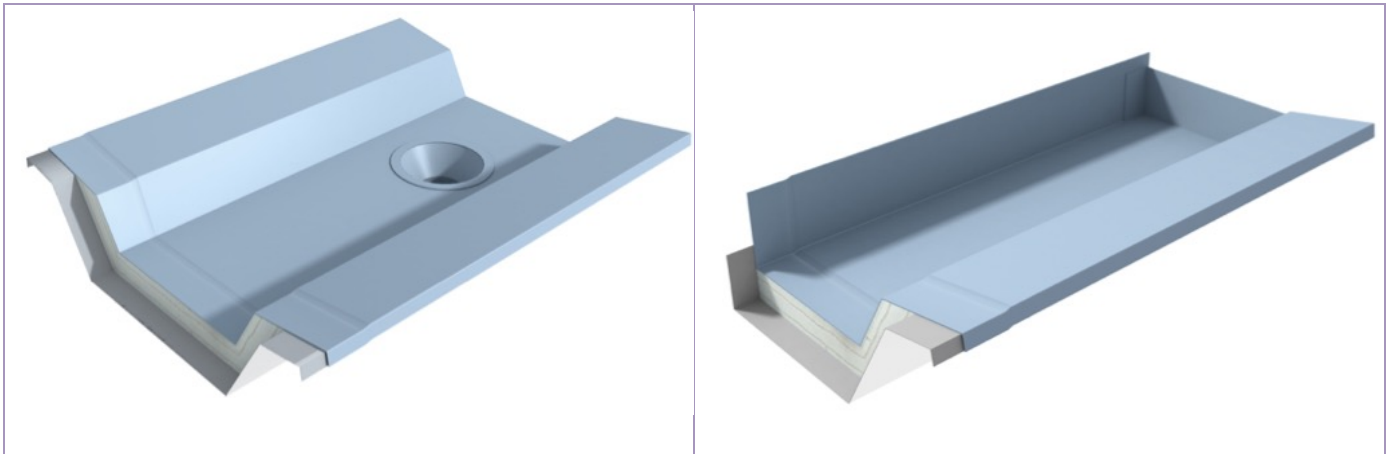




Trimform Membrane Lined Insulated Gutters

Description	
	<p>Trimform membrane lined insulated and single skin gutters create a fully sealed gutter system and are the ideal solution for rainwater management.</p> <p>Gutters are the critical elements in the weather proofing of a building, especially gutters classed as internal such as valley or boundary wall gutters. If these leak, the roof system has failed and the building occupants and operation is put at risk.</p> <p>Why rely on a plain galvanised steel gutter that relies on sealants and bolts at the gutter joints and a brush applied paint surfacing?</p> <p>Why rely on a plain aluminium gutter that has issues with thermal expansion and gutter joints?</p> <p>Trimform Raintite gutters have fully sealed joints:</p> <ul style="list-style-type: none">• No bolted joints• No reliance on sealants• No aluminium expansion issues• No secondary protection paint needed. <p>Using Fatra Raintite coated metal, Trimform insulated membrane lined gutters feature:-</p> <ul style="list-style-type: none">• Plasticiser free Fatra PVC weathering• Unique slip resistant textured surface• Fully sealed joints (hot air welded)• Steel substrate• Insulated (PIR insulation and rock fibre available)• Walkable (when fully fixed)• Ponding tolerant• 25 and 35 year guarantees available• Approved installers• Zero ODP insulated core• White polyester coated liner• Virtually maintenance free• Trimform rainwater capacity design calculation service <p>Trimform gutters are fabricated to customer order for valley, boundary wall/parapet and eaves applications.</p> <p>Stopends, corner sections, outlets, sumps, leaf guards and downpipes etc are available to order. The PC-80 paint finish to fabricated outlets, weirs etc is compatible with welded details into Fatra PVC.</p>
Application	

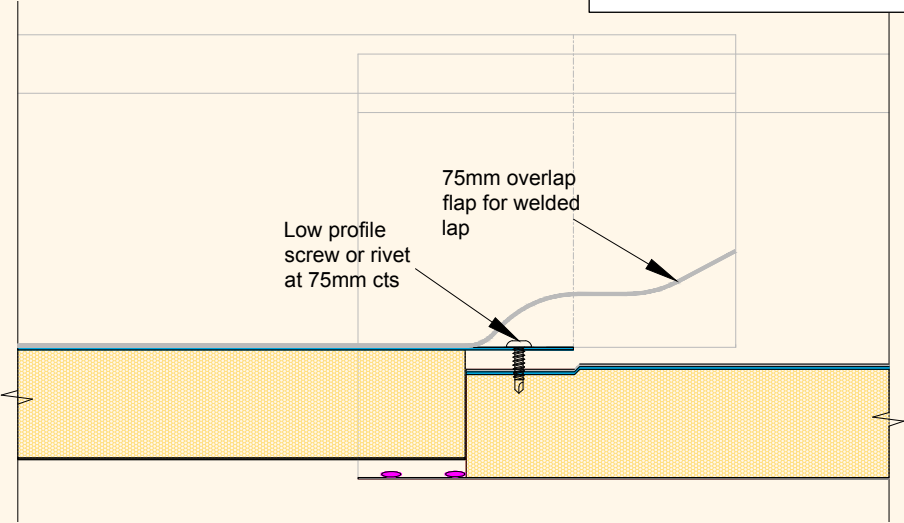
Trimform Membrane Lined Insulated Gutters



