Alesta® AP and Alesta® SD

Cleaning and maintenance guidelines

Introduction

Powder-coated surfaces need to be cleaned and maintained regularly to ensure that the decorative and protective properties of the coating are retained over time.
If the coating is not cleaned properly - or is not cleaned regularly - deposits can build up on the surface and prolonged contact could cause damage to the coating. This may include surface defects (such as corrosion) and loss of decorative effect (for example staining, chalking).
Correct cleaning is therefore essential to the long term-performance of the coating and a condition of the Axalta Architectural Warranty.

Building and component design

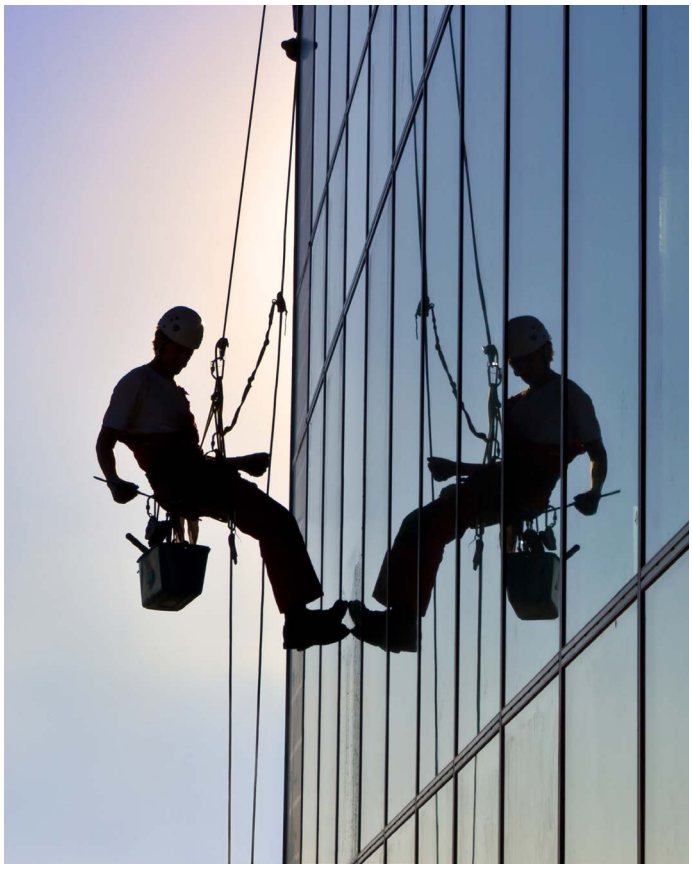
Successful cleaning depends on component design, installation and ease of access:

- Coated components should not include water or dirt traps
- Where possible, design should be optimized to reduce soiling
- Water/dirt run-off across important visual surfaces should be avoided
- Consideration should be given to ease of access for regular cleaning throughout the life of the coating

Cleaning of powder coated surfaces

Normal cleaning should be carried out by regular washing with clean water containing a mild detergent:

- The surface to be cleaned should be cool, not hot (preferably below 25°C)
- Surfaces should be first be rinsed with cold running water to remove any grit and loose deposits.
- Cleaning should be performed with a soft cloth or sponge.
- The detergent should have a pH in the range of 5-8 and must be diluted and used in accordance with the manufacturer's instructions (especially in the case of a fine-textured finish).
- The temperature of the diluted detergent should not exceed 25°C.
- The detergent should only be allowed to remain in contact with the coating for the minimum time necessary to enable effective cleaning. This should not exceed 1 hour.
- Immediately after cleaning, the surface should be rinsed thoroughly with clean, cold running water and then dried using a soft cloth.
- Strongly acidic or alkaline cleaners must not be used (use of hard water should be avoided).
- Abrasive cleaners may cause scratching or other surface damage and must not be used under any circumstances.
- Commercial cleaning agents may cause damage to the coating and should be tested for suitability before use.



