ZANCOR® SF-X

alkyd

One component fast drying anti-rust alkyd coating, pigmented with zincphosphate.

- Excellent anti-corrosive, lead and chromate free.
- Easy to apply in thick layers.
- Good hardening at low temperatures.

Application as anti-rust primer/coating on blasted or hand de-rust steel.
- After hardening recoatable with practically any paint system.
- Very well applicable as finish layer.
- To retouch transportation and assembling damage applicable down to –15°C.

Product information

Finish	Eggshell (depending on colour)
Colour	RAL colours
Mass density	approx. 1.4 kg/L (depending on colour)
Solids content by volume	approx. 55 volume % (depending on colour)
VOC	approx. 375 gr./L (volatile organic compound)
Recommended film thickness	37- 70 µm d.f.t. per layer 65-130 µm w.f.t. per layer (undiluted)
Theoretical spreading rate	At 70 µm d.f.t. 7.9 m²/L
Practical spreading rate	Depending on several factors like shape of object, profile of surface, method of application, application circumstances and experience. A few guiding principles are: Brush/roller 85-90% of the theoretical spreading rate Spraying 50-70% of the theoretical spreading rate
Flashpoint ISO 1523	Paint 27°C Thinner FGM 631 26°C Thinner WTD 107 14°C
Dry temperature resistance	120°C
Durability	At least 12 months, provided that it has been stored in closed original packing at a dry and cool spot.

Drying times

For d.f.t. up to 80 µm	30°C	20°C	5-10°C
Dust dry	10 minutes	20 minutes	30 minutes
Manageable	3 hours	4 hours	8 hours
Recoatable: Minimum interval	2 hours	4 hours	10 hours
Maximum interval	Unlimited, provided that the surface is dry and clean.		
	Film thickness, ventilation, temperature and relative humidity are of great influence on the drying times.		
Recoatable with a two components paint system	After 1 to 4 weeks, depending on the temperature and layer thickness.		

Explanation: in order to avoid or reduce the risk of wrinkling, it is to be recommend to apply the 2nd layer of this product or a finish coat based on the same resin technology, within 4 hours or after 48 hours drying of the 1st layer. If necessary, please consult your supplier.

Application instructions

Application conditions

During application and hardening the temperature should be above 5°C to attain optimal qualities.

The surface should stay dry and the temperature of the surface should be at least 2°C above dew point.

During application and hardening in closed or small spaces, it is necessary to refresh the air continually to remove the solvent vapours, this because of drying, health and safety.

Usage information

	Airless-spray	Airspray
Type of thinner	FGM 631 / WTD 107	FGM 631 / WTD 107
Recommended thinner (depending on application and equipment)	5 – 10 vol. %	5 – 15 vol. %
Nozzle orifice	0.41 – 0.46 mm 0.016 – 0.018 inch	1.5 – 2.5 mm
Nozzle pressure	150 – 180 bar	3 – 5 bar
Maximum attainable d.f.t.	80 µm	60 µm
Cleaning of tools	Thinner FGM 631 / WTD 107	

Surface conditions

Steel

New steel:
Blasting according to the ISO norm 8501-1:1988 Sa 2½.
Roughness profile Ra 10-12 µm Rz 50-60 µm.
Surface must be clean and dry.

Repair and maintenance:
Clean the surface with a suitable cleaning preparation or by steam cleaning.
Remove salts and other water-soluble impurity by spraying with clean tap-water under high pressure.
Remove rust a.o. by (water)blasting Sa 2½ or derust mechanical until St. 2-3.
Apply the advised paint system on a clean surface.

- Mechanical or hand derusting gives less quality than (water)blasting and will result in less protection of the applied paint system.

Safety description

See safety data sheet

Ventilation rules

Minimum required quantity of air to comply with:

	MAC	10 % LEL
Zancor SF-X	1990 m³/L	85 m³/L
Thinner FGM 631	3995 m³/L	160 m³/L
Thinner WTD 107	4085 m³/L	168 m³/L

MAC = Maximum Acceptable Concentration
LEL = Lower Explosion Limit
Also consult the security information sheets

Pretreatment / Labeling / Technical Terms (downloadable from www.zandleven.com)

A 1 Labeling of paint products in the European Community
A 2 Physical data
A 4 General guidelines for steelpreservation
A 6 Pretreatment of construction steel