

### INTENDED USE

#### DECORATION OF BUILDINGS

A rapid drying high performance 'one coat', anti-corrosive, self priming low sheen topcoat, giving a tough flexible film with remarkable adhesion to many difficult substrates.

VOC Classification 2004/42 Cat A(i) = 500g/L.

Apply by brush, do not add thinners.

Typical uses are:

- Cladding Paint; dries at low temperatures down to 5 C for use throughout the year. SEE SUPPLEMENTARY DATA SHEET FOR USE AS A CLADDING PAINT.
- Metal Railings and Fencing; adheres directly to galvanised metal or steel with no need for mordant solutions or etch primers.
- Galvanised or steel structures subject to high humidity; such as steel roof trusses in swimming pools

Not suitable for use in areas subject to chemical / solvent attack

**ARTICLES** - that are not part of a building structure (and are therefore outside the scope of the building products VOC Product Directive)

Typical uses are: machinery, process steelwork, fixed plant, exteriors of pipelines and tanks; for areas exposed to high humidity and certain chemicals (seek advice from Manor Coating Systems Technical Department)

Not suitable for use in areas subject to chemical / solvent attack

#### METAL FINISHING

A rapid dry 'one coat' anti corrosive self priming low sheen topcoat, giving a tough flexible film with remarkable adhesion to many difficult substrates with excellent re-coat characteristics.

Typical uses are:

- General Metal Fabrication; used to overcome problems associated with conventional alkyd paints subject to severe exposure conditions often associated with poor adhesion
- Wrought iron gates and railings, applied direct with no need for a mordant or etch primers
- Metalwork subject to low temperatures, Hi Build Vinyl X Semi-Matt remains flexible
- Metalwork subject to high humidity

Not suitable for use in areas subject to chemical / solvent attack

#### NICHE END USES ON SOME PLASTICS

## SUITABLE SUBSTRATES AND PREPARATION

Some rigid and flexible plastics; such as Foamex and PVC. Always perform a test area prior to painting. if required, seek advice from Manor Coating Systems Technical Department.

See also the Manor supplementary information sheet 'Guide to the UK VOC legislation' to understand how the VOC content of a coating determines its suitability for use in any application.

Not suitable for use in areas subject to chemical / solvent attack

Untreated steel and wrought ironwork; for best results blast clean prior to painting to SA 2 1/2, otherwise manually abrade using powered hand tools and abrasives to ST2.

Weathered Galvanised Steel; remove all traces of oil or grease, lightly abrade with P600 wet or dry paper. Remove dust

Heavily Chromated Galvanised Steel; alkali clean and then proceed as for Bright Spangled Galvanised Steel.

Bright Spangled Galvanised Steel and Newly Galvanised Steel (less than six months since galvanising); remove oil and grease, thoroughly abrade with P600 wet or dry abrasive, remove dust.

Cladding; see separated Data Sheet and follow instructions prior to painting

Aluminium; use 1 Pack Etch Primer CT, see data sheet for details

Always prepare a test area.

Other substrates including plastics; seek advice from Manor Coating Systems Technical Department

## AVAILABILITY

A low satin finish in 5 litre containers in a range of colours. If a Metallic is required, lustre will be affected by sheen.

A Hi Build Vinyl MIO (Micaceous Iron Oxide) in 5 litre containers in Graphite Grey.

## PRODUCT INFORMATION

Composition	Based on a modified vinyl resin pigmented with suitably selected pigments and modified zinc phosphate anticorrosive pigment.
Volume Solids	43% Approx depending on colour
Weight Solids	64% Approx depending on colour
VOC content	500 Max. g/litre
Typical film thickness	Typically 150 microns wet and 65 microns dry  Galavanised items; inc rails & fences to prevent zinc salts migrating a minimum dft of 75 microns is required If items are in coastal location a minimum 120 microns d.f.t. is required
Theoretical coverage	6.7 sq metres/litre at 150 microns wet film thickness, 65 Dry film thickness
Dry heat resistance	60 C
Flash Point	Within the range 21-31 C

## APPLICATION DETAILS

PREFERABLY BRING PAINT TO 15-25C AND STIR WELL BEFORE USE

Note To comply with VOC Products Directive for the DECORATION OF BUILDINGS no thinner may be added

Airless spray:	cold	Do not thin (see application note). Typical tip size 17-19 thou. (0.43-0.48mm) Typical fluid pressure 2800 p.s.i or 200 kg/sq metre.
	heated	Not recommended
Conventional spray		Thin up to 15% with thinner, apply 2 to 3 coats to achieve the required film thickness (See application note) Do not hot spray
Brush Roller		Only attempt to brush and roller small areas such as making a localised repair or painting narrow areas such as gates or railings where wet edge retention is not an issue. Do not attempt to brush out or lay off.
Thinner		Normally Manor Industrial Thinner. Manor Synthetic thinner may be used for brush & roller. Manor Fast Flash Thinner for spray application in a booth for quicker flash off. (see application note for details)

#### Film thickness per coat

	<u>Dry</u>	<u>Wet</u>
<b>Minimum</b>	26 microns	60 microns
<b>Maximum</b>	75 microns	174 microns

## DRYING AND RECOATING

Approximate drying times at 75 microns d.f.t.

