

Technical Data Sheet

GRÖNOLUX SYNTHETIC METALGROUND WITH ZINCPHOSPHATE 050-colour shade

Serial-No.	050-colour shade
Colour	RAL- and special tones
Gloss degree	mat
Characteristics	<ul style="list-style-type: none"> • good flow for vehicles suitable • fast drying and very good corrosion protection • with 1C-synthetic resin and 2C-PUR-paints recoatable • resprayable earliest after 30 min. or if the primer is mat and tack-free • at a minimum thickness of 80 µm is a free storageing of 12 month given
Areas of application	Priming of steel constructions and steel surfaces in vehiclesl, machinery, apparatuses and containers.

Preparation of the surface

The surface to be coated or primed must be clean, dry, firm and free of grease and dust. As well it must be free of mill scale, rust and other loose surface products, which may affect the adhesion negatively. Appropriate measures for pre-treatment are sandblasting according to EN ISO 12 944 / Part 4, on standard quality SA 2 1/2, metallic pure. In so doing, it is particularly in case of open-air storage of primed parts – important to observe the depth of surface roughness when determining the film thickness of the coating.

Chemical processes, such as alkaline degreasing and iron- or zinc-phosphatising are also suitable pre-treatment. Zinc-plated, non-iron-metal, aluminium and stainless steel surfaces must be cleaned with an suitable cleaner (solvent-based or solvent-free). If necessary surface should be sanded or swept prior to the painting process and a suitable primer should be used. Nonsustainable old coatings should be removed, sustainable coatings should be sanded down. We recommend to carry out a test application to check adhesion.

Suitable undergrounds + = very good adhesion o = test adhesion - = no adhesion

	1C-System	
steel	+	

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Delivery date

Solid content	65 Gew.-% +/- 4 (colour-dependently)
Solid volume	340 +/- 10 cm ³ /kg ≈ 46 +/- 1 Vol.-% (colour-dependently)
Delivery viscosity	65 - 120 sec./4 mm at 20°C room temperature according to DIN 53 211 (colour-dependently)
Container size	after arrangement
Storage stability	<ul style="list-style-type: none">• Master Component 12 Months in the locked original container

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Density	1,34 +/- 0,05 g/cm ³ (colour-dependently)
VOC-content (without dilution addition) mixed	455 +/- 5 g/ltr. (colour-dependently)
Important Information	EU Regulation 2004/42/EC (Directive Decopaint) Product type IIA / j, Type Lb Maximum VOC content ready to use < 500 g / ltr.
Minimum recommended Layer thickness	40 µm dry; match ≈ 90 µm wet.
Theoretical Coverage	8,2 - 8,8 m ² / kg at 40 µm dry coating weight
Practical Coverage	Dependent on the application procedure and/or dissipation factor.
Dilution/ Cleaning	GRÖNOLUX Synthetic-Thinner, 50-V-01 or GRÖNOCELL Universal-Thinner, 20-V-21

Cleaning	All equipment must be cleaned immediately after use with GRÖNOLUX Synthetic-Thinner, 50-V-01 . It is recommended to flush the spraying equipment several times. The cleaning frequency depends on the spraying quantity, the temperature and the pot life.
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Processing parameter

	Compressed air	Airless	Air-Mix
Processing-Visc. in sec. according to DIN 53 211/4 mm at 20°C	30 - 40 sec.	50 - 60 sec.	50 - 60 sec.
Dilution addition	5 - 6 %	2 - 3 %	2 - 3 %
Nozzle size	1,5 – 1,8 mm	0,280 – 0,330 mm or 0,011 – 0,013 inch	0,280 – 0,330 mm or 0,011 – 0,013 inch
Pressure	4,0 – 5,0 bar	120 – 180 bar	80 – 120 bar plus 1,5 – 3,0 bar additional air
ESTA (electrostatically processable)	<input type="checkbox"/> Yes, without additives	<input type="checkbox"/> When desired from factory adjustable	
	<input checked="" type="checkbox"/> Yes / 1000 kΩ from factory	<input type="checkbox"/> No	
Hot lacquer finish	<input type="checkbox"/> No		<input checked="" type="checkbox"/> Yes, up to max. 80 °C possible in form of delivery, without additional dilution

Drying process at 40 µm dry film thickness

Air drying at 20 °C	dust dry	approx. 30 Minutes
	touch dry	approx. 45 Minutes
	ready to assembly	approx. 12 Hours
Heat drying	up to 80 °C after 10 Minutes ventilating time possible	

The drying process is always dependent on ambient conditions (temperature, air humidity, air circulation, substrate temperature, etc.) and application thickness. Compared with solvent-based agents, water-dilutable products are reacting more sensitive to ambient conditions during application. The substrate temperature during application should be at least 3 °C above dew point. A dew point index is available on request. The ideal application temperature is between +15 °C and +25 °C.



- Certifying after EN ISO 9001 / 2000
- Ü-Zeichen after EN ISO 12 944

Disclaimer: The above-mentioned figures and properties are the result of intensive development work and many years of practical experience. Our recommendations are intended as an aid in selecting our products and do not constitute a contractual relationship. They do not release the buyer and the user from their obligation to satisfy themselves as regards the suitability of our products for their intended use. We reserve the right to make modifications designed to improve our products or their use. With the publication of this issue all earlier issues are invalid.

Safety-relevant data are given in the Safety Data Sheet.