



F.H.BRUNDLÉ

SERVING THE TRADE SINCE 1889

METAL PAINTS & COATINGS

The secret to achieving the perfect finish

- Vinyl Coating
- Enamel
- Hammered Finish

- Patina Finish
- Primers
- Touch Up Paints



We offer an excellent range of British made paints which have been specially designed to meet the needs of our customers. This brochure contains useful tips and advice, and our staff are always happy to help with any questions you may have. Our British made paints have also been exported to diverse countries such as Bahrain and Canada where they stand up well to the wide range of temperatures these countries experience.

Our high quality paints were especially designed to paint steelwork and wrought ironwork, including galvanised steel. The range includes everything from great value commercial red oxide and other primers to our Vinylast™ and other topcoats. Many of our paints are designed for spraying, but other are perfect for brushing. We include simple to use Patinas and Staygold for creating luxury finishes on decorative ironwork. We offer a range of aerosols and touch-up paints to complete our range.

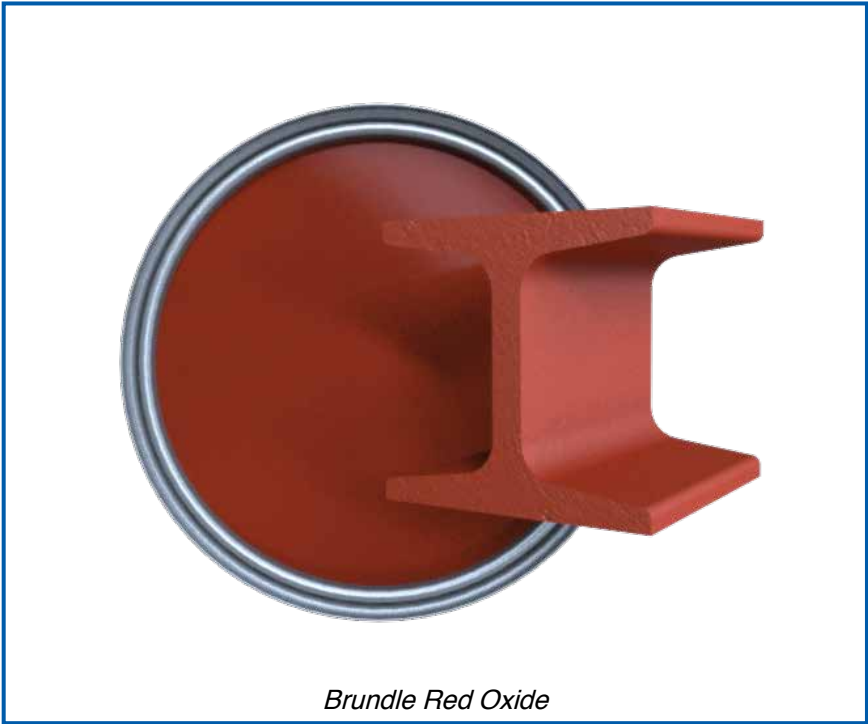
We stock the most popular RAL and BS colours and can produce any RAL or BS colour to order*.

**Minimum quantities may be required.*

We hope that you find this brochure useful, and we always welcome any feedback.

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Brundle Red Oxide

Check out our full range of paints & coatings.
Search **PAINTS & COATINGS** at www.fhbrundle.co.uk



A Guide to Sheen Levels

Sheen levels refer to how shiny the paint or coating is. These are far more important on top coats than on primers which are designed to be covered over and can vary.

In the UK there are no standards as to how to name sheen levels, nor what gloss percentage they must have so interpretations can vary from different manufacturers.

