

INTENDED USE

A solvent borne high performance anti-corrosive one coat, multi surface self priming mid sheen topcoat (50% gloss). Two grades are available:

- brushing
- spraying

Both have high opacity and will obliterate most surfaces in one coat in most colours.

Based on a low odour solvent.

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.

DECORATION OF BUILDINGS

Typical uses are the commercial decoration of internal factory steelwork e.g. steel, old galvanised steel and previously painted surfaces.

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

ARTICLES - that are not part of a building structure (and therefore are outside the scope of the building products VOC Product Directive)

Used as a refurbishment or maintenance coating for items such as:

INSIDE BUILDINGS Machinery, fixed plant, moveable equipment, fork lift trucks, trolleys, frames, guards etc

OUTSIDE BUILDINGS: Exterior surfaces of tanks, pipework and process plant, towers, bridges or any structure which is not part of a building

METAL FINISHING

Typical applications include portable accommodations units and site stores, containers, metal stillages, exterior surfaces of storage tanks, waste containers, farm buildings and original equipment.

Ideal for striping Zinfos 250, Zinfos 490 and Zinfos 800.

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. Always perform a test area when applying over an unknown previous coating.

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 Mordant Solution, 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

Brushing in 5 litre and Spraying in 20 litre containers in an extensive range of colours. If a Metallic is required, lustre will be affected by sheen.

PRODUCT INFORMATION

Composition	Based on a modified alkyd resin pigmented with suitably selected pigments, barrier extenders and modified zinc phosphate anti corrosive pigment.
Volume Solids	50%
Weight Solids	64-68%
VOC content	380-400 g/litre depending on colour
Supply Viscosity	6.5-7.5 poise at 20 C
Typical film thickness	Airless spray single coat 150 microns wet and 75 microns dry
	Brush application single coat 80 microns wet and 40 microns dry
Theoretical coverage	6.5 sq metres/litre at 150 microns wet film thickness; 12.5 sq metres/litre at 80 microns wet film thickness.
Dry heat resistance	80 C
Flash Point	Within the range 32-55C

APPLICATION DETAILS

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

Note		Always wash out spray equipment thoroughly if switching from other fast drying paints to or from Zinfos 340WS. If in doubt seek advice from Manor Coating Systems Technical Department.
		Normally 75 microns dry film thickness is applied to bare steel and 50 microns dry film thickness to previously painted surfaces.
Airless spray:	cold	The product is supplied ready for use by airless spray. Typical tip size 13-15 thou or 0.33-0.38 mm. Typical fluid pressure 200 kg/sq metre or 2800 p.s.i.
	heated	As for cold airless but keep temperature below 30C
Conventional spray		Thin with 10-15% Low Odour White Spirit. Typical material nozzle size 1.8mm using an HVLP gravity fed gun.

Brush Roller

Supplied ready for use. Typically 4" long/medium pile solvent resistant radiator rollers are considered most suitable or if the surface dimensions demand a 9" long pile roller may be used.

Thinner

Low Odour White Spirit

Film thickness per coat

	<u>Dry</u>	<u>Wet</u>
Minimum	60 microns	120 microns
Maximum	80 microns	160 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	1 hour	Overnight	Overnight
20C	45 minutes	Overnight	Overnight

Note

Drying.
Force drying will significantly enhance gloss levels.

Environmental conditions

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

After painting keep items out of direct rain and excessive condensation for 8 hours.

Overcoating / repainting

Zinfos 340WS is a 'one coat' finishing system and as such should not require overcoating when applied by airless spray. :

- Wet on wet; may be applied wet on wet (spray only)
- After painting the coatings should be left overnight (12 hours) prior to recoating with itself
- If left more than 3 days after initial coating lightly abrade the surface to improve adhesion.

May be overcoated with Manor Synthetic Enamel or decorative Gloss if required.

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: 15/02/2024

Reference: ZB and ZS Version: 10.0