Sole width	To customer order, with minimum 300mm advised (preferably 500mm) for foot traffic accessible gutters and to allow access for cleaning. Note that the sole width has to accommodate the outlet diameter and installation.
Depth	To customer order, minimum 150mm advised
Lengths	To customer order. Raintite coated metal sheet girth 1000mm and 1250mm - maximum length 3000mm. Girth > 1250mm, maximum length 1475mm.
Raintite coated metal - material girths	1000mm, 1250mm and 1475mm
Raintite coated metal -membrane	1.2mm thick textured RAL7012 dark grey plasticiser free PVC membrane (other colours on enquiry), factory bonded to a steel substrate. Integral 125mm loose strip for 75mm overlap at joints.
Raintite coated metal - steel substrate	1.2mm thick hot dipped galvanized steel substrate to BS EN 10346:2015, DX51D+Z275/AZ150 with primer and internal grade white polyester paint finish to both sides. 50mm joggle joint.
Accessory options	<ul style="list-style-type: none"> • Stop ends (insulated or single ply) • Weir overflows • Prefabricated corner gutters • Sumps • PVC sharp edge outlets with integral Fatra weathering strip • Bespoke steel sharp edge outlets with separate Fatra weathering strip • Bespoke steel side outlets with separate Fatra weathering strip • Tapered outlet option available • Integral outlets on enquiry • PC-80 welding compatible coatings to accessories



Trimform Membrane Lined Insulated Gutters

Insulation	<p>Foil faced PIR bonded to each steel surface, thickness to customer order and U value requirement. Zero ODP, BS EN 13165:2012+A2:2016 $I_D = 0.022W/mK$.</p> <p>To enable non-combustible class A1 core gutters for compartment wall locations, enquire with Trimform for the Class A1 non-combustible rigid rock fibre core. BS EN 13162:2012+A1:2015 $I_D = 0.034W/mK$.</p>
Joint	<div><div><ul style="list-style-type: none">• 50mm joggle joint• Low profile stainless steel joggle screws• 50mm + 75mm = 125mm membrane overlap, 75mm for welding.• Sealed liner.</div></div>
Lining	<p>0.7mm bright white polyester coated steel, 50mm overlap joggle joint.</p>



Trimform Membrane Lined Insulated Gutters

Performance	
Fire	<p>Liner: 0.7mm white polyester: BS EN 13501-1:2018, Reaction to fire A1</p> <p>Fatra membrane: BS EN 13501-5:2005, BBA 04/4079ps1,Section 7: B_{Roof}T4</p> <p>PIR insulation core: BS EN 13501-1:2018, Class F</p> <p>Rock fibre insulation core: for compartment wall situations, BS EN 13501-1:2018, Class A1</p>
Rainwater capacity design	<p>The standard for calculating the sizing of guttering and downpipes is BS EN 12056-3:2000.</p> <p>Trimform provides a gutter capacity design service for gravity drained gutters based upon the industry leading CRM Gutterflow v4.0 software.</p> <p>Refer to the Trimform Gutter Design enquiry sheet for the information that Trimform will require to provide rainwater capacity calculations.</p> <p>BS EN 12056-3:2000 allows for two types of flow in gutters:</p> <ul style="list-style-type: none">• Free flow• Restricted flow <p>Industrial style gutters, where the gutter capacity exceeds the outlet capacity (due to the gutter being sized for access as well as drainage) are hydraulically bigger than they need to be and are generally designed for restricted flow.</p> <p>Note that back or side outlets, leaf guards and corners in gutters can restrict flow and must be allowed for in design. Leaf guards reduce outlet capacity by 50%</p> <p>Tapered outlets give best outlet capacity.</p> <p>Pipe diameters are typically 50mm, 63mm, 75mm, 100mm, 150mm and 200mm</p> <p>The insulation value of the gutter can be made to be less than that of the roof. This can be an advantage during icy conditions by encouraging the gutter snow to melt first and start clearing before accommodating deposited flow from a thawing roof.</p>



Trimform Membrane Lined Insulated Gutters

Thermal

The U values are for the gutter area expressed in W/m²K

For a valley gutter the gutter area is the sole width plus the two sloping upstands

For a parapet gutter the gutter area is the sole width plus one sloping upstand.

BRE information paper IP 1/06 table 4 gives the typical default linear thermal transmittance value (psi - φ, W/mK) for a valley gutter in a metal roof as 1.50W/mK

Insulation thicknesses are subject to availability.

