

## STANDARD OPERATION PROCEDURE

Description of Operation	To install lines and bay markings using ViaLine F210, applied using spray equipment	
Tools and Equipment Required	1. ViaLine F210 White [or colour to suit]	
	<b>Spray application:</b> 2. 50-75mm wide lines 217 Yellow Spray Tip* 3. 100mm wide lines 319 yellow Spray Tip* 4. 150mm wide lines 321 or 421 yellow Spray Tip* *PLEASE NOTE - it may be necessary to alter tip sizes to compensate for temperature variations. Refer to tip chart at end of SOP for fuller details	
	5. Stiff Wire Broom	
	6. Blue Poly Yard Brush	
	7. Drill and Mixing Paddle	
	8. Chalkline [if using spray machine fitted with GuideLazer 2000 this may not be necessary]	
	9. Gaffer tape	
	10. SF Thinners X290	
	11. UltraClean X792 Advanced Cleaner	
	12. Measuring instrument kit	
	Preparation	1. Use wire broom to remove any loose or flaking material
		2. Use yard brush to sweep area clean
3. We recommend mechanical preparation to the surface, to ensure it is prepared and in the best condition to receive primer and paint. Examples of suitable equipment are scabblers such as GrindLasers for external surfaces, shotblasters or grinders for internal smooth floors.		
4. Check site conditions to ensure they are suitable for application: <ul style="list-style-type: none"> <li>• Measure ground temperature [5°C and rising]</li> <li>• Measure air temperature - [minimum of 5°C and at least 3°C above dew point]</li> <li>• Measure relative humidity [less than 80%]</li> <li>• Measure substrate moisture content [less than 10%]</li> </ul>		
5. Prime with UniPrime X250 primer [see SOP.014 - Primer application]		
<b>Spray application:</b> 1. Load paint into spray machine and check spraying satisfactorily 2. It may be necessary in cooler temperatures to thin the paint using SF Thinners X290 3. If the paint is not spraying properly, ie coming out in a thin jet rather than a fan, try thinning. 4. Start with 5% [approx. 1 litre of thinners per 20kg of paint] and test spray; if not enough, repeat and check again. You can thin up to 20% maximum, [ie approx. 4 litre of thinners per 20kg of paint] 5. Do not use UltraClean X792 for thinning ViaLine F210		

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Application	1. Apply ViaLine F210 taking care to apply evenly. Do not over-apply		
	2. A second coat can be applied for extra durability, if required		
	3. Peel away gaffer tape once paint applied, if used		
	4. Once operation completed, clean equipment and tools with UltraClean X792		
	5. Please take great care to be aware of your surroundings and the presence of any customers or other personnel in the area.		
	6. Suitable traffic management should be employed to protect yourself, your equipment and to prevent any traffic over uncured paint		
	7. Suitable PPE should always be worn		
	8. Full procedures for machine set-up, spray pressures, colour changing and cleaning are all outlined in relevant sections of the training manual.		
	9. Please refer to the manual if in any doubt about these.		
Site Conditions	It is important that due attention is given to the prevailing temperatures and conditions in the immediate environment. Specific guidelines are given on Tech Data Sheets, as a blanket good practice there are 3 key criteria which need to be observed:		
	1. Surface temperature - minimum of 5°C - measured using Digital thermometer		
	2. Air temperature - minimum of 5°C and at least 3°C above dew point [this may be considerably more than 5°C] - measured using Multifunction dew point thermometer		
	3. Humidity - less than 80% - measured using Multifunction dew point thermometer		
	4. Substrate moisture content - less than 10% - measured using Moisture meter		
Suggested Spray Tip	Product	Line Width (mm)	Suggested Tip
	ViaLine F210	50	215
		75	217
		100	319
		150	421
		200	627
		Stencil	317 (green)
Please note the above table is a guide only. Paint may need to be thinned as well at cooler temperatures and site conditions <b>must</b> be suitable.			

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Typical output rates per shift	<p>750 - 3000 metres of 100mm wide lines</p> <p>There are several components to be considered to arrive at an "output per shift", namely</p> <ol style="list-style-type: none"><li>1. Preparation, including cleaning, priming</li><li>2. Marking out of work to be completed</li><li>3. Any masking out there may need to be</li><li>4. Set up of any equipment</li><li>5. Application methods, ie machine or hand applied</li><li>6. Cleaning up</li></ol> <p>Output rates are therefore subject to specific site conditions. We have allowed for all the above considerations and the output rate includes preparation and priming, as well as setup and cleandown. A "shift" is 6 working hours on site, for one person, for purposes of our guidelines. A 2 man team would double the output per shift in most cases</p>
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