When choosing the right sheen level there are several factors to balance:

- What makes your work look best?
- Glossier finishes are often easier to clean, but show any imperfections more clearly than matt finishes
- Matt finishes often look softer
- Semi-Gloss or Satin often looks great on wrought-ironwork
- The greater the %, the higher the gloss level will be
- The thickness of the coat can affect the sheen as thicker coats often look glossier

At F.H.Brundle we work to these guides:

Sheen Level	Typical Gloss %
Flat Matt	0 - 5
Matt	6 - 10
Semi-Matt	11 - 15
Satin	16 - 34
Semi-Gloss	35 - 60
Gloss	61 - 80
Full Gloss	> 80

Galvanising

Protecting Steelwork

The first decision most people have to make is how to protect the work you have done. For this we have a choice of red oxide, and grey and black primers and cold zinc galvanise coatings. Each is designed to do the job you want. If the work is external, some people may like to hot dip galvanise it before painting, whilst others will prefer a good paint primer beneath a topcoat.

Whichever paints you use, it is advisable to check that the coating has been applied to the correct thickness for the job, either with a low cost wet film thickness gauge or an electronic dry film thickness gauge* can also be used. Both will ensure that the correct amount of paint has been applied. With experience it is usually quite possible to simply know what 'looks' right simply by judging the appearance and sheen level.

*(*Please note that electronic dry film thickness gauges may include the thickness of any galvanising and this has to be allowed for. Check before painting and again when the paint has dried. The difference between the readings will be the dry film thickness.)*

With all paint products, drying times may vary according to temperature, humidity, and film thickness. Some coatings may take a considerable time to become fully cured whilst we offer some quick-drying products. We also recommend that newly-painted products should always be handled with care.

To galvanise or not?

Galvanising offers the best possible rust protection but can add to the cost. It will however keep future maintenance to a minimum and extend the life of the product, and if this is your choice then we recommend that ironwork is hot dipped galvanised to the appropriate British Standard. If you chose to galvanise, then the work must always be allowed to dry thoroughly before painting. This can take up to 48 hours, or even more, depending on temperature and humidity, but this is necessary to avoid any moisture being trapped under the paint. Galvanising is not usually required for internal work.

If you apply paint on top of a galvanised surface this will protect the zinc coating and increase the lifespan considerably as well as providing a decorative finish where required. Some paints, such as Vinylast™, may not require pre-treatment.

For further information about galvanizing, please visit www.galvanizing.org.uk

Preparation



It is extremely important that all work is cleaned off and prepared correctly before painting and highlighting.

For non-galvanised steel, please ensure that the work is dry, clean, free from oil, rust and mill-scale, etc. Our Panelwipe is ideal for cleaning the surface, or for best results, mild steel surfaces could be blast-cleaned or wire brushed thoroughly before painting. This will help adhesion and give a longer life before any maintenance is required.

- Always follow instructions for your products
- Ensure that all surfaces are clean, dry and free from grease and oil
- If you have a glossy surface you may need to abrade or blast-clean before painting
- Always thoroughly mix the paint before using
- Always use the appropriate thinner for your product and use sparingly. Mix well into the paint. Adding too much thinner may mean additional drying time or applying more coats
- Non-galvanised work will usually require a primer*
- Galvanised steel may require a Mordant 'T' wash to help adhesion, although our Vinylast™ may not require pre-treatment
- Always use appropriate PPE (personal protective equipment)
- Helpful guides can also be found on our website in the Paint section

**Vinylast does not usually require any primer*

If the work is contaminated with oil or grease we recommend F H Brundle Panelwipe/Degreaser. Using Panelwipe will clean the surface and assist adhesion. Panelwipe can be applied with a clean rag or brush. The affected area needs to be wiped clean and left to dry before painting. We have two types of cloths which can be used for application.

Product	Quantity	Code
Brundle Panelwipe	5 litre	29PW05
Mordant 'T' Wash	5 litre	29MTW05
Lint Free Cloth	400 (approx)	29SW68
Low Lint Cloth	150 (approx)	29RT150



Low Lint Cloths

For newly-galvanised steel, please ensure that any sharp points have been removed, and that it is thoroughly dry and free from dust, oil or grease before painting. Wiping the work over with our **Brundle Panelwipe** is an excellent preparation. If the galvanising is very shiny, it may require abrading or a pre-treatment such as **Brundle Mordant 'T' Wash** for best results as this will aid adhesion.