Normal cleaning may not be sufficient to remove certain non-water soluble materials. Examples include grease, oil, silicone sealant and residue from adhesive or protective tapes. In such cases:

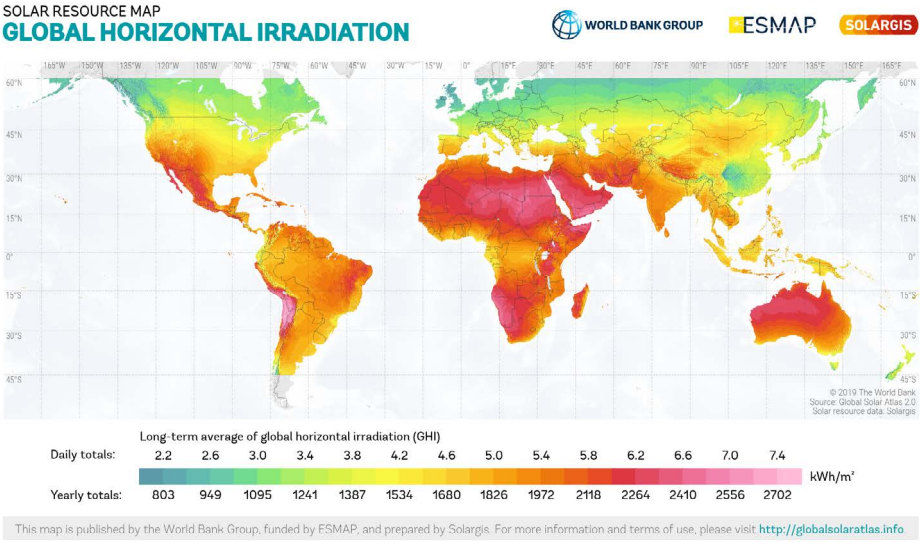
- Diluted Isopropanol may be used (isoproponal/water 70/30).
- It is strongly recommended that a small non-visible area is tested before use.
- Other solvents - or cleaning materials containing solvents - must not be used.
- Solvents comprising or containing ketones, esters, aromatic or halogenated hydrocarbons must not be used under any circumstances.
- Any remaining residue should be removed by cleaning with mild detergent and rinsing (as above).

Cleaning of textured, metallic or pearlescent powder-coated surfaces should be carried out with special care. It is strongly recommended that a small non-visible area should be tested first.
Particular care should be taken with high-pressure cleaning equipment to avoid damage to the coating.
Excessive rubbing should be avoided. Polishing is not recommended as it may result in changes to the appearance of the coating, in particular for special finishes (metallic, textured, matt, etc.).
In case of severe soiling, a soft brush may be used, however, it should be tested beforehand to ensure that there is no risk of scratching the powder-coated surface.

Cleaning Frequency

The need for such cleaning depends on many factors including:

- The geographical location of the building
- The environment surrounding the buildings, i.e marine, industrial, alkaline/acidic, etc.
- Levels of atmospheric pollution
- Direction of prevailing wind
- Possibility of airborne debris, for example: sand causing erosion of the coating or metallic particles (for example, from railway lines) causing staining of the coating
- Protection by surrounding buildings



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Further information may be sought from associations including:

- Qualicoat (Recommendations for Care of Coated Aluminium)
- GSB International e.V (Cleaning of Aluminium Surfaces)
- Aluminium Center, Advisory and Information Service (D-40003 Düsseldorf)
- German Institute for Quality Assurance and Certification e.V (RAL-GZ 632, Cleaning and Protection Facade and Monument)
- American Architectural Manufacturer's Association (AAMA) U.S.A., (AAMA 609 & 610-15 Cleaning Procedures)

Disclaimer

The advice herein is provided by Axalta Coating Systems and is applicable to our Alesta® and Teodur® powder coating products. It is based upon our own experience but does not in any way constitute a warranty.
The implementation of the cleaning and maintenance process remains entirely the responsibility of the final user who must also ensure that it meets his or her own specific requirements.

			Cleaning frequency	
Environment[1]	**UV radiation**	**Pollution**[2]	**Alesta® AP**	**Alesta® SD**
Normal	<1500 kWh/m2	Urban and industrial areas, moderate sulphur dioxide pollution. Coastal areas with low salt content.	12 months	18 months
Severe	<2200 kWh/m2	Industrial areas and coastal areas with moderate salt impact.	6 months	12 months
Hazardous	>2200 kWh/m2	Industrial areas with high humidity and aggressive atmosphere. Coastal and offshore areas with high salt content.	3 months	6 months