



PROCEDURE FOR RE-COATING COILS

Valspar does not encourage re-coating coils of pre-paint steel/aluminum; however, we realize that it is sometimes necessary. If re-coating is required, Valspar recommends the following procedure:

- 1 Strip should be run through the up to temperature cleaning section.
- 2 Apply tie-coat KXC0073 at a DFT of 0.10 to 0.15 mils; PMT should be between 450°F and 465°F.
- 3 Apply a full film thickness of Valspar coating to the top of the coil at the recommended DFT on the Technical Data Sheet (TDS).
- 4 Check all physical tests required by the Product Detail Sheet (PDS) along with crosshatch impact on line.
- 5 Valspar also recommends that along with the on line physical testing that a crosshatch boiling water test be performed. Reverse impact/ crosshatch panel should be placed in boiling water for a minimum of fifteen (15) minutes, then tested for intercoat adhesion.

Valspar is not responsible for field claims resulting from re-coated coils.