

## ZINCPLAST 11254 GREY

Protective primer base zinc phosphate and inert pigments



### technical data sheet

Revision 1 fro 31/01/2017

**Destination** Used for agricultural machines, metal carpentry and general industrial artefacts. Can be used also in industrial bodywork. Can be used also on pre-treated aluminium or galvanised steel. Possible to apply also on plastic material, rigid PVC and ABS). Overcoatable with nitro, synthetic and air enamels R.E., PUR and oven ones.

**Characteristics** Excellent anticorrosive power  
Excellent adhesion  
Fast drying  
Allows application wet/wet

**VOC (Directive 2004/42/CE) ( g/l )** Monocomponent paintings at high performances.  
EU limit value for this product (Cat. A/i): 500 g/l (2010). This product contains max. 500 g/l

**Recommended surface and temperature conditions** Avoid applications at room temperature under +5°C or over +35°C and relative room humidity over 80%. Verify surface suitability according to humidity degree with hygrometer . Support temp: min: +5°C - max +35°C.  
WARNING: areate the environment to avoid humidity accumulation  
WARNING: the complete film polymerisation comes after 7-10 days at T=20°C e U.R.60%  
Avoid applications with superficial condensation or under direct sun action  
In enclosed spaces, properly ventilate the area during appliaction and drying

**Reccomendations** Well mix before use.  
It is recommended to apply uniformly the product along the whole surface to paint in order to do not leave uncovered parts from which it could start a deterioration process of the applied cycle film and of the support. High humidities can lead to opacifications during the application. For the painted surfaces cleaning it is recommended to use soft sponges with neutral detergents. Avoid to use abrasive clothes or detergents containing alcohol or solvents of any type.

In order to obtain an excellent result concerning the surface homogeneity and the drying uniformity, we reccomend to avoid the application under the direct exposition to the sun.

The antirust-painted surfaces must be recoated as soon as possible with finish enamels , in order too keep unchanged over time the anticorrosive power of their pigments, which could be considerably reduced for long periods outdoor



## ZINCPALST 11254 GREY

Protective primer base zinc phosphate and inert pigments



### technical data sheet

Revision 1 fro 31/01/2017

#### Application cvcle

##### NEVER PAINTED FERROUS METAL SURFACES

Completely remove the possible calamine and rust on the surface through sandblast sa 2 1/2 or through hand or mechanical cleaning system (brushing ST3). The sanded surfaces must be recoated with antirust primer within 8 hours. Carefully wash to remove possible contamination substances. Be sure that the support is completely dry. Apply 1 layer of anticorrosive primer as our ZINCPALST 11254. After at least 12 hours apply 2 layers of FINITURA SMALTO with an intreval of at least 24 hours from each other.

##### ALREADY PAINTED FERROUS METAL SURFACES

Cleaning with hand or mechanical system until complete elimination of the old painting layers not well anchored and of possible points of rust. Roughen the old well anchored paintings and remove the dust. In case of particularly deteriorated surfaces it is recommended to remove the ols paintings and the rust which comes from sandblasting Sa 2 1/2 ou ude adequate paint stripper and then remove the rust through hand or mechanical system (brushing ST3).

The sanded surfaces must be recoated with antirust primre within 8 hours. Remove the dust from the surface. Be sure that the support is completely dry. Apply 1 layer of anticorrosive primer as our ZINCPALST 11254. After at least 12 hours apply 2 layers of FINITURA SMALTO.

##### GALVANISED SURFACES, ALUMINIUM AND LIGHT ALLOYS

Carefully clean the surface from possible traces of oxide through cleaning with hand or mechanical cleaning. Otherwise carefully wash with solution DECAPHOS or alkaly detergents leaving it for some minutes with following wash for the complete elimination of the phosphating and oickling solution . Residual of DECAPHOS solution or alkaly detergents can compromise the success of the painiting cycle. Be sure that the product is perfectly clean. Apply 1 layer of anticorrosive primer ZINCPALST 11254. After at least 12 hours apply with FINITURA SMALTO.

##### PVC AND ABS SURFACES

Remove the dust from the support .  
Be sure that the support is completely dry  
Apply 1 layer of anticorrosive primer as our ZINCPALST 11254  
After at least 12 hours apply FINITURA SMALTO.

## ZINCPLAST 11254 GREY

Protective primer base zinc phosphate and inert pigments



### technical data sheet

Revision 1 fro 31/01/2017

### Characteristics and technical informations

Data observable at T=20°C and 60% relative humidity

<b>Tin aspect</b>	Liquid
<b>RESIN</b>	Alkyd
<b>Color</b>	Light grey

### Use



Spray gun



Brush



Roll



<b>Thinner</b>	CS/2 - CS/3000
----------------	----------------

<b>Tools' cleaning</b>	CS/2 - CS/3000
------------------------	----------------

### Application process

#### Air Spray

Thinner (% Volume)		20 - 30
Noozle diameter	1,2 - 1,4	
Noozle pressure (Atm/Mpa)	3 - 4	

#### Airless spray

Thinner (% Volume)		CS/2 - CS/3000
Noozle diameter	0,46 - 0,53	
Noozle pressure (Atm/Mpa)	150 - 180	

#### BRUSH / ROLLER

Thinner (% Volume)	CS/2 or CS/3000	5 - 10
--------------------	-----------------	--------



# ZINCPLAST 11254 GREY

Protective primer base zinc phosphate and inert pigments



## technical data sheet

Revision 1 fro 31/01/2017

### TECHNICAL DATA

Mass density ( kg/l )	1,40	
Solids content by vol. ( % )	41	
Solids content by weight ( % )	35	
Brookfield viscosity (cP)	-	
ASTM 4 cup viscosity ( s )	-	
Brilliance ( % )	<10	Mat
Out of dust (minutes )	15 - 20	
Touch dry ( h )	1 - 2	
Depth dry ( days )	12 - 18	
recommended dry film thickness (dtf) ( μm )	30 - 40	
Theoretical spreading rate ( mq <sup>2</sup> /lt )	8,7 - 11,6	
Complete polymerisation - days	7 - 10	
Recoating interval ( h )	min. 24- 48 h; max 15 - 20 gg	
Minimum film temperature ( °C )	5	
Dirt pick-up class UNI EN 10792		
Resistance to washing (UNI 10560) cycles:	-	
Flashpoint ( °C )	> 22	
Temperature resistance ( °C )	120	
Sandable ( h )	-	

**Notice** Data refer to the product mixed at 20 °C.

### STORAGE (dry and cool place)

24 months in tightly closed package, protected from frost and heat sources

### Storage temperature (°C)

+5 ÷ +30

### Unit size

0,50 - 2,5 lt

## ZINCPLAST 11254 GREY

Protective primer base zinc phosphate and inert pigments



technical data sheet

Revision 1 fro 31/01/2017

### Safety instructions

Products must be treated with attention, avoid the skin contact. Users will have to follow the actual laws. Actions as wet sanding, sanding, removal with flame, etc. of old painting coats can generate dust and dangerous smokes. Work in well aerated areas and wear the adequate individual protection means.

In Italy Decree 303 and 547 concern the rules valid for the application operations. For further information concerning the right product elimination, storage and manipulation please consult the relative technical data sheet. Data in this technical sheet are only given for information and are the result of laboratory tests and practical experience. However, the factory is not responsible if the product isn't used under its direct control.

SESTRIERE VERNICI Srl Technical Assistance is available to give all information necessary for a correct use of the product.

Be careful: the product could show, towards some subject who are particularly sensitive to isothiazolones, a little irritation. It's thus recommended to use gloves and protective glasses and to wash very well the parts which could by chance touch the skin.