

**Preparation description: Galvanized Steel strip (Sendzimir process)**

**General Information:**

A cold-rolled steel strip is wound into a coil. The strip is dipped into a molten bath at a zinc temperature of 450-480°C. After the process and cooling, the thickness of the zinc coat is around 5-20µm and it protects the steel coil against corrosion. New galvanized surfaces could have a zinc patina (white corrosion) and/or oily residues. The surface to be painted must be dry, clean and free from any contamination, e.g. corrosion, oil, grease, release agents.




It is very important to use the correct PPE (personal protective equipment) such as gloves, glasses, mask, and protective overalls.

Use only the appropriate tools and equipment, and certified grinding media.

Use slower evaporating cleaners to avoid condensation on the surface. Do not apply any paint products to objects which are subject to the influence of moisture. Recoating must be executed without any undue delay (within 60-90 minutes), with direct lacquers or primer and topcoat.


**Cleaning**

Products: Ammonia alkaline wetting agent (mix 10 litres water, 0.5 litres ammonium hydroxide 25% and 1 cap dishwashing liquid in a container)

	to refine 1x	Use the recommended products with a brush or abrasive scuff pad (not wire wool) applied to the zinc surface to be cleaned and sand thoroughly forming a wet foam. Wait for 10-15 minutes.
	stream cleaning	Using pure stream hot or cold water, clean the surface very well until the hot dip galvanized steel surface looks clean and shiny.
	blow dry with pressurized air	Using compressed air to remove any moisture, repeat until the surface is dry.

**Coating**

Depending on the recommendation, such as a HVLP/LVLP/RP spray gun or low-high pressure pump

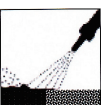


	to coat	Application of direct to metal topcoats, primer, primer surfaces with basecoat and clearcoat or topcoat.
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Please select a suitable paint system from the "System Technique" datasheets.

As option:




**Shot Blasting - Sanding**

Products: P180 – P240 grinding (eccentric) machine or scuff pad

	Beam technology „sweeping“	Use a non-metal abrasive, at a blasting pressure of 3-4 bar, a beam angle of 30-45°, at a distance of 0.3-0.5 meters. <b>Warning:</b> Sweep blasting may damage the zinc surface!
	sanding	If necessary, the surface can be sanded after the cleaning process with an eccentric grinding machine (<5mm rotary lift unit), P180 – P240 sanding disk and aspirator.
	scuffing	With a nylon-perlon abrasive part to roughen the surface, e.g. fine scuff-pad, treat edges and corners with care.


**Cleaning**

Products: RS605/607/609 Universal Reducer or AD690 Degreaser

	cleaning with pressured air	The sanded/scuffed surface must be cleaned with compressed air so that loose abrasive particles which were not vacuumed by the suction device are removed.
	to refine 1x	Use the recommended products with a soaked cloth/rag to remove the residues on the surface.
	wipe dry	With a clean, dry cloth/rag the dissolved contaminant from the surface is removed until it is dry.

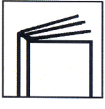
**Coating**


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Please select a suitable paint system from the "System Technique" datasheets.

**Further Information**

	For more information see:	<ul style="list-style-type: none"> <li>• Information at CRS (ICRIS, COINS, Valspar refinish)</li> <li>• Purple Box starter pack information sheets</li> <li>• Information on our web page (<a href="http://www.valsparindustrialmix.com">www.valsparindustrialmix.com</a>)             <ul style="list-style-type: none"> <li>○ Technical Information</li> <li>○ Technical Data Sheets</li> </ul> </li> </ul>
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	<p>This preparation description has been developed in order to enable professional users to maintain high quality standards for Valspar (Light) Industrial Mix and Commercial vehicle systems.</p> <p><b>Precautions:</b> During application all health and safety measures referring to the use and handling of coating materials are to be observed, e.g. existing regulations issued by the trade associations in the chemical industry. For health and safety information, please refer to the Material Safety Datasheet (MSDS). Information is also available on our web page: <a href="http://www.valsparindustrialmix.com">www.valsparindustrialmix.com</a></p>
	<p><b>Note:</b> The products listed are intended only for the professional user and for professional use. All recommendations given in writing on the use of our products to customers or users are non-binding and do not give reasons for secondary obligations resulting from the bill of sale. Every care is taken to ensure that the technical information provided is accurate and up to date according to the present state of knowledge in science and our experience. These recommendations do not, however, exempt the customer from independently checking whether our products are suitable for the intended purpose. The durability of the coating system largely depends on thorough preparation of the surface. Furthermore, our uniform terms of delivery and payment are applicable.</p>
	<p>With the publication of this Technical Data Sheet, all previous versions regarding this product are no longer valid.</p>