Cold galvanise protection

We have a range of high quality cold galvanise coatings, available in both aerosols and brushing paints, for when extra protection is required. Choose below for your solution to repairing and protecting your metalwork. Use our **ZG-90 Cold Zinc Galvanised Spray** for an excellent anti-corrosion coating, and to repair damaged zinc surfaces. This is also available in a Green or Black finish and our new Brushable version. We also have ZG-90 available in a matt finish for touching up old, galvanised steel. Or use our **Galvafruid**, which can be used both as a primer and a top coat, to prevent corrosion and rust to provide protection.



Aerosol

Product	Sheen	ml	Code	Thinner Code
ZG-90 Bright Cold Zinc Spray	Bright	500	2902A	—
ZG-90 Bright Cold Zinc Spray Black RAL9005	Gloss	500	2902B	—
Light Zinc Spray	—	400	2902L	—
ZG-90 Matt Silver Cold Zinc Spray	Matt	500	2902M	—
Fast Drying ZG-90 Bright Cold Zinc for Brushing	Bright	400	2902ABR	29002
Galvalast	Matt	500	2903	29002



Brushable



F.H.Brundle carries a range of primers for protecting steelwork against rust. Using primers will help protect your steelwork and form a base for your topcoats. Our primers are excellent value, hard-wearing, and are suitable for many coverage applications.

Industrial QD Thinner



Litres	Code
5.0	29002
25.0	2900225

RX-90 Red RAL 3009



ml	Code
500	2904A

Matt Galvalast Grey



ml	Code
500	2903

Thinner code: **29WS05**. Best for rollers and brushes.

Red Oxide



Matt Black



Matt Zinc Phosphate Grey



Product	Colour	Application	ltr	Code	Thinner Code	Use With Top Coat	Notes
Brundle Matt Red Oxide	Matt Red	Brush or Spray	2.5 5 20	29BRO025 29BRO05 29BRO20	Brundle No.1 Ind. QD Thinners Code: 29002	General purpose	A high build quick-drying quality primer, containing zinc phosphate for excellent protection.
Brundle Matt Black Primer	Matt Black	Spray	2.5 5 20	29BBP025 29BBP05 29BBP20	Brundle No.1 Ind. QD Thinners Code: 29002	General purpose	A high build quick-drying quality primer, containing zinc phosphate for excellent protection
RX-90 Red Oxide	Red	Aerosol Spray	0.5	2904A	n/a	General purpose	Very useful for smaller jobs
Zincphos QD Sprayable ZP Primer	Grey	Spray	1 5 20	29ZQDP01 29ZQDP05 29ZQDP20	Brundle No.1 Ind. QD Thinners Code: 29002	Enamelrite	A quick-drying quality primer, containing zinc phosphate for excellent protection
Brushable ZP Primer	Matt Grey	Brush	5	29BZPGP05	Brundle White Spirit Code: 29WS05	Brundle Brushable Enamel	A quality primer contains zinc phosphate for good protection. Apply by brush
Vynylast™	Any RAL or BS Number	Brush or Spray	2.5 5 20	Any Vynylast™ Paint, except *Vynylast™ Gloss	Brundle No.1 Ind. QD Thinners Product Code: 29002	Vynylast™	*Please note that Vynylast™ Gloss can only be used as a top coat on top of Matt or Semi-Gloss

Our anti-rust oxide primers can be used on clean or slightly rusted metal, are quick-drying, and can be used under most top coat paints. We also have our Brundle Brushable ZP Grey Primer which is designed for priming under our Brundle Brushable Enamels.

