

# System Specification & Application Instructions

## Rooflock 48 for Metal Roof Refurbishment

### Preparation

Substrate preparation is of paramount importance to ensure the success of **Rooflock 48 for Metal Roof Refurbishment**.

- Surfaces must be:
  - 1) Sound and secure
  - 2) Completely dry
  - 3) Clean
  - 4) Completely free from all rust (St 2 standard) and all loose or flaking material  
**RUST MUST BE REMOVED BACK TO SHINY METAL**
  - 5) Completely free from organic growth
  - 6) Completely free from dust and grease, or any other contaminants
- Suitable substrates are weathered plastisol and PVF2 coatings, bare steel and aluminium.
- **Existing coatings must not be cracked or peeling. All flaking coatings must be removed.**
- Remove all fixings caps before coating system application.
- Remove white zinc salts from galvanised metal by dry abrasion.
- Use white spirits to remove surface migrated plasticiser from plastisol coatings.
- Test substrate suitability in a concealed area to check adhesion strength and plasticiser migration.



### Suitable substrates

- PVC Plastisol based coatings (weathered)
- Weathered galvanised steel
- Steel

### Fixing heads

- Although Rooflock 48 coating system does not cover waterproofing integrity of a metal roof, we recommend that fixings are replaced, as perished washers frequently cause future water ingress issues.
- If fixings are not replaced, dab metal fixing heads with 1 coat of **Rooflock Zinc Rich Metal Primer**

### Moisture

- Substrate **MUST BE DRY**. Application to damp surfaces or in rainy conditions is not recommended.

### Primer for rusty bare metal surfaces (including cut edge corrosion)

- Grind all rusty steel back to solid shiny metal. (St 2 standard)
- On the same day, apply 2 coats of **Rooflock Zinc Rich Metal Primer** to these areas only. There is no requirement to prime the existing plastisol sheet coating.
  - Open the tin and stir the contents thoroughly.
  - Using brushes or solvent resistant rollers, apply the stirred **Rooflock Zinc Rich Metal Primer** thinly to the complete prepared metal surface using a brush or roller thickness of 50 microns wet film thickness (approx 40-50 square metres per 2.5 litre tin)
  - Allow to cure for minimum 2 hours.
  - Apply another coat as above
- Ensure sheet ends are thoroughly coated with primer
- Do not apply too thick, as this would negatively impact the cure time and performance.
- **Substrate MUST BE COMPLETELY DRY. Application to damp surfaces or in rainy conditions will cause delamination.**
- Allow minimum 2 hours before coating with Rooflock 48 Coating. Surface must remain dry during this time.

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### Sheet end lap sealant (IF SPECIFIED)

- Consult Rooflock Technical Department before sealing sheet end laps.
- Grind all rusty steel back to solid shiny metal. (St 2 standard)
- Apply 2 coats of **Rooflock Zinc Rich Metal Primer** to these areas only. There is no requirement to prime the existing plastisol sheet coating.
- After primer is applied, seal the sheet end laps with Rooflock 42 gun grade sealant:
  - Brush the sealant over every joint that is to be coated.
  - It must touch both sheets and it is essential that a complete seal is achieved.
  - The combined sealant and base coat must visually conceal the leading edge of the top sheet. Approx. coverage is 2.5 - 3 linear metres per 300ml cartridge (excluding an allowance for sheet profile).
- Before sealant cures, brush the sealant to a semi-flat profile, ensuring no pockets or crevices are present.



### Main Coating

- **Substrate MUST BE DRY. Application to damp surfaces or in rainy conditions is not recommended.**
- Mix tin slowly for 1 minute.
- Apply Rooflock 48 evenly to the prepared metal substrate, at 300 microns WFT. (50-60 square metres per 25kg tin)
- Use either brushes, solvent resistant rollers or airless spray gun.  
Airless spray tip size: 19-21 thou. Test in a concealed area.  
Add up to 500ml of Xylene thinners if required to aid usability.
- Surface should ideally remain free of moisture for 2 hours after application.

**Important:** at the end of each work shift, complete the application of Rooflock 48 to full roofing sheets. Do not coat half a roofing sheet and attempt to rejoin the coating at the start of the next shift.

### Repairs

- Lightly abrade the existing Rooflock 48 coating with 120 or 180grit sandpaper. Use gentle pressure only. Use of electric sanders or grinders is not recommended.
- Clean the area with water and allow to dry.
- Apply Rooflock 48 Surface Activator thinly and allow to dry (5-10 minutes).
- Apply Rooflock 48 coating as above instructions.

If a Rooflock product warranty is required, this **MUST** be requested from Rooflock Technical Department **PRIOR** to order.