Weights are the flat area nominal weights for the materials in kg/m²

Rock fibre insulation is intended for situations where the gutter bridges a compartment wall.

Insulation type	λ	Insulation thickness	U value	Weight
	W/mK	mm	W/m ² K	kg/m ²
PIR	0.022	50	0.41	18.9
PIR	0.022	60	0.35	19.2
PIR	0.022	70	0.30	19.6
PIR	0.022	75	0.28	19.7
PIR	0.022	80	0.26	19.9
PIR	0.022	90	0.24	20.3
PIR	0.022	100	0.21	21.1
Rock fibre	0.034	50	0.62	22.0
Rock fibre	0.034	60	0.53	23.0
Rock fibre	0.034	70	0.45	24.0
Rock fibre	0.034	75	0.43	24.5
Rock fibre	0.034	80	0.40	25.0
Rock fibre	0.034	90	0.36	26.0
Rock fibre	0.034	100	0.32	27.0

Walkability

Once fully fixed Trimform gutters are walkable.

Trimform insulated gutters are non-fragile class B when tested to ACR[M]001:2019 Test For Non-Fragility of Large Element Roofing Assemblies

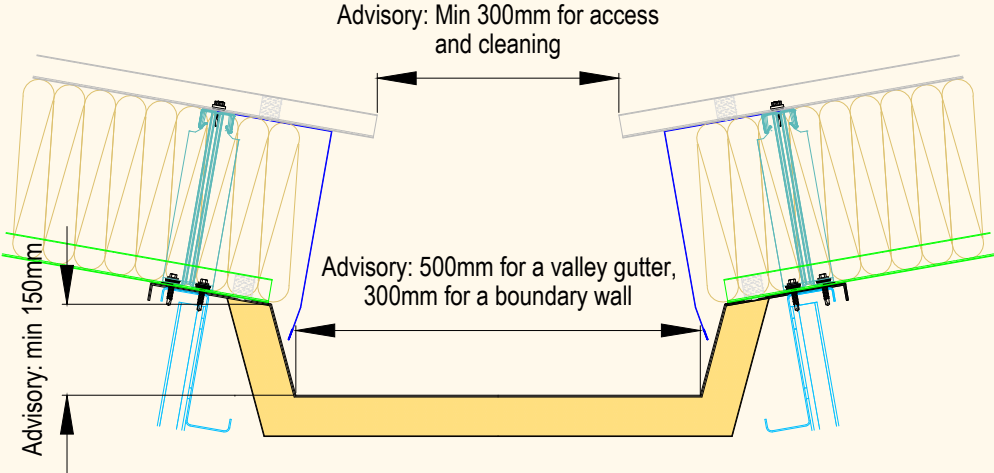
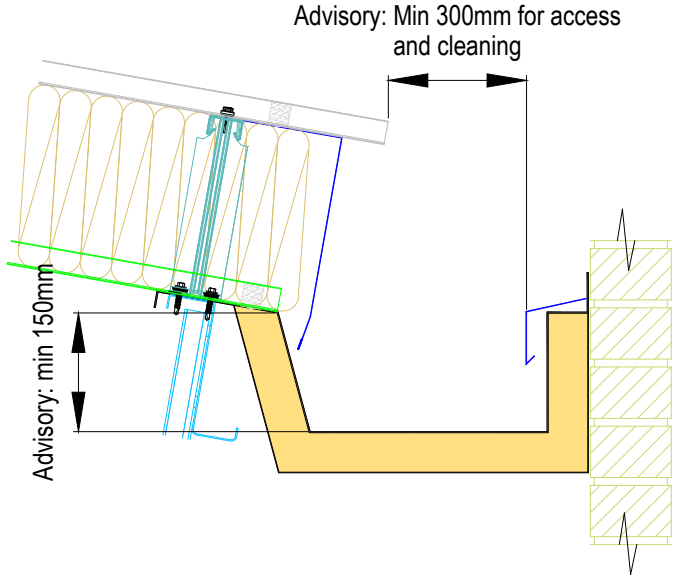
Note that the assessment is on new materials and once in service an engineer (competent and familiar with metal roofing) should be used to assess whether the assembly retains its integrity and remains non-fragile.

The Raintite Fatra Coated Metal membrane has an anti-slip textured surfacing and has been tested for slip resistance, Ceram report 126180-25452, Pendulum test method.

