructions.
- Do not install anything on the roof that holds moisture or causes water to pond.
- Do not use wood to support rooftop equipment or pipes etc. Wood blocking impedes water flow and may contain salts or copper sulfate which deteriorate the roof and voids the warranty coverage. Instead use a proper metal roof clamping system, such as S-5! or similar.
- Do not allow water to cascade onto the roof from an adjacent roof. Use gutters and downspouts as necessary to properly channel water.
- Do not allow rooftop air conditioning units or evaporative coolers to drain onto the roof. Use PVC pipe to carry condensate to gutters.

#### Inspect your roof in the event of:

- Fire, vandalism or known damage to an adjacent roof area
- Exposure to severe weather:
  - o High winds: debris, loose panels/trims/fasteners/closures and punctures
  - o Hail storms: damaged trim and loose fasteners
  - o Heavy rains: ponding water at roof laps, roof curbs/penetrations, gutters and all trims
  - o Sliding snow/ice: perimeter trims, plumbing pipes/roof penetrations etc. check for loose fasteners at trim and panel endlaps

#### Notify all other trades before allowing them on the roof panels that they must:

- Protect against foot traffic damage, roof scratches and dents by using appropriate roof covers in work areas.
- Make advance arrangements with roofing contractor to ensure that all penetrations are properly designed and installed.
- Remove all construction debris including metal shavings, sealants, wood scraps, fasteners etc.
- Protect roof with fire cloth wherever welding equipment or cutoff saws will be used.
- Clean up spilled chemicals/solvents on the roof immediately thoroughly rinse affected areas with water.

#### **Foot Traffic**

Foot traffic must be properly managed to reduce damage to metal roof systems:

- Do not walk on trims, trim laps, ridge caps or gutters
- Avoid walking near skylights, roof curbs or other roof penetrations
- Keep off panel high ribs (walk on flat area of panels)
- Heavy foot traffic can damage paint finishes
- Install roof walkway systems for areas of regular foot traffic
- Minimize unnecessary traffic limit access to roof, roof hatches and access ladders
- Post signs at access points authorized personnel only allowed on roof.
- Keep a log book of all visits to the roof and the reason for visits.

#### Ice and Snow Removal

Snow and ice in excess of building design loads should be removed from roof immediately to prevent damage. Pay attention to gutter areas (eaves and valleys), areas sheltered from the wind (behind facades, step roof conditions, etc.). Use extreme caution with removal and follow all roof safety procedures.

- Do not use metal tools to remove the ice or snow as this can damage the paint and/or Galvanized/Galvalume coatings.
- Do not disturb plumbing pipes and flashings.
- Be aware of skylights and light transmitting panels (LTPs). They are not designed to support a person's weight and are difficult to locate if covered with ice and snow.
- Remove snow at an equal rate from both sides of a gabled roof to avoid unbalanced loads.

#### **Dissimilar Metals**

Never allow your roof to come in contact with dissimilar metals or water runoff from dissimilar metals, including but not limited to: copper, lead or graphite. Failure to adhere to this requirement will cause roof damage including staining and galvanic corrosion, and will void all warranties.

Common sources include:

- lead hats for plumbing vents
- copper lightning rods/cables, trims, gutters
- air conditioning and evaporative cooler condensate

#### Leak Repair Procedures:

**Roof systems covered by a Metl-Span weathertight warranty:** No leak repairs should be attempted without prior written approval from Metl-Span (unauthorized repairs may result in warranty forfeiture).

Additions/alterations to the roof during the weathertight warranty period including but not limited to roof curbs, pipe penetrations and HVAC units must be approved in writing by Metl-Span before work commences.

**Roof systems NOT covered by a Metl-Span weathertight warranty:** Leak repairs should only be attempted by a Metl-Span qualified roofing contractor. Contact Customer Relations for a list of qualified contractors near you.

Proper leak repairs usually involve partial dis-assembly and re-assembly of roofing components, replacement of damaged panels/trims, sealant remediation and/or flashing alterations. Applying surface caulk, elastomeric membranes, plastic roof cement etc. is usually not a long term solution for leaks and can lead to further damage. *Under no circumstances should roofing tar or other similar compounds be used to repair metal roofs.* 

# Chapter 4 – Paint Finish Repairs

#### **Minor Paint Scratches**

For scratches without rust, clean the scratched area using a clean white rag dampened with the appropriate solvent indicated in **Chapter 2 Valspar Cleaning and Maintenance Guides**.

For scratches with rust, remove the rust per Chapter 2 Valspar Cleaning and Maintenance Guides.

Apply primer if scratches are deep (down to the bare metal) or if rust was present. Otherwise, no primer is necessary.

- Apply the touchup paint using an artist brush or similar.
- Use only Metl-Span supplied touch-up paint. Primer and color matched touch-up paint with brush applicator is available from Metl-Span Customer Relations.
- Additional information for repairing minor scratches with the Fluropon<sup>®</sup> paint system can be found in the Valspar Fluropon<sup>®</sup> Air Dry Touch-Up document contained in this guide.