<u>Substrate temperature</u>	<u>Touch Dry</u>	<u>Overcoating times</u>	
		<u>Minimum</u>	<u>Maximum</u>
10C	1 hour	3 hours	Indefinite
20C	30 minutes	1 hour	Indefinite

#### Environmental conditions

The air temperature should be at least 5 C with a surface temperature 3 C above dew point and the relative humidity below 90% thus ensuring that the surface is dry and that condensation will not occur during application or drying.

The drying times will be significantly extended in cold, damp conditions

Do not apply to external surfaces if the forecast is for rain to fall within the next 24 hours as surface may water mark during curing.

In exposed windy conditions a minimum air temperature of 8 C is recommended.

#### Overcoating / repainting

An additional coat of Hi Build Vinyl X Semi-Matt may be applied if required.

If spraying Wet on Wet application can be undertaken

## SHELF LIFE

Store in cool, dry conditions, typically 5-25C. After a period of storage the product should be thoroughly stirred. Usable life is 2 years from date of manufacture in unopened containers.

## **SAFETY PRECAUTIONS**

Refer to Manor Safety Data Sheet

## **LIMITATIONS**

The information given in this data sheet is based on experience and is accurate to the best of our knowledge. No guarantee should be implied however, since the conditions of use are beyond our control. This data sheet does not constitute a specification.

A Painting Guide can be accessed via our website which provides additional information on paint and painting and definitions of terminology.

In case of doubt as to the suitability of the product please consult our Technical Department. If you are advised that the paint can be used in a manner not specified on this datasheet our Technical Department will confirm this to you in writing. Do not use paint prior to receiving this confirmation.

References to other primers, topcoats, cleaners and thinners are to the Manor Product of that name only.

This data sheet supercedes all previous issues.

## **REFERENCES**

Amended: 29/07/2025

Reference: HX Version: 3.0

# MANOR

## PRODUCT DATA SHEET

### HI-BUILD VINYL X SEMI-MATT

### WHEN USED AS A CLADDING PAINT

### (also see the HI-BUILD VINYL X SEMI-MATT GENERAL DATASHEET)



#### INTENDED USE

##### DECORATION OF BUILDINGS

A rapid drying high performance 'one coat' anti-corrosive self priming low sheen topcoat, giving a tough flexible film with remarkable adhesion to many difficult substrates.

VOC Classification 2004/42 CatA(i)= 500 g/litre

This data sheet explains how to test whether Hi-Build Vinyl X Semi-Matt can be used to paint cladding and how to use the product.

#### TESTING THE SUBSTRATE

There are many different types of plastic-coated steel cladding. These can vary significantly in the way they accept overpainting. While Hi-Build Vinyl X Semi-Matt has been found to perform excellently on a wide selection of cladding, no single paint system is suitable for every type of cladding. Therefore, an application / adhesion trial on a small test area is essential to verify the suitability of painting each project. This process takes time and must be planned well in advance of the intended maintenance.

##### Testing the substrate

###### *(i) Purchase a tin of Hi-Build Vinyl X Semi-Matt*

Purchase 5L of the Hi-Build Vinyl X Semi-Matt in the colour required for the job, if the accuracy of the colour match is critical this should be checked during testing.

IT IS IMCUMBENT ON THE SPECIFIER/END USER TO ASSESS THE SUITABILITY OF HI BUILD VINYL X SEMI-MATT FOR THE SUBSTRATE IN QUESTION.

###### *(ii) Select Test Area(s)*

Select several test areas, particularly test around vents and exposed surfaces especially where dirt, oil, grease or chemicals may have attacked the existing coating or where the existing coating has failed.

###### *(iii) Prepare test area*

Thoroughly clean with hot water/steam power wash and alkaline degreaser to remove all traces of dirt and debris, small areas can be done by thorough hand cleaning. Apply the paint by brush.