Raintite Fatra Coated Metal achieved:-

- Dry Value: 46 (PTV >36: Low Slip Potential)
- Wet Value: 34 (PTV 25-35: Moderate Slip Potential)

Trimform Membrane Lined Insulated Gutters

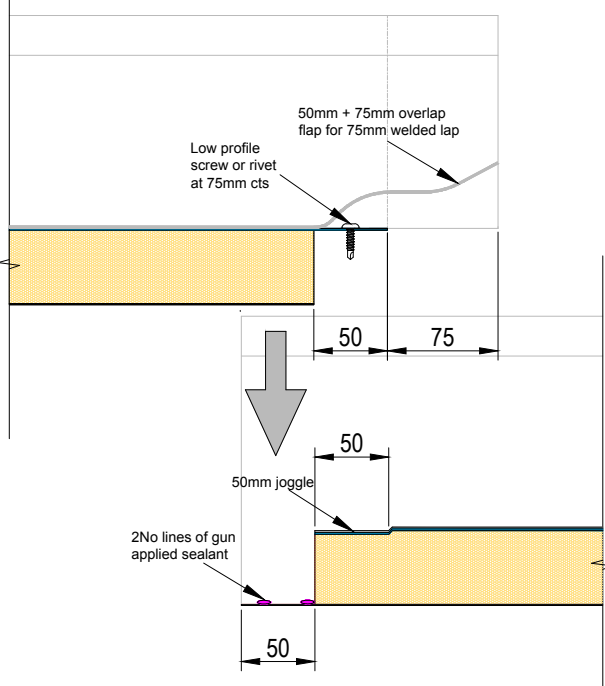
<p>Valley gutter</p>	
<p>Parapet/boundary wall gutter</p>	



Trimform Membrane Lined Insulated Gutters

Installation	
Delivery	<p>Products are protected, banded and shrink wrapped. Delivery is by Trimform Products delivery fleet.</p> <p>Inspect packs and record any damage/shortages on delivery paperwork and send with photos and a report to Trimform within 48 hours.</p>
Fasteners	<p>Gutter to structure – initial fix: Fix to supports at each side of the gutter at max 1500mm centres, minimum 4No per gutter unit (ie min 6No for a 3m unit), using 5.5mm dia low profile head stainless steel screw fasteners or 4.8mm dia stainless steel rivets.</p> <p>Gutters that will be used for regular access before the roof system is installed and fixed should be secured to the structure at 750mm centres at the time of gutter installation.</p> <p>Ensure that the gutter unit flanges sit tight to the purlin and that the fixings engage properly (ie, that purlin deflection does not result in fixings missing).</p> <p>Gutter to structure – final fix: The gutter is subsequently fully secured by the roof system fixings (factory insulated or site assembled, bedded for the air/vcl seal on filler blocks or 8mm dia butyl beads).</p> <p>Gutter joints: Fix together using 5.5mm dia low profile head stainless steel fasteners or 4.8mm dia rivets within the gutter overlap, at 75mm nominal centres.</p>
Laps/Sealants	<p>Liner: 2 lines gun applied low modulus, neutral cure sealant</p> <p>Raintite PVC Weathering: Site welded 75mm PVC overlap, hot air weld:-</p> <ul style="list-style-type: none">• Tack weld the overlap into position.• Continuously weld the next 25mm.• Continuously weld the last 25mm to ensure a watertight seal.• The joint should then be dressed with a bead of Fatrafol 854 Liquid PVC <p>A separate Fatra strap is supplied with separate stop ends.</p> <p>Refer to the Raintite welding instructions appended (1- Raintite_Basic-Welding-Procedure.pdf)</p>

Trimform Membrane Lined Insulated Gutters


<p>Joint</p>	 <p>50mm + 75mm overlap flap for 75mm welded lap</p> <p>Low profile screw or rivet at 75mm cts</p> <p>50mm joggle</p> <p>2No lines of gun applied sealant</p> <p>50 75</p> <p>50</p> <div style="border: 1px solid black; padding: 5px; margin-top: 10px;"> <p>50mm joggle joint with integral 50m + 75mm = 125mm membrane overlap for welding.</p> <p>2No lines of gun applied sealant to seal the liner.</p> <p>Low profile stainless steel joggle screws at 75mm cts</p> </div>
<p>Outlets</p>	<p>Outlets are fabricated in aluminium and provided with a welding compatible Plascoat PC-80 powder coating and supplied with a 500mm x 500mm Fatra patch.</p> <p>Locate the required outlet position and site cut a clearance hole for the outlet pipe using a hole saw. Clear any swarf. Secure steel bespoke outlets to the gutter using stainless steel rivets through the flange.</p> <p>Hot air weld the pvc patch using the normal Fatra joint method. PC-80 coated outlets are compatible with welded details</p> <p>Seal around the internal outlet pipe/ liner junction using white silicone sealant or using a white painted steel collar fabrication.</p>
<p>Access</p>	<p>Never walk in unsecured gutter sections.</p> <p>Once fixed Trimform gutters are walkable.</p> <p>ACR[M]001:2019 Test For Non-Fragility of Large Element Roofing Assemblies: Trimform insulated gutters are non-fragile class B</p>
<p>Structural</p>	<p>Trimform Raintite gutters should be supported by continuous supports to each side where ever possible. This can be aided by using gutter straps at regular spacings (typically 1m).</p> <p>Larger single skin gutters may require additional structural support in the form of a continuous base support for anything nominally over 500mm sole / 1000mm girth.</p>

