
MANOR

PRODUCT DATA SHEET



ZINFOS 490

INTENDED USE

METAL FINISHING

A medium solids 'one coat anti corrosive' semi gloss finish (40% gloss). Applied by airless spray Zinfos 490 has been designed to assist processes conform to the VOC SED regulations for metal processes emitting less than 15 tonnes of VOC per year. It has excellent application properties and sag resistance.

Typical applications include: portable accommodation units, containers, metal stillages, exterior of storage tanks, waste containers, farm buildings painted in spray shop and original equipment.

DECORATION OF BUILDINGS

Typical uses are the commercial decoration of internal factory steelwork e.g. steel, old galvanised steel and previously painted surfaces. Where the product is normally applied by brush and roller unless spraying can be adequately controlled.

VOC classification 2004/42 Cat A/(i) = 500 g/litre

See also the Manor supplementary information sheet 'Guide to the UK VOC legislation' to understand how the VOC content of a coating determines its suitability for use in any application.

SUITABLE SUBSTRATES AND PREPARATION

Untreated steel; for best results blast clean prior to painting to SA 2 1/2, otherwise manually abrade using powered hand tools and abrasives to ST2.

Previously painted steel; remove rust back to sound metal. Remove loose or flaky paint. Bring forward by patch priming. Sound previously painted surfaces should be lightly abraded prior to application in order to promote adhesion.

Remove dust. Remove oil or grease with Panel Cleaner. If using a waterborne degreaser remove fully. Test a small area prior to painting.

Aluminium and galvanised steel; abrade and pre-treat with Manor Wash Primer, Manor Chromate Free Wash Primer or Manor 1 Pack Etch Primer in accordance with data sheets for these products.

Other substrates; seek advice from Manor Coating Systems Technical Department

AVAILABILITY

5 and 15 litre containers in an extensive range of colours from the Manormix scheme

**PRODUCT
INFORMATION
(TYPICAL FIGURES)**

Composition	Based on a modified alkyd resin pigmented with suitably selected pigments, barrier extenders and modified zinc phosphate anti corrosive pigment.
Volume Solids	47%
Weight Solids	65%
VOC content	450-475 g/litre
Supply Viscosity	4.0-4.5 poise at 20 C
Typical film thickness	160 microns wet and 75 microns dry by airless spray
Theoretical coverage	6.5 sq metres/litre at 160 microns wet film thickness
Dry heat resistance	80 C
Flash Point	Within the range 21-31 C

**APPLICATION
DETAILS**

PREFERABLY BRING PAINT TO 15-25C AND STIR WELL BEFORE USE

Airless spray:	cold	The product is supplied ready for use by airless spray. Typical tip size 15-17 thou or 0.43-0.53 mm. Typical fluid pressure 170 kg/sq metre or 2400 p.s.i.
	heated	As for cold airless but keep temperature below 30C
Conventional spray		Up to 10% thinners may be added to suit equipment, but film thicknesses will be appreciably lower.
Brush Roller		Not recommended but small areas can be brushed for touch up.
Thinner		Industrial Thinner

Film thickness per coat

	<u>Dry</u>	<u>Wet</u>
Minimum	50 microns	110 microns
Maximum	100 microns	220 microns

DRYING AND RECOATING

Approximate drying times at 75 microns d.f.t.

<u>Substrate temperature</u>	<u>Touch Dry</u>	<u>Overcoating times</u>	
		Minimum	Maximum
10C	2 hours	4 hours	Same day or after 7 days (see note)
20C	1 hour	2 hours	Same day or after 7 days (see note)

Note

Striping within 48 hours of original painting.
Once the original coating is dry enough to mask up, stripe with Zinfos 340WS which is high opacity and due to its solvent blend is extremely unlikely to attack the original coating.

Environmental conditions

Drying.
Force drying will significantly enhance gloss levels.
The air temperature should be at least 5C with a surface temperature 3C above the dew point and the relative humidity below 80% thus ensuring that the surface is dry and that condensation will not occur during application or drying.

Drying will slow significantly at temperatures below 10C.

Do not apply in conditions below 5C

Overcoating / repainting

After painting keep items out of direct rain and excessive condensation for 24 hours.

Zinfos 490 is a 'one coat' finishing system and as such should not require overcoating. Should an overcoat with Zinfos 490 be required for instance on a colour change then:

- Wet on wet; may be applied wet on wet
- Painted within the last 24 hours; the coating must be left at least 24 hours from initial painting to cure prior to re-coating
- Painted between 24 hours and 14 days. If there is a defect on the original surface or coating that requires flattening out. Flat out. Leave for 16 hours prior to re-coating or force dry for 1 hour with a metal temperature of 80 C. Apply thin mist coats rather than full wet coats.
- Coating more than 14 days old; if the original coating has had more than 14 days to cure the surface must be abraded prior to overcoating.

SHELF LIFE

Store in cool, dry conditions, typically 5-25C. After a period of storage the product should be thoroughly stirred. Usable life is 2 years from date of manufacture in unopened containers.

SAFETY PRECAUTIONS

Refer to Manor Safety Data Sheet

LIMITATIONS

The information given in this data sheet is based on experience and is accurate to the best of our knowledge. No guarantee should be implied however, since the conditions of use are beyond our control. This data sheet does not constitute a specification.

A Painting Guide can be accessed via our website which provides additional information on paint and painting and definitions of terminology.

In case of doubt as to the suitability of the product please consult our Technical Department. If you are advised that the paint can be used in a manner not specified on this datasheet our Technical Department will confirm this to you in writing. Do not use paint prior to receiving this confirmation.

References to other primers, topcoats, cleaners and thinners are to the Manor Product of that name only.

This data sheet supercedes all previous issues.

REFERENCES

Amended date: December 10, 2012

Reference and number: Z4- 4