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# Fluropon<sup>®</sup> Air Dry Touch-Up

# Fluropon PVDF 100% trusted

Fluropon<sup>®</sup> Air Dry Touch-Up is a two component system that iincorporates Valspar Fluropon topcoats with an air dry additive (920x346). The components are mixed then applied to small damaged areas and air dryed. The applied touch-up is tack free in 30-45 minutes at 70° F and dry to handle after 24 hours. The touch-up system is designed for use in field application to repair scratches and confined areas of factory coated Fluropon products. Recommended application methods include fine air brush or small art brush.

Fluropon Air Dry Touch-Up is not designed for large surface areas. On large areas we recommend, when possible, replacing the building part with a factory coated part or removing the part and recoating in the factory with a baked on Fluropon coating.

Prior to touch-up, an assessment of the damaged area will need to be conducted. If the scratch or nick has penetrated both the topcoat and primer, and there is exposed metal, pre-treatment and primer of the affected area needs to be considered. If the damage is superficial, the touch-up can be applied direct to the factory applied Fluropon coating.

"Fluropon coatings have been the first choice among architects & builders for over 40 years. Whether your project is a long-life monumental high-rise, or a pre-engineered building, Fluropon is the most trusted name in PVDF coatings."



# Touch-Up End Uses

Recommended for use in touch-ups where an air dry system is needed. This system is designed for small, damaged areas such as scratches and nicks. It is not warranted nor is it intended for restoration use.

- Touch-up of factory applied Fluropon building components
- Touch-up of Fluropon coated preengineered building
- Touch-up of residential and architectural windows, doors, skylights and access systems

# Fluropon Air Dry Touch-Up

Application Temperature: Application Reduction for Air Dry: Dry Film Thickness: Tack Free Time: Dry Handling Time: Clean Up Solvent: 50° F 50/50 by Volume with 920x346 1.0 - 1.3 mils DFT 30 - 40 Minutes @ 70° F 24 Hours @ 70° F Xylene or MEK

# Field Touch-Up Process

- Surface Preparation
  - Surface must be dry and free from debris
  - Clean affected area with an isopropyl alcohol clean cloth, remove all contaminants
- Application of Touch-Up
  - Apply only if ambient and surface temperatures are above 50° F
  - Allow at least 30 45 minutes for tack free and 24 hours dry to handle at 70° F
  - Apply with small art brush or fine air brush directly in the scratch or affected area
  - Multiple coats or passes will likely be required to achieve desired film thickness (DFT)
  - Mica/Metallic touch-up is much more sensitive to color and appearance differences versus the factory applied coating color



Valspar makes no warranties, expressed or implied, and disclaims all implied warranties including warranties of merchantability or fitness for a particular use. Valspar will not be liable for any special, incidental or consequential damages.

Fluropon<sup>®</sup> is a registered trademark of The Valspar Corporation.



NOTE: Metl-Span panels are provided with factory warranted paint systems on the exterior face (interior face is not covered under paint warranty). Please contact Metl-Span Customer Relations for all claims regarding paint finish within the warranty period.

Under no circumstances should re-painting be attempted without the prior written approval of Metl-Span. Failure to do so will result in immediate cancellation of the factory paint system warranty.

**The following section contains re-painting instructions for** <u>non-warranted repairs only</u> (panels no longer within the warranty period or damage not covered under the factory warranty). These repairs methods may only be used for the following paint systems:

| Metl-Span Color Group | Туре                  | Valspar Brand Name               |
|-----------------------|-----------------------|----------------------------------|
| Standard I, II        | PVDF                  | Fluropon®                        |
| Premium I, II, III    | PVDF                  | Fluropon <sup>®</sup>            |
|                       |                       | Fluropon <sup>®</sup> Classic    |
|                       |                       | Fluropon <sup>®</sup> Classic II |
| Standard SP           | Siliconized Polyester | -                                |
| Premium SP            | Siliconized Polyester | -                                |
| Polyester             | Polyester             | -                                |

Larger Areas Requiring Repainting - For larger repairs that require re-painting, use the procedures outlined below for each type of paint system. Field painting of the pre-painted surfaces on our panels should be attempted only by a skilled professional using the systems and methods outlined below. It is the responsibility of the painting contractor to follow all safety procedures, verify compliance with environmental regulations and guard against overspray on buildings and vehicles. *Metl-Span is providing this information as a customer service only, and assumes no responsibility for the repairs.* 

#### No warranty for area re-painted.

Note: Color changes may not be uniform on surfaces that are not equally exposed to the sun and elements. In addition, there are slight shading and gloss differences between field-sprayed paint systems and pre-painted, coil-coated systems. These differences are more noticeable when using mica or metallic paint colors.

