



# ONSHORE STEELWORK PAINTED

**MGDUFF**  
Specification No  
**Z4**

## SCOPE:

<i>Material:</i>	<b>Steel</b>
<i>Environment:</i>	<b>Natural atmospheric conditions up to 160°C</b>
<i>Expected Lifespan:</i>	<b>40 years</b>

## SPECIFICATION:

<i>Surface Pre-preparation:</i>	<b>ISO 8503/4</b>	
<i>Surface Preparation:</i>	<b>SA 2.5 (ISO8501-1) or WJ-1 (NACE-5/SSPC-SP12)</b>	
<i>Surface Profile:</i>	<b>Rz 40-60µm</b>	
<i>Surface Roughness:</i>	<b>Ra 12.5-15µm</b>	
<i>Coat</i>	<i>Material</i>	<i>Total d.f.t. (µm)</i>
<b>Applied in 1 or 2 coats</b>	<b>ZINGARD</b>	<b>60-80</b>
<b>Mist-coat</b>	<b>ALUFER WR</b>	<b>20-30</b>
<b>Tie-coat</b>	<b>ALUFER WR</b>	<b>50-60</b>
<b>Finish</b>	<b>Polyurethane</b>	<b>50</b>

## Remedial Specification:

Remedial work should be dictated by depth of damage. If the damage has been sufficient to reach the substrate then the full process as listed above must be repeated from surface preparation onwards. If the damage is confined to the finish layers then the existing layer should be sweep-blasted and recoated as per tie-coat and finish coats listed above.

## Notes on this Specification:

- If the Zingard is to be spray applied it should be thinned by 5% using Zingasolv only.
- Each Zingard coat must be thoroughly dry (uniform light grey colour) before each succeeding coat is applied or before handling operations. This can take from 10 to 90 minutes depending on ambient temperatures.
- The Zingard coats must be allowed to cure for a full 24 hours before the mist-coat is applied.
- The total tie-coat thickness must not exceed 100µm dft.
- All curing times and dft's for each component layer must be observed as per manufacturer's specifications.
- In non-ideal application conditions please consult the MGDUFF technical department.
- All materials must be obtained from MGDUFF.
- This is a summary specification. For full details please contact the MGDUFF technical department.

Zingard Spec Z04.doc	<p>MG Duff International Ltd. 1 Timberlaine Estate, Gravel Lane, Quarry Lane, Chichester, West Sussex. PO19 8PP Tel: 00 44 [0] 1243 533336 Fax: 00 44 [0] 1243 533422 Email: <a href="mailto:zingard@mgduff.co.uk">zingard@mgduff.co.uk</a></p>	<p>Issue: 1.00 Issued: 05/04/04</p>
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