



## 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.....: 7.5m<sup>2</sup>/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**<sup>®</sup> has been adhesion tested to ISO 2409, BS 3900 part E6 (1992) and DIN 53151.

**GALVACOAT**<sup>®</sup> has been subjected to mechanical tests under DIN 53156 (Erichsen Cupping Test) and DIN 53153 (Bucholz Hardness).

**GALVACOAT**<sup>®</sup> has been salt spray tested to DIN 52155.

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