Trimform Membrane Lined Insulated Gutters

In service performance	
Durability	<p>Trimform Raintite gutters use 1.2mm PVC roof membranes factory laminated to the steel substrate.</p> <p>Under normal service conditions, the system will provide a durable roof waterproofing with a service life in excess of 30 years.</p>
Care and maintenance	<p>Raintite membrane lined gutters are maintenance free, but an annual inspection and report is advised.</p> <p>Membrane durability can be affected by a build-up of debris such as grit, bird carcasses, plastic bags, plants and trees etc, and the gutter is where all this will accumulate.</p> <p>Depending on the location and surrounding topography, gutters should be checked once or twice a year and cleaned using a soft bristled brush and a plastic shovel to collect the debris.</p> <p>The inspection can be from a cherry picker, but must always be carried out by a competent and suitably trained person after a risk assessment is in place.</p> <p>For further information refer to the appended Raintite information:-</p> <p>2 - Raintite_Care-Maintenance.pdf 4 - Raintite_Repairs-of-small-perforations-in-the-weather-surface.pdf</p>
Guarantees	<p>25 year and 35 year Raintite Trading Ltd material guarantees are available with Trimform membrane lined gutters.</p> <p>Both guarantees are subject to registration with, and acceptance by, Raintite.</p> <p>The 35 year guarantee has to be notified to Trimform/Raintite at the time of <u>enquiry</u> with full project details.</p> <p>The 35 year Raintite material involves a bespoke non-stock enhanced membrane and will require material procurement specific to the project.</p> <p>The 25 year and 35 year guarantees are subject to the Raintite guarantee conditions.</p> <p>The 35 year guarantees will require inspection and sign off by Trimform (this may be subject to a fee).</p> <p>The installer has to provide copies of current Fatra training certificates to show that the site operatives are Fatra trained.</p>



Trimform Membrane Lined Insulated Gutters

References	
Reference documents	<p>Appended reference documents:-</p> <ul style="list-style-type: none"> • 1- Raintite_Basic-Welding-Procedure.pdf • 2 - Raintite_Care-Maintenance.pdf • 3 - Raintite_Coated-Metal-Product-and-Membrane-Specifications-2.pdf • 4 - Raintite_Repairs-of-small-perforations-in-the-weather-surface.pdf • 5 - 25yr Guarantee Application Form AVAILABLE AS INTERACTIVE.pdf • 6 - 35yr Guarantee Application Form AVAILABLE AS INTERACTIVE.pdf • 7- Plascoat PVC PC80 GS.pdf
Reference Standards	<p>MGMA Guidance documents for best practice</p> <ul style="list-style-type: none"> • MGMA Data Sheet 3 • MGMA Data Sheet 5 • MGMA Data Sheet 13 • MGMA Data Sheet 17 <p>BS EN 12056-3:2000 BBA 04/4079ps1 ACR[M]001:2019: 6th edition: Test For Non-Fragility of Large Element Roofing Assemblies</p>
Trimform Products	<p>Trimform Products, Harding Way, Somersham Road, St. Ives, Huntingdon, Cambridgeshire, PE27 3WR T 01480 461103, E info@trimformfabs.co.uk</p> <p>Trimform Products (a division of Building Solutions (National) Limited). Registered in England and Wales No. 11912299.</p> <p>Colorcoat® GP, LG and HPS200 Ultra® are trademarks of Tata Steel UK Limited</p>  <p>Assessed to ISO 9001:2015 Cert/LPCB ref. 635-1</p>

Basic Welding Procedure

Raintite Coated Metal Product

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 **The following are basic guidelines and recommendations as to the procedure for hot air welding of a Raintite Coated Metal product within a guttering application.**

- All procedures should be carried out within the HSE guidelines for working at height and Risk assessments conducted prior to commencement of any procedures.
- Great care should be taken to ensure the joint area of the product is not damaged and is free from any dirt or contamination.
- During the installation process, the use of sacrificial walkway products or walkboards to protect the material surface from manual traffic damage is recommended.
- All contractors should ensure the footwear of their operators is clean and suitable and will not damage the membrane surface. I.e. the use of "Hobnail" type footwear is not recommended.
- The welding process should only be carried out by approved and trained operatives.
- In an Ideal situation the gutter joints should be welded immediately after installation of the gutter section. Splitting the installation team into 2 groups will assist in this process. Group 1 will install and fix the gutter section, immediately followed by Group 2 who will clean and weld the gutter joint. This method of installation will reduce the cleaning process involved and ultimately reduce the installation time.
- The overlap surface of the gutter should be cleaned and any detritus removed, the use of Solvent Cleaner Fatrafal FF860 is recommended for this.
- No sharp implements should be used during the cleaning process i.e. metal spades or shovels, metal scrapers wire brushes or abrasive wools or pads. Soft lint free cloth type materials are ideal for this process.
- Hot air welding should only be attempted in a well ventilated area, extraction should be used if deemed necessary.
- The Hot air gun should initially be set to between 350 and 400deg C, a trial weld should be attempted and the temperature adjusted to compensate for weather conditions and prevailing wind direction.
- The overlap weld should be a minimum of 75mm and created in 3 complete passes.
 - 1 - First 25mm Tack weld the overlap into position.
 - 2 - Continuously weld the next 25mm.
 - 3 - Continuously weld the last 25mm to ensure a watertight seal.
- The Joint should then be inspected with a probe and any potential weak points addressed.
- The joint should then be dressed with a bead of Fatrafal 854 Liquid PVC, this product has been specifically designed to penetrate any potential gaps and will set over the next 12 hours.
- Where a stop end or intersection is being fitted the installer is required to use of Fartafal internal corners at all times. These corners have been specifically designed to suit this type of application and will ensure a watertight seal.
- Finally all visible areas of the gutter joint should be closely inspected with particular attention paid to joints stop ends and outlets.

