



DESCRIPTION

GALVACOAT® is a 2 component polyurethane-acrylic anti-corrosion and adhesion top coat. It is specifically designed to adhere directly to new and weathered Hot Dip Galvanized surfaces.

GALVACOAT® can be applied by brush, roller or spray equipment.

It has very good resistance to UV exposure and can therefore be applied as a one coat system in outside weathering conditions.

ACTIVE PIGMENT

Zinc phosphate

GLOSS

Matt/ satin 14-22 Gardner 60; Gloss 40-45 Gardner 60

COLOUR

All RAL and BS colours available.

PHYSICAL PROPERTIES

Density.....: 1.3 - 1.4
Solid content.....: 60% by volume
Theoretical yield.....: 7.5m²/kg at 50 microns
Viscosity.....: Thixotropic

DRYING TIMES

Dustfree.....: 1 hr
Tack free.....: 4hrs
Hard.....: 20hrs
Recoatible.....: 12hrs
Recommended thickness.....: 40 - 120 microns
Potlife.....: 6 - 8hrs at 20C

SURFACE PREPARATION

The galvanizing to be coated must be free of dust, rust, oil, grease and soluble salts (white rust).

After welding, any damage to a galvanized film should be cleaned and any rust removed. A cold galvanized material with a minimum zinc content of 92% should be applied to the damaged areas at a minimum thickness of the galvanized film plus 10%.

A combination of degreasing and steam cleaning is the optimum way to remove any dirt, grease and zinc salts.

Wash down with fresh water.

USE

Add the hardener to the base paint and mix well.

DILUTION:

Airless application..... Dilute 0-10% with thinner PU41

Airmix application..... Dilute 5-10% with thinner PU41

Air assist application.....Dilute 10-20% with thinner PU41

Recommended spray nozzle size for airless spray : 0.015-0.017"; 50-80 degree angle

APPLICATION CONDITIONS

Relative air humidity : max 85% (no condensation on the substrate)

Temperature during application and drying : 2C above the dew point. Never apply below 5C.

Max. temperature during application : 40C

FOR BEST APPLICATION RESULTS REMEMBER:

- ✓ Always ensure that the galvanizing is clean and dry and that any zinc oxide (white rust) has been removed.
- ✓ Add all the hardener to the base and stir together well, once.
Do not continually stir as agitating the material only serves to generate heat which reduces the pot life.
- ✓ Do not apply GALVACOAT when it is raining or the temperature is likely to go below 5C within 2-3 hours.
- ✓ When applying a light colour (white, yellow), it is advisable to stripe coat all edges and vertical surfaces with GALVACOAT before applying a full coat, as it is difficult to get sufficient material on an edge to cover in one coat of a light colour.
- ✓ Ensure that no more than three days passes between the cleaning down of the galvanizing and the application of GALVACOAT.

TEST RESULTS

GALVACOAT[®] has been adhesion tested to ISO 2409, BS 3900 part E6 (1992) and DIN 53151.

GALVACOAT[®] has been subjected to mechanical tests under DIN 53156 (Erichsen Cupping Test) and DIN 53153 (Bucholz Hardness).

GALVACOAT[®] has been salt spray tested to DIN 52155.

All the above tests were carried out on Hot Dip Galvanized panels.