



422 GALVAPLAS

PRODUCT DESCRIPTION

A single pack Zinc Rich coating, designed to be used on steel window frames and door frames to paint over weld lines and bare steel seams, may also be used on shed constructions.

FEATURES

- Provides galvanic protection to prepared steel surfaces.
- Economic, single pack primer of sacrificial type, resists underscore corrosion.
- Superior protection to inhibitive zinc chromate primers.
- 24% Zinc Content

PRODUCTS

422 Galvapas		422-6015
Reducers		
	<i>Small Areas</i>	AER20 Alkyd Enamel Reducer
	<i>Large Areas</i>	125 Acrylic Urethane Reducer
Cleaners		
		971-9119 PROTEC® Metal Conditioner
		AA-6822 <i>Protec</i> Heavy Duty Wax & Grease Remover

SURFACE PREPARATION



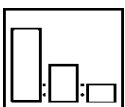
All surfaces must be free from mill scale, bloom rust, oil and grease

Abrasive blast to AS 1627.4 Class 2.5

Coat surfaces with Zincoat 10 before re-rusting appears

Where abrasive blast cleaning is not possible, thorough mechanical cleaning is necessary to remove rust and scale

MIXING RATIO BY VOLUME



422 GALVAPLAS	100	
Reducer	Up to 15%	<i>(by volume)</i> Spray application

SPRAYGUN



CONVENTIONAL, HVLP

SETUP

- GRAVITY 1.8 mm - 2.0 mm
- SUCTION 2.0 mm - 2.2 mm

SPRAY PRESSURE

- CONVENTIONAL 3.0 - 4.0 bar (300 - 400 kPa, 45 - 60 psi)
- HVLP / RP 2 - 3 bar



AIRLESS, AIR ASSISTED AIRLESS

SETUP

- TIP 0.011 - 0.013
- PUMP RATIO 32:1

SPRAY PRESSURE

- AIRLESS 100 - 140 bar
- AIR ASSISTED AIRLESS 70 - 100 bar

APPLICATION & FLASH OFF



- CONVENTIONAL, HVLP 2 wet, even coats
- BRUSHING 1 - 2 coats

Allow 5 - 10 minutes flash off between coats at 25°C

Note: Do not apply at temperatures less than 10°C, when the relative humidity exceeds 80%, or if the surface temperature is within 3°C of the dew point.

DRYING TIMES



AIR DRY (25°C)

- TOUCH DRY: 20-30 minutes
- SURFACE DRY: Up to 2 hours
- HARD DRY: Overnight

Note: Drying times can vary dependent on temperature, flash off between coats, film builds and number of coats applied.

RECOAT



Can be recoated after overnight drying with recommended generic Alkyd Topcoats.

TOTAL DRY FILM BUILD

Spray / Brush one coat at a coverage of 9m²/Litre at a wet film thickness of approximately 100µm.

This will give a dry film thickness of approximately 50µm.

TECHNICAL PARAMETERS

VOLUME SOLIDS (RFU)	38%
COVERAGE	9m ² /L
RESISTANCE PROPERTIES	
WEATHERING	Good
ABRASION	Fair
SOLVENT	Poor
CHEMICAL	Poor
HEAT	Satisfactory up to 120°C Dry Heat
IMMERSION	Not recommended

EQUIPMENT CLEANING

After use, clean all equipment thoroughly with cleaning solvent or thinner.

HEALTH AND SAFETY

Please refer to Safety Data Sheets (SDS) for full Health and Safety details, as well as product can labels.

Hardeners and activated products contain isocyanate and therefore particular safety precautions must be taken; please refer to SDS for full health and safety details.

This product is for professional use only.
The information given in this sheet is for guidance only. Any person using the product without first making further inquiries as to the suitability of the product for the intended purpose does so at his or her own risk and we can accept no liability for the performance of the product or for any loss or damage (other than death or personal injury resulting from our negligence) arising out of such use. The information contained in this sheet is liable to modification from time to time in the light of experience and our policy of continuous product development.
Drying times quoted are average times at 25°C/77°F. Film thickness, humidity and shop temperature can all affect drying times.

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