Failure to comply with any of the procedures contained within this document or the any subsequent documentation issued by Raintite Trading Ltd will invalidate any form of Guarantee / Warrantee implied or inferred.

Version 1.2 October 2015



For more information on our products or to discuss your specific requirements call **01291 423 252** email info@raintite.co.uk or visit www.raintite.co.uk

Raintite Trading Ltd, Unit 11, Symondscliffe Way, Severn Bridge Industrial Estate, Caldicot, NP26 5PW



The following are basic guidelines and recommendations as to the procedure for care & maintenance of a Raintite Coated Metal product within a guttering, pitched and flat roofing application.

- All maintenance and repair procedures should be carried out within the HSE guidelines for working at height and Risk assessments conducted prior to commencement of any procedures.
- Great care should be taken to ensure the weather surface of the product is not damaged during the cleaning / repair process. The use of sacrificial walkway products or walkboards to protect the material surface from manual traffic damage is recommended.
- All contractors should ensure the footwear of their operators is clean and suitable and will not damage the membrane surface. I.e. the use of "Hobnail" type footwear is not recommended.
- Annually. The weather surface of the gutter should be cleaned and any detritus removed, pressure washing or detergent and manual soft brushing are adequate methods. All debris vegetation, animal waste and soil dirt air-borne contaminants should be removed.
- No sharp implements should be used during the cleaning process i.e. metal spades or shovels, metal scrapers wire brushes or abrasive wools or pads.
- A record of all maintenance and or repairs should be held by the building occupier together with the relevant dated invoice from the approved Roofing / Cleaning contractor.
- All visible areas of the gutter should be closely inspected with particular attention paid to joints stop ends and outlets.
- Any mechanical or rodent damage should be immediately repaired in accordance with our repair criterion, utilizing only approved products and methods.

Failure to comply with any of the procedures contained within this document or the any subsequent documentation issued by Raintite Trading Ltd will invalidate any form of Guarantee / Warrantee implied or inferred.

Version 1.1 Dec 2007



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Raintite Coated Metal Product & Membrane Specifications

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 A modified PVC based product, specifically designed for roofing & rainwater products

Conventional PVC roofing technology requires the use of low molecular weight liquid plastisol polymers applied to lightweight fabrics to create a flexible membrane. Over time, UV, heat and environmental contaminants draw the plastisol (plasticizer) to the surface of the membrane where it's washed away by wind and rain. This plasticizer migration reduces flexibility and leaves the membrane susceptible to damage from thermal shock, hail impact and foot traffic. Additional effects of plasticizer migration on the in situ aging process can make the membrane difficult to repair, and subsequently impossible to maintain.

Raintite Coated metal is engineered using an alternate technology whereby a Plasticizer Free PVC, (non-Plasticised Polyvinyl Chloride) is used. This unique development vastly reduces the ageing process and the subsequent potential modes of failure.

This coating technology is then thermally bonded to hot dip galvanized steel with 4 added protective layers of epoxy polyester paint. The result is a high performance membrane coated steel product that remains flexible and ideally suited for roofing and guttering applications.

Product specification

1	Widths	1000mm, 1250mm & 1475mm (Alternative widths by agreement)
2	Steel substrates	0.6m, 1.2m & 1.5m (Alternative thicknesses by agreement)
3	Mechanical properties, suitable for cold forming with any standard production method:- shearing, press brake and folding (with gauge compensation)	Hit dipped Galvanized to BSen 10346 : 2009 DX51d G275 & AZ150 Tolerance to BSen 10143 : 2006
4	Adhesion	100% flat cross hatch & Erickson, cut cross hatch (with tape)
5	Corrosion resistance	Minimum 1000hrs humidity & salt spray (tested to 3000hrs)
6	Hot air welding temperature (no requirement for sealants or cleaning agents)	up to 410 Deg C (Dependant upon ambient temperature)
7	Chemical Bonding	Can be chemically bonded please contact us to discuss the application in detail
8	Cold forming	10 deg C minimum

