

PAINTING A CARAVAN

This leaflet is prepared by The Caravan Club as part of its service to members. The contents are believed correct at the date of publication, but the current position may be checked with the Club's Information Department.

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Aluminium panels used in the construction of modern touring caravans are supplied to the manufacturer pre-painted with a polyester finish which remains flexible when panels are cut and moulded into the required shapes.

Under normal care and conditions this finish should last for many years, but should re-painting be required, this leaflet gives basic advice on how to tackle the work and what materials to use.

These instructions can apply equally to aluminium or fibreglass construction.

1. Preparation

The area to be painted should be washed thoroughly with a proprietary detergent solution to remove all dirt and grease, followed by thorough rinsing with clean water to remove any film left by the detergent. If the caravan has been wax polished, it may need a solvent cleaner like Tetrosyl Panel Wipe. Do not use a synthetic cellulose solvent as it may react against the original acrylic or polyester finish. Stippled finishes may need steam cleaning to remove all traces of protective wax and dirt.

Any peeling paint work should be stripped by physical means. Chemical strippers should not be used on glass fibre or polyester finishes.

Any large dents in aluminium panels should be beaten out as smoothly as possible before priming. After the beating out operation it will be found that the surface of the metal is not entirely smooth. This may be rectified by the use of body filler, applied with a knife or plastic spreader, as used with cars.

The surface to be painted should be lightly abraded with wet and dry or fine emery paper (320 grit by hand, 240 grit with sanding paper or orbital sander), to provide key

for the new paint. Whenever practicable, the use of hard water in wet flatting, rinsing etc. should be avoided, as it leaves traces of mineral salts on the surface. Purified (de-ionised) water is ideal. Finally ensure surface is free of dust and sanding residue - the professionals use compressed air and tak dusters.

2. Painting

Two types of finish can be recommended for pre-painted aluminium panels:

- 1) Conventional external quality domestic paints stocked by normal retail suppliers, for example ICI or Dulux.
- 2) Specialised vehicle refinishing enamel, such as Tekaloid by Breakwells Paints Ltd. See Appendix 1.

APPENDIX 1

Application To Prepared Areas

Priming Aluminium Prior to Application of BC19 Undercoat

CA29 Single Pack Etch Primer By Brush

Ready for use. Apply one coat by brush or roller.

CA29 Single Pack Etch Primer By Spray

Thin CA29 20% by volume using TN18 thinner. Apply one light to medium coat. Allow 2 hours drying @ ambient temperature of 18C +/-2C before applying subsequent undercoats.

Primer/Undercoat BC19 Spray Application

Thin suitable coloured Tekaloid primer/undercoat BC19 with 10% by volume with thinners TN02.

Apply one light coat; allow to flash off after 30 minutes. Apply one full coat; allow to dry for four hours before overcoating with enamel. Wet Flattening can be carried out after this time if required using 400-wet/dry paper. Rinse thoroughly using clean water. Dry off and remove flattening residue using compressed air and tack rags.

Tekaloid Primer/Undercoat BC 19 By Brush

Apply one full coat unthinned. Allow to dry for four hours before overcoating. Flattening can take place as recommended for spray application.

Enamel Finish Tekaloid SEBG18 By Spray Application

Thin Tekaloid BG18 with 10% by volume with TN02 thinners. Apply one light coat. Allow to flash off 30 minutes at 15-18 C. Apply one full coat, allow 16 hours drying before masking and recoating.

Enamel Finish Tekaloid By Hot Spray Application

Heat enamel to 170F /75C. Apply one full coat only. Excessive film thickness can cause crazing. If second coat is required allow at least 16 hours to dry between coats.

Enamel Finish Tekaloid SEBG18 By Brush

Apply one full coat. Allow 16 hours drying before recoating.

Varnish BG18000 (Optional) Spray

Where varnishing is required apply by one spray coat thinned 10% by volume. Allow to dry for 16 hours.

Varnish BG18000 (Optional) By Brush

Apply one full coat by brush. Allow to dry 16 hours.

Note:

The foregoing drying thinning ratio times unless otherwise stated have been calculated taking ambient temperature as 60F/17C. Longer drying times may result from lower temperature.

All coatings to be applied in accordance with manufacturers relevant technical data sheets.

Material Description

Tekaloid SEBG18 is a quality coach enamel based on synthetic alkyd resins. The material is designed for use either by spray or brush application. Tekaloid SEBG18 dries to a high gloss durable finish.

Flash Point

Tekaloid will dry under less favourable conditions than most air drying enamels. However, it should be applied at a temperature higher than 45F/7C. Under normal conditions of temperature and humidity, Tekaloid becomes dust proof in approximately 1-2 hours or even sooner if applied by hot spray. After overnight drying it can be flattened to a very fine surface in the usual way, and if required another coat may be applied.

For further information on Tekaloid products none of which contain lead, please contact:

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