Our primers cover most requirements from standard everyday use to high quality coatings designed to offer prolonged protection against rust. In some cases, primers may not be necessary if you have galvanised the steelwork and are using a product like Vynylast™ which simply requires a sufficient thickness of paint. However, if the steelwork is not galvanised then it is important to consider the most appropriate primer to achieve the degree of protection which you require.



We stock a wide range of excellent top coats for both protection and decoration. We have something in our range for internal and external use, and for painting mild steel or galvanised work. To help you to get the perfect finish for your requirements we will discuss the benefits of each of them in the following sections:

Hi-Build Vinylast™

We offer a wide range of Vinyl paints which are the perfect paints for decorative and commercial ironwork, such as gates and all types of steel railings. Vinylast™ is perfect for a long-lasting special finish. Vinylast™ is ideal for using on galvanised steel with the minimum of pre-treatment and will offer a low maintenance finish.

Thinners for Vinyl Paints

For best results when using vinyl based paints we recommend Brundle No.1 Industrial Thinner code: **29002**. This is a high quality xylene-based solvent which will help the paint to dry faster than standard thinners. When using thinners, it is better not to use more than necessary. Too much thinners may lead to an extra coat being required, runs, insufficient film thickness, or may lengthen the drying time. Other products may require different thinners and it is important to use the correct thinners with each product. Do not use White Spirit with Hi-Build Vinyl paints.

Vinylast™ (Thinners code: 29002)

A high quality coating, designed and produced to be applied directly to newly-galvanised decorative ironwork or mild steel. It offers an attractive, long-lasting, low maintenance finish.

The most popular choice of finish is our Smithy Black in a Satin finish, but Gloss (for a top coat only) and Matt sheens are also available. Graphite and Anthracite are also popular choices, with Moss Green, Ironstone Brown, Pure White and French Blue also in demand. Used with our Patinas these colours can offer outstanding finishes which will give many years' service when a luxury finish is required. Vinylast™ can be over-coated in the future easily and successfully.

Vinylast™ is a perfect product for most decorative ironwork and is a relatively 'soft' coating, which helps to prevent damage and makes it easy to repaint with a single coat without having to scrape off or wire brush to abrade the original coating. If a 'harder' finish is required you may wish to consider our Enamelrite or Brundle Brushable Enamel ranges. Our Brushable Enamel is recommended for use where cables may come into contact with light fittings for example, and the solvents will not react with the cables which can happen with some xylene based solvents. However Brushable Enamel should not be used on the top of any xylene based products.

Vinylast™ does not require an undercoat, but it is essential to apply the correct thickness of paint in several coats, depending on the method you use.

For Aluminium, ensure that the surface has been abraded and always use Brundle Mordant 'T' Wash (see page 4) prior to painting with Vinylast™ to help adhesion.

Application

After suitable preparation, we recommend spraying with Vinylast™ to the appropriate film thickness following the instructions. You will usually require a minimum of 2/3 coats to achieve the required film thickness. We recommend that the first coat is properly applied with at least 40 microns dry film thickness as this will help to achieve a good value, long-lasting, low maintenance, and attractive finish to your work.

*Please note that Vinylast™ Gloss should only be used as a final coat over the top of Matt or Satin Vinylast™. Never use Zincaphos QD ZP Grey Primer code: **29ZQDP05** (5L) as a primer for Vinylast™.*



Picture taken 2005



Picture taken 2024

*The gate above left was originally hot dipped galvanised and painted with Vynylast™ Pale Grey (code: **29RSGG025**) and highlighted with our Patinas in 2005. The picture on the right was taken in Summer 2024. Apart from washing a couple of times a year it has never required repainting or touching up. When applied to instructions Vynylast™ will perform for many years. The garden may have changed in nearly 20 years but the gate hasn't!*

A good tip is to use a slightly different colour for the first coat, such as Vynylast™ Stone Grey RAL 7030 if you are spraying, or any colour of Vynylast™ paint that you may have left over from a previous job. The reason for this is that it is quite difficult to be sure that you have applied two coats if you use black over black and not missed anything. This also make good economic sense as you can use up any paint left over from a previous job (except Vynylast™ Gloss).