Membrane specification next page





Membrane specification

1	Thickness	1,2mm +/- 0,25mm minimum (Alternative thicknesses by agreement)
2	Standard widths (Alternative widths by agreement)	1000mm, 1250mm / 1475mm +/- 5mm
3	Surface	Unique Textured anti slip emboss Dry valve 46. Wet valve 34.
4	Colour (Alternative colour subject to minimum order quantities)	Dark grey (alternatives by agreement) RAL 7012
5	Flexibility in low temperatures. Insensitivity to hot-cold cycles	Excellent
6	Resistance to weathering and ultraviolet rays	Excellent
7	Fire precautions	Self extinguishing and does not present Fire hazard when in storage, transit or use Class 0 spread of flame
8	Heat Welding	Fumes are given off whilst welding but do not present a problem in a normal roof situation. Extraction is required for enclosed / confined areas
9	Composition	Non reinforced film manufactured from modified PVC


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Repairs of Small Perforations in the weather surface of Raintite Coated Metal Product

 The following are basic guidelines and recommendations as to the procedure for repairing small perforations of a Raintite Coated Metal product within a guttering, pitched and flat roofing application.

If the surface of the product has been mechanically damaged during transit to site or as a result of foot traffic and insufficient protection, the following procedure should be followed.

- All maintenance and repair procedures should be carried out within the HSE guidelines for working at height and Risk assessments conducted prior to commencement of any procedures.
- If the damaged area is greater than 8mm diameter it is recommended that a patch repair be performed utilizing the hot air welding method, and the edges sealed
- If the perforation is smaller than 8mm diameter and the steel substrate remains intact, liquid PVC Fatrafol 854 can be applied to the damaged area without affecting the product warranty, provided the following steps have been followed.
- The Liquid PVC will cure over the following 24 hours, producing a homogeneous weather surface.
- Thoroughly clean the effected area with solvent cleaner (applied to a small cloth, ensuring the area is completely dry.
- Allow the cleaner to completely evaporate 2-3 minutes is normal.
- Apply the Liquid PVC into the indentation ensuring no air bubbles remain.
- Cut the nozzle of the application bottle to a suitable size and decant the liquid PVC into the bottle.
- The repair does not require excessive use of the liquid PVC, ensuring that the PVC is flush with the surface of the undamaged surrounding membrane is sufficient.
- The Liquid PVC will cure over the following 24 hours, producing a homogeneous weather surface.

Failure to comply with any of the procedures contained within this document or the any subsequent documentation issued by Raintite Trading Ltd will invalidate any form of Guarantee / Warranty implied or inferred.

Version 1.1 Dec 2007



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Raintite Application for 25yr Product Guarantee



Raintite
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 Please fill in your details below, save & email to info@raintite.co.uk

1	Client Name (to be included on guarantee)	
2	Address of building subject to guarantee	
3	Forwarding Address if different from above	
4	Main Contractor (if applicable)	
5	Fabricator name & address	
6	Gutter construction / Type	
7	Area/m ² of membrane coated metal	
8	Date of Completion	
9	Supplier of membrane coated sheet and Invoice / delivery note number	
10	Pack numbers	

 I, the undersigned, certify that the work has been carried out in accordance with Raintite Technical manuals and specification and the installation has been completed to my satisfaction.

Approved contractor		Date	/	/
Title		Your Name		

For Raintite use only

Inspection Date	/	/	Roof Inspection Report completed? YES <input type="checkbox"/> NO <input type="checkbox"/>	Date	/	/
Approved <input type="checkbox"/>	Guarantee Issued <input type="checkbox"/>		T 01291 423 252 www.raintite.co.uk			



Raintite Application for 35yr Product Guarantee

Please fill in the detail below, save and email to:

info@raintite.co.uk

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1	Client Name	
2	Address of building subject to warranty	
3	Forwarding Address if different from above	
4	Main Contractor (if applicable)	
5	Fabricator name & address	
6	Gutter construction / Type	
7	Area m2 of membrane coated metal	
8	Date of completion	
9	Supplier of membrane coated sheet & Invoice / delivery number	
11	Pack numbers	

I, the undersigned, certify that the work has been carried out in accordance with Fatra / Raintite Technical manuals and specification, and the installation has been completed to my satisfaction.

Approved contractor:	
Title:	
Print name:	
Signature:	



For office use only

Inspection date:	
Roof inspection report completed:	
Approved:	
Warranty issued:	



Raintite Trading Ltd, Unit 11, Symondscliffe Way,
Severn Bridge Industrial Estate, Caldicot, NP26 5PW

Company registered in England & Wales No. 5806416 VAT Registration No: 879758241

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PLASCOAT PVC PC80GS



Coating Powder

GENERAL DESCRIPTION

Plascoat PC80GS is a finely divided pvc powder for use in fluid bed coating. Plascoat PC80GS has been specially formulated to give coatings with excellent weathering characteristics, combined with low dirt pick up properties. Used over the recommended adhesive primer, the Plascoat PVC coating maintains long term adhesion to steel and aluminium even under conditions of continuous high humidity, providing a corrosion protection system invaluable where a low maintenance finish is required.