#### **Polyester and Silicone Modified Polyester Finishes**

- All areas to be repainted should be pressure washed to remove all surface contaminants and to remove poorly adhered paint and clear coats. Washing process shall consist of high pressure washing of 2,000-5,000 psi (may be reduced on softer substrates such as aluminum) using the solution recommended in Chapter 2 Cleaning – Routine Washing.
- 2. Mask area to be repaired to eliminate any over spray onto existing structures.
- 3. Sand entire area to be repaired with fine sandpaper (400 grit) until surface is smooth and all nicks and scratches have been removed.
- 4. Wipe sanded area clean with a clean, white lint-free cloth dampened with suitable cleaner as identified in Section 2 – Cleaning, Valspar Cleaning and Maintenance Guide. Follow all instructions on proper handling of cleaning solutions, including use of proper safety gear and disposal.
- 5. If sanded to bare metal, pre-treat and prime the metal prior to painting to ensure proper adhesion of the air dry system.
- For best results, primer and paints should only be applied when the temperature of the air and substrate is above 50 degrees F (10°C).

# Chapter 4 – Paint Finish Repairs (continued)

- 7. Prime entire part uniformly using a good corrosion resistant automotive type primer to achieve a smooth, consistent film with complete hiding of the metal, dry film of 0.40-0.50 mils.
- 8. Minimum dry film thickness should be measured with a Nordson Microtest Gauge or equal.
- 9. It is not necessary to prime areas that do not show bare metal. If it is necessary to prime the area, then follow the recommendations of the primer's manufacturer for reduction and application techniques. For large areas, you may choose to use a Binks hand spray gun (or equivalent) with a cup reservoir. For smaller areas, you may use an artist's air brush or Crown spray tool #8010 with #8011 power pack aerosol from Crown Industrial Products, Hebron, IL 60034. HVLP (low pressure, high volume spray) equipment should be used to conserve material and contain paint mist/overspray.
- 10. If priming is necessary, the primer should be tack-free and ready to topcoat in 4 to 6 hours or as recommended by the manufacturer. If handling is necessary prior to top-coating, overnight dry time is recommended.
- 11. Top-coat using a good exterior grade acrylic paint or exterior machinery maintenance of the same gloss range as that of the surrounding area. Correct spray viscosity is dependent upon the application equipment selected and the recommendation of the paint manufacturer. Some degree of trial and error may be necessary to achieve the required appearance depending upon the conditions where the repair is being performed.

#### **Product Sources – Polyester Finishes**

• Air dry acrylic products may be obtained through Metl-Span Customer Relations, or through Custom Aerosol Products Inc. (972-382-4321, www.custom-aerosol.com).

#### Fluropon® PVDF (Fluoropolymer) Finishes

Primer is required when the Fluropon<sup>®</sup> coated surface has less than three (3) years of weather exposure. "ADS" is a PVDF based air-dry field repair touchup finish for scratches only, not large areas. It is supplied as a solution coating ready for on-site application. *No warranty*.

# Chapter 5 – Dent or Tear Repairs

# NOTE: Dents or tears in panels are NOT covered under Metl-Span factory warranties. For more information on coverage and exclusions, please refer to your warranty documents.

There are three main methods of dent or metal facing damage repairs. The first two involve patching or overlays, the third involves repair to the existing metal panel surface.

#### Patching method:

- 1. Field fabricate a patch from a section of matching metal skin.
- 2. If metal facing is torn and foam is damaged, repair foam by injecting two part urethane into the void and let fully cure.
- 3. Seal the patch to the panel face with color matched urethane, silicone or polyether sealant and pop-rivet into place.

#### Overlay method:

Panels that become damaged from dents, large or multiple dings or irreparable scratches may be field-repaired by using an overlay sheet of the same profile. Please contact Customer Relations for more specific instructions regarding overlays.

#### Panel surface repair method:

- We strongly recommend that the services of a local qualified automotive body shop be used for this repair method.
- 2. Determine the type of paint system on the panel to be repaired (PVDF or polyester).
- 3. Mask off area to be repaired.
- 4. If metal facing is torn and foam is damaged, repair foam by injecting two part urethane into the void and let fully cure. Level foam as necessary with wood rasp.
- 5. Remove paint and primer by sanding down to bare metal around area to be repaired.
- 6. Repair damage to face of panel with automotive body filler.
- 7. Use separate piece of matching metal skin to imprint proper embossing texture into filler (if required to match panel surface).
- 8. Prime and repaint over repaired area using procedures outlined in Chapter 4.
- 9. "Dentless repair" methods may also be attempted depending on the shape and size of the damage. Consult with a qualified automotive body shop to determine applicability of this repair method.

NOTE: Large areas of damage may require complete panel replacement.

# Chapter 6 – Replacement Parts or Service

Replacement panels, trim pieces and accessories may be obtained through your local Metl-Span panel contractor, or may be ordered directly through Customer Relations. When calling to place an order, please reference the original Metl-Span job number (if available), project name, year built, original panel contractor and building address.



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