

Introduction

Painting is considered of great importance for the purposes of environmental safeguarding. Painting must be the result of a sustainable process.

Standard paint color

Dark grey matt metallized (type Neri).

Painting techniques performances for hot galvanized steel

In order to ensure quality and high resistance of items over time, painting products have the following performance features:

Resistance to QUV

ΔE less than 2 after 2,000 hours of exposure in compliance with UNI ISO 11507 test.
This value is certified with a certificate issued by an independent body.

Resistance to rusting

Resistance to saline mist test greater than 1,500 hours in compliance with UNI ISO 9227 test
This value is certified with a certificate issued by an independent body.

Thickness of paint when dry

-Thickness not less than 110 micron (μm) for parts in steel.

Table of environmental performance during application of paint to items.

The QUV and rust resistance parameters indicated above are obtained with a painting cycle of low environmental impact having the following emission parameters:

quantity of solvents in the painting product used per m^2

-lower than 50 g per m^2 for parts in hot galvanized steel.

Standard painting cycle for hot galvanized steel

- Grade SA2.5 micro-sandblasting.
- Application by spraying of a coat of twin-component zinc phosphate epoxy primer, diluted with water.
- Application by spraying of a coat of twin-component diluted polyurethane varnish, diluted with water.

Specific painting cycle for poles with core in hot galvanized steel

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The performance parameters of:

resistance to QUV;

corrosion resistance;

thickness when dry;

tint, remain common to the two cycles.

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Standard paint colour for wood

Dark brown semi-opaque (type Neri).

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Painting techniques performances for Iroko wood or similar essence

In order to ensure quality and high resistance of items over time, painting products have the following performance features:

Artificial seasoning

Consists in a vaporization treatment with hot water at 110-115°C under pressure in autoclave and then drying, which is performed in a dry kiln where hot air is circulated with an ever decreasing degree of humidity down to 12-15%.

Sanding - Smoothing

The aim is to smooth and eliminate residue and irregularities caused by the previous mechanical processes.

Standard painting cycle for Iroko wood or similar essence

-one coat of water-soluble protective impregnating paint, particularly indicated against mould, fungi and UV radiation.

-one coat of water-soluble intermediate pigmented primer.

-one coat of transparent water-soluble finish, with UV filter, for protection against discoloration.

-drying at room temperature.

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Standard painting cycle for aluminium

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- Application of a coat of powdered epoxy primer.
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Standard paint colour for cast iron and hot galvanized steel

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Standard paint colour for wood

Dark brown semi-opaque (type Neri).

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Thickness of paint when dry

-Thickness not less than 200 micron (μm) for parts in cast iron.

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Standard painting cycle for cast iron

- Grade SA 3 micro-sandblasting.
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