Manor Coating Systems Limited, Otley Road, Shipley BD17 7DP

Tel: 01274 587351 [www.manorcoatingsystems.co.uk](http://www.manorcoatingsystems.co.uk)

Code HXCLAD Number 1.0 Issued 06/12/2024 February 2024 Reference Word



*(iv) Leave overnight then check for tackiness*

If the film remains tacky and soft it is likely that the cladding has a high plasticizer content. Repeat the test again but this time after cleaning wipe the area with Methylated Spirits to remove any surface plasticizer, allow to dry and then apply the test paint. If this fails then another paint system will be required, contact Manor Coating Systems Technical Department.

*(v) Leave for 7 days then check for tackiness As for (iv) above*

*(vi) After 7 days and if there is no significant tackiness check the adhesion* Using a sharp Stanley knife (or similar) make a series of 5 parallel cuts about 3mm apart and 20 mm long. Repeat these cuts at a 90° angle to make a Portcullis or grid pattern. Apply clear adhesive tape over the cut marks, press down firmly, leave for 2 minutes and pull off sharply holding the edge of the tape. Examine the back of the tape. If no paint has been removed surface preparation and painting can proceed. If significant amounts of paint are removed, repeat test in another area and consult Manor Coating Systems Technical Department, it is likely that an alternative system will be required.

*(vii) Verify the accuracy of the colour match*

Verify the accuracy of the colour match to panels being matched to.

#### **SUITABLE SUBSTRATES AND PREPARATION**

Plastic coated steel that has been tested for product suitability as described above.

##### **Surface Cleaning**

Thoroughly clean with hot water/steam power wash and alkaline degreaser to remove all traces of dirt, dust and debris. Small areas can be done by thorough hand cleaning. Lightly abrade the surface with a Green 3M Scotchbrite Pad. If during testing it has been necessary to wipe the surface with Methylated Spirits this will also have to be done on the main painting work.

##### **Patch Repair**

Treat any areas where the original coating has failed, remove any rust by abrasion and remove any flaking plastic coating back to a firm edge. Spot prime with 2 generous coats of Hi-Build Vinyl X Semi-Matt leave 2 hours between coats and leave to dry overnight. Feather back the edges of the repair with wet and dry paper to prevent a lip showing.

#### **AVAILABILITY**

Extensive range of BS, RAL and house colours in 5 and 20 litre containers. If a metallic is required, lustre will be affected by sheen.

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<b>PRODUCT INFORMATION</b>	See main data sheet	
<b>APPLICATION</b>	<b>Airless Spray (cold)</b>	<p>Ensure that release of spray dust and overspray is prevented by sheeting up or similar.</p> <p>A typical set up for airless spray application would be a minimum working pressure of 2800 psi with a tip size of 0.38-0.48 mm (15-19 thou) and a spray angle of 65-80°</p> <p>Do not thin Do not exceed recommended film thicknesses</p>
	<b>Conventional Spray</b>	Not recommended
	<b>Brush / Roller</b>	Only attempt to brush and roller small areas such as, localised repair where wet edge retention is not an issue. Do not attempt to brush out or lay off.
	<b>Thinner</b>	To comply with VOC products directive for the DECORATION OF BUILDINGS no thinner may be added.
	<b>Film thicknesses</b> Airless Spray one coat 150 microns wet and 65 microns dry	
<b>DRYING AND RE-COATING</b>	<b>Drying times</b>	See main data sheet
	<b>Environmental conditions</b>	<p>The air temperature should be at least 5C with a surface temperature 3 C above the dew point and the relative humidity below 90% thus ensuring that the surface is dry and that condensation will not occur during application or drying.</p> <p>The drying times will be significantly extended in cold, damp conditions.</p> <p>Do not apply to external surfaces if the forecast is for rain to fall within the next 24 hours as the surface may water mark during curing.</p> <p>In exposed windy conditions a minimum air temperature of 8 C is recommended.</p>
	<b>Overcoating / repainting</b>	An additional coat of Hi-Build Vinyl X Semi-Matt may be applied if required.

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<b>Shelf life</b>	Store in cool, dry conditions, typically 5-25 C. After a period of storage, the product should be thoroughly stirred. Usable life is 2 years from the date of manufacture in unopened containers.
<b>Safety Precautions</b>	Refer to the Manor Safety Data Sheet
<b>Limitations</b>	<p>The information given in this data sheet is based on experience and is accurate to the best of our knowledge. No guarantee should be implied however, since the conditions of use are beyond our control. This data sheet does not constitute a specification.</p> <p>A Painting Guide can be accessed via our website which provides additional information on paint and painting and definitions of terminology.</p> <p>In case of doubt as to the suitability of the product please consult our Technical Department. If you are advised that the paint can be used in a manner not specified on this datasheet our Technical Department will confirm this to you in writing. Do not use paint prior to receiving this confirmation.</p> <p>References to other primers, topcoats, cleaners and thinners are to the Manor Product of that name only.</p> <p>This data sheet supersedes all previous issues.</p>