ZINGALUFER

Zingalufer is a moisture curing one pack polyurethane. Micaceous iron oxides create the special lamellar structure which create a very tight paint film for optimal barrier protection and corrosion resistance. Zingalufer is used as a sealer on ZINGA, as intermediate coat in a three layer ZINGA system.

PHYSICAL DATA AND TECHNICAL INFORMATION

WET PRODUCT

Components	- Micaceous Iron Oxides - Aluminium Silicates - Magnesium Silicates
Binder	Moisture curing aromatic polyisocyanate prepolymers
Density	1,52 kg/dm³ (±0,05 Kg/dm³) at 20°C
Solid content	- 79% by weight (± 2%) - 66% by volume (± 2%)
Type of thinner	Zingasolv
Viscosity	105 KU (±5 KU) at 20°C
VOC	< 300 g/L (= 198 g/Kg)

DRY FILM

Colour	Grey
Gloss	Mat

PACKING

1 L	Available
5 L	Available
10 L	Available
20 L	Available

CONSERVATION

Shelf life	2 years in the original, unopened package.
Storage	Store in a dry environment at temperatures between –20°C and +40°C.

CONDITIONS

SURFACE PREPARATION

When the waiting time between the successive coats is abnormally prolonged or in extremely polluted areas, the Zinganised surface can become contaminated. All contaminations that hamper the adhesion of the paint should be removed by appropriate means. Salt deposits or other water-soluble contaminations should be removed with water and brush, water under high pressure or steam. Possible white rust on ZINGA should be removed with water and rigid nylon brush.

ENVIRONMENTAL CONDITIONS DURING APPLICATION

Ambient temperature	- Minimum 0°C - Maximum 35°C
Relative humidity	- Minimum 30% - Maximum 98% - Do not apply on a damp or wet surface
Surface temperature	- Minimum 3°C above the dew point - No visual presence of water or ice

APPLICATION INSTRUCTIONS

GENERAL

Application methods	Zingalufer can be applied on top of ZINGA by brush and roller, conventional spray-gun or airless spraying.
Stripe coat	It is always recommended to treat corners, sharp edges, bolts and nuts before applying a uniform coat.
Cleaning	Cleaning of equipment with Zingasolv.

APPLICATION BY BRUSH AND ROLLER

Dilution	5 to 10% with Zingasolv (v%)
Type of brush or roller	Industrial round brush

APPLICATION BY CONVENTIONAL SPRAY-GUN

Dilution	10 to 15% with Zingasolv (or Thinner 41)
Pressure at the nozzle	3 to 5 bar
Nozzle opening	1,2 to 1,5 mm

APPLICATION BY AIRLESS SPRAY

Dilution	5 to 15% with Zingasolv (or Thinner 41)
Pressure at the nozzle	100 to 300 bar
Nozzle opening	0,017 to 0,024 inch

APPLICATION ON ZINGA

Mist (tie) coat	- Application at least 6 hours after ZINGA is touch dry. - 25-30 µm DFT - Diluted according TDS
Full coat	- 2 hours after touch dry of mist coat - DFT = specified DFT - 20-30 µm DFT - Diluted according TDS

OTHER INFORMATION

COVERAGE AND CONSUMPTION

Theoretical coverage	- For 80 µm DFT: 8,3 m²/L - For 100 µm DFT: 6,6 m²/L - For 150 µm DFT: 4,4 m²/L
Theoretical consumption	- For 80 µm DFT: 0,12 L/m² - For 100 µm DFT: 0,15 L/m² - For 150 µm DFT: 0,23 L/m²
Practical coverage and consumption	Depends upon the roughness profile of the substrate and the application method.

DRYING PROCESS AND OVERCOATING

Drying time	For 80 µm DFT at relative humidity of 75%: - 10°C: Dustdry: 2,5 hours Tackfree: 4 hours Dry: 8 hours - 20°C: Dustdry: 1 hours Tackfree: 2,5 hours Dry: 6 hours - 30°C: Dustdry: 40 minutes Tackfree: 1,5 hours Dry: 4 hours
Overcoating	For 80 µm DFT at relative humidity of 75%: - 10°C: Minimum: 24 hours Maximum: 3 months - 20°C: Minimum: 6 hours Maximum: 1 month - 30°C: Minimum: 4 hours Maximum: 1 week Remark: At longer intervals a good cleaning is necessary to avoid intermediate coat contamination which could disturb the adherence of the next coat.

RECOMMENDED SYSTEM

ISO 12944	Tested according to ISO12944 in industrial zones with high humidity and aggressive environment (continuous condensation and high pollution) (C5 I) and in coastal zones and marine zones with high salinity (continuous condensation and high pollution) (C5 M) with high classification (Life expectancy > 15 years): ZINGA 1 x 60-80 µm DFT Zingalufer 1 x 80 µm DFT

For more specific and detailed recommendations concerning the application of Zingalufer, please contact a Zingametall representative. For detailed information about the health and safety hazards and precautions for use, refer to the Zingalufer safety data sheet.