Some customers like to rig up a gantry so they can get to both sides of the ironwork and then easily move it along so they can paint the next piece. Another method is to lay the work flat on trestles so they can walk around it and get everything from underneath as well, although the piece then has to be turned over to get the other side.

If there are a lot of small awkward corners or joints in decorative work, it may be easier to paint these parts with a brush prior to spraying to ensure that you don't miss any parts which are difficult to spray.

We suggest using either a low cost wet film thickness gauge or an electronic dry film thickness gauge* to ensure that the correct amount of paint has been applied. With experience it is usually quite possible to simply know what 'looks' right simply by judging the appearance and sheen level.

**Please note that electronic dry film thickness gauges may include the thickness of any galvanizing and this has to be allowed for. Check before painting and again when the paint has dried. The difference will be the dry film thickness.*



Thinners

For best results when using Vynylast™ we recommend Brundle QD Thinner code: **29002**. This is a high quality xylene-based solvent which will help to dry the work faster than standard thinners. When using thinners, it is best not to use more than necessary. Using too much thinners may lead to an extra coat being required, runs, insufficient film thickness, or lengthening the drying time. Other products may require different thinners and it is important to always use the correct thinners with each product. Never use White Spirit with Vynylast™.

Another Colour?

Some people prefer something other than black! A firm favourite is our Pale Grey, a grey paint with a hint of sparkle. Sparkle Silver will give metalwork a modern appearance and Vynylast™ is available to order in any RAL or BS colour. We can produce any RAL or BS colour* to order. Please allow a little more time to for non-standard colours made to order. **Minimum quantities may apply.*

RAL colours can be found at <https://www.ralcolor.com/> and BS colours at <https://www.britishstandardcolour.com>

Our patinas and Staygold can also be applied after painting the ironwork with Vynylast™. When highlighting, we recommend applying patina to a small test area first to ensure the appropriate finish is obtained. Some of your customers may like the patinas to be very subtle whilst others like a lot more colour. If you have examples to show your customers it gives them a choice and most enjoy having a personalised touch to their new work. Remember that it is far easier to add more Patina than it is to remove it!

Future Maintenance

One big advantage of using Vynylast™ is that it is long-lasting and very low maintenance when applied to the correct film thickness. It will look good for many years and then it is very simple to repaint in the future. Just ensure that the work is clean and dry before repainting with your chosen colour.

Staygold code: 29007 (1L)

Thinners for Staygold code: 29WS05 (5L)

The perfect choice for **Gold Painted Finials and features**. For parts which require a solid gold colour we recommend using Staygold – this is an exceptionally high quality paint for smaller areas which are required to be gold, such as railheads and other features. Staygold stays bright much longer than many other gold paints - it does what it says and stays gold for longer! Staygold would normally be brushed on top of the finished ironwork and need at least two coats for best results.





Used for highlighting, patinas are high quality products which were developed to enhance the appearance of decorative wrought ironwork quickly, easily, and inexpensively. They are used to provide a range of modern finishes, offering customers a wider choice of colours to match their house or interior. They are fast to apply and will greatly improve the decorative appearance of ironwork without adding significantly to the cost. Patina finishes are popular with potential clients and will make your work stand out from the rest. They will create a luxury feel to your work, simply by spending a few minutes time and using a tiny amount of paint. Also see Advice Sheet 5 for Patina and Staygold.

Vinylast™ can be easily highlighted using patinas and a piece of sponge. (See Advice Sheet 5.)

Product	ml	Code	Thinner Code
Copper / Bronze	375	29P001	29WS05
Gold	375	29P002	29WS05
Silver	375	29P003	29WS05
Verdigris (Dark Green)	375	29P004	29WS05
Highlighting Sponge	375	29FOAM	29WS05



- 375ml of patina supplied in a 500ml tin
- Best applied with highlighting sponge code: **29FOAM**

Tip... Try mixing colours together or applying one on top of another to create your own special effects!