TYPICAL USES

Street furniture:

Plascoat PVC has evolved over 20 years and has gained wide approval for use on balustrading, lighting columns and traffic signposts.

Architectural metalwork:

Exterior components on motor vehicles.
Fencing.
Garden furniture.

WEATHERABILITY

Plascoat PVC PC80GS has been specially formulated to provide long term weather resistance in European type climates.

GUIDE TO TYPICAL COATING CONDITIONS

Batch operation:

Metal preheat temperature min 280°C/max. 320°C

Cure cycle may be required when coating thin metals, heat to 160°C for one minute.

Water quench optional.

Pretreatment for corrosion protection:

Degrease - solvent wash or vapour degrease
Shotblast - to Swedish standard SA 2½-3
Adhesive Prime - using Vyprime EA663

For optimum protection a chemical pretreatment e.g. Zinc phosphate may be desirable.

Plascoat PVC Coating Powders are available in black or grey.

For typical properties of the coating see overleaf.

TYPICAL PROPERTIES OF THE POWDER

Coverage (100% efficiency)*	2.65 m ² /Kg at 300 micron
Particle Size	below 250 microns
Bulk Density	at rest 0.67 g/cm ³ fluidising 0.61 g/cm ³
Fluidising Characteristics	Good
Packaging	25 kg in paper sacks

TYPICAL PROPERTIES OF THE MATERIAL

Specific Gravity*	1.26 g/cm ³
Tensile Strength	BS 2782 320A 13 MPa
Elongation at Break	ISO 527 250%
Hardness	Shore A BS 903 A26 80
Volume Resistivity	10 ¹⁰ - 10 ¹² ohm metre
Dielectric strength	30 kV/mm
Water Absorption (max)	0.5%

**These values may vary from colour to colour*

STORAGE

Plascoat PC80GS is made to order to ensure that the powder has the maximum storage life on despatch. The powder will age slowly at ambient temperature, but good properties will be maintained for at least twelve months with maximum storage temperatures of 30°C. High temperatures, humid conditions or direct exposure to sunlight may lead to plasticiser migration which could make the powder tacky and unusable. Storage areas for Plascoat PC80GS should be kept dry, shaded and as cool as possible; and the oldest material used first to keep stocks fresh.

HEALTH AND SAFETY

Plascoat PC80GS is supplied as a finely divided powder and normal handling precautions for dealing with fine organic powders should be taken - i.e. excessive dust generation and inhaling of the powder should be avoided. The powder can ignite and burn if brought into direct contact with a source of ignition or exposed to abnormally high temperatures.

Reference should be made to Plascoat Health and Safety Data Sheet HS201, available on request.

PLASCOAT PVC PC80GS



Coating Powder

TYPICAL PROPERTIES OF THE COATING

The following data applies to a 400µm coating applied, under standard conditions, onto 3mm thick sheet steel, shotblasted and primed with Plascoat primer.

Appearance	after water quenching	Smooth, glossy finish
Gloss	Gardner 60°C, ASTM D523	78°
Impact Strength	Gardner (drop weight) at 23°C at 0°C	1.7 joules 1.5 joules
Abrasion	Taber ASTM D4060 H18 load 500g, weight loss CS17, load 500g, weight loss	120 mg/10 ³ cycles 30 mg/10 ³ cycles
Environmental Test	Salt Spray ASTM B117-6	240 hours. No change. Less than 3mm under film corrosion from predamaged area.
Accelerated weathering External weathering	QUV ASTM G53-77	1000 hrs some loss of gloss and fading No detectable change after 10 years in Northern Europe
Chemical Resistance*	At ambient temp - dilute acids - dilute alkalis - solvents	Good Good Poor
Safe Working Temperature	(Continuous in air)	60°C max

*Further technical advice may be obtained from Plascoat concerning the effects of particular chemicals or mixtures.

QUALITY

Plascoat is committed to the manufacture and supply of a wide range of thermoplastic coating powders. This service is backed by the unrivalled experience of over 40 years of powder coating application. With a policy of continuous improvement to its range of products. Plascoat reserves the right to alter or amend any item. Stringent quality control procedures are carried out at every relevant stage of manufacture and Plascoat operates a quality management system approved by BSI in accordance with ISO 9001:2000.

Plascoat can also offer, through its many factories in Europe, specialist plastic coating equipment, an extensive custom coating service and a size reduction service for plastics and other materials.

Plascoat is an Axalta Coating Systems company.

Plascoat is a UK registered trade name.

It should be appreciated that the information given here is, to the best of our knowledge, true and accurate. However, since conditions under which our materials and equipment may be used are beyond our control, recommendations are made without warranty or guarantee.

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