



**ASTEC #900 System
Ductwork**

2/17/04

**ALL GENERAL REQUIREMENTS
AND ARCHITECTURAL DETAILS ARE
PART OF THIS SPECIFICATION**

- 1. PREPARATION** shall include but not limited to structurally sound, solid, clean and dry surfaces.
- 2. SUFFICIENT DRAINAGE** shall be required to allow coating proper curing time. Curing time will vary due to temperature and humidity. Under normal weather conditions, 21 days is needed prior to 24 hours ponding. No ponding is allowed for the first 48 hours after application.
- 3. INSTALLATION of ASTEC #900** final coat shall be made when temperatures are 40 degrees and rising. Even dry to touch, the **ASTEC #900** final coat will continue to cure for up to 21 days. Should persistent ponding occur in this period, blow or sweep water from the application surface so that cure can continue.
- 4. METAL** surfaces shall be dry, clean, free of dirt, rust, corrosion and other contaminants which could affect the bond of the **ASTEC SYSTEM**.
- 5. ALL JOINING METAL SECTIONS** shall be properly closed and mechanically fastened. All screws and fastening devices shall be retighten or replaced
- 6. JUST PRIOR TO APPLICATION**, all dust, dirt and other contaminants must be removed by brushing, vacuuming, power blowing and washing or power water washing.
- 7. IF CORROSION IS PRESENT**, scaling rust shall first be removed by scraping and mechanical wire brush. A minimum two coat application of **ASTEC B-16-71 Metal Primer** shall be applied to the surface at a minimum coverage rate of 300 sf/gal per coat over rusted areas.
- 8. Apply ASTEC #4000 Surface Conditioner** at a rate of 200 sq/ft per cut gallon over entire areas of previously coated, painted, factory applied color, or surfaces with silver aluminum coatings to provide proper adhesion of the subsequent coatings.
- 9. ALL EXPOSED CRACKS** and seams in the metal sections shall be caulked **with ASTEC #2001 Caulk**, 100% urethane, or 100% acrylic caulk.
- 10. AFTER CAULK** has skinned over, **WPM #9** shall be applied at a rate of 100 sf/gal to an area at least four inches on either side of the caulking bead.
- 11. A 4" WIDE POLYESTER CLOTH** is embedded into the wet strip of WPM #9 (100 sf/gal) centered over all joints, flashings, and repair areas in the deck. A brush or roller shall be used to assist in this embedding process. A second wet strip of WPM #9 (100 sf/gal) is applied over the top of the cloth and two inches on each side of the cloth and two inches on each side of the cloth edge.
- 11. THE FINAL COAT** of application shall be **ASTEC #900** applied by brush, roller or sprayer over the entire surface at a minimum coverage rate of 74 sf/gal.

NOTE:

After priming with **ASTEC B-16-71** or if surface is a dark color, apply a **thin** coat of **ASTEC #900** to bring surface temperature down. Then apply remainder of finish coating to meet specifications.