N.B. Gloss finishes may not highlight quite as satisfactorily with patinas as will matt, satin, or semi-matt sheens.

Brundle Gunwash is also available for cleaning spray equipment, etc. Codes: **29GW05** (5L) or **29GW25** (25L)

We are
Paint Pros.

It runs in our family.





F.H.Brundle offers two distinct types of enamels. We have Brundle Brushable Enamel and Enamelrite.

Please note that these products use different solvents and have different application methods so hopefully we can provide you with a perfect solution for your requirements.

Brundle Brushable Enamel (White spirit thinner code: **29WS05**)

Excellent for **internal work** - such as **lights**, **balustrades**, etc. Best applied by brush.

Often a semi-gloss finish with highlights may be the preferred finish of many customers, and for this our Brundle Brushable Enamel is the perfect choice. Available in Black RAL 9005 or White RAL 9010 in 2.5L cans. We also offer a choice of satin or gloss sheens.

If you are painting light fittings then our Brundle Brushable Enamel is a good option as the solvents are less likely to react with any cables they may come into contact with. Thinners (if necessary) should be White Spirit code: **29WS05**.

Order of Application	Product Application	Description
1	Primer	Brushable Zinc Phosphate Grey Primer (code: 29BZP05)
2	Second Coat	Brundle Brushable Enamel
3	Thinners	Brundle White Spirit (code: 29WS05)
4	Highlight	Patina or Staygold

Please leave for a minimum of 24 hours before heavy handling.

Enamelrite (Industrial QD thinner code: **29002**)

Enamelrite is a quality enamel for both internal and external use and is best applied by spraying. Enamelrite is available in semi-gloss - both gloss and satin sheen levels, and in both Black and White RAL 9010 in 5L cans.

Order of Application	Product Application	Description
1	Primer	Brushable Zinc Phosphate Grey Primer (code: 29BZP05)
2	Second Coat	Enamelrite - Sprayable Enamel
3	Thinners	Brundle Industrial QD (code: 29WS05)
4	Highlight	Patina or Staygold

Please leave for a minimum of 24 hours before heavy handling.





Thinners

We have two different types of Thinners (or solvents) which can be used with our products. For best results we recommend that you add the least amount of thinners that is necessary when thinning your paint. Adding too much can mean the paint taking longer to dry or may mean that an additional coat is necessary.

- Always mix into the paint thoroughly
- It is essential that the correct type of solvent is used for the paint you are using. Using the wrong type of solvent may cause problems

Product	ltr	Code	Use With Coating	Notes
Brundle White Spirit	5 25	29WS05 29WS25	Patinas, Staygold, Brundle Brushable Enamel, Brundle Brushable ZP Grey Primer	Essential for these products
Brundle Industrial QD Thinner	5 25	29002 290025	Brundle Red Oxide, Brundle Grey Primer, Brundle Value Vinyl, Enamelrite Zincaphos QD ZP Primer, Vinylast™	Excellent value and quick drying

Miscellaneous Products

Product	Application	Quantity	Code	Use For	Notes
Brundle Mordant 'T' Wash	Brush	5ltr	29MTW05	Pre-treatment of aluminium or bright, spangled galvanised surfaces	Always use PPE when applying
Brundle Panelwipe	Brush Cloth	5ltr	29PW05	Use for cleaning and degreasing work before painting	—
Lint Free Cloth	n/a	400*	29SW68	For use with Brundle Panelwipe and general purposes	Great value
Low Lint cloth	n/a	150*	29RT150	General purpose cloths	—
Brundle Gunwash	n/a	5ltr 25ltr	29GW05 29GW25	Use for cleaning spray equipment	—
Foam pieces 80 x 80 x 50mm	n/a	—	29FOAM	Highlighting with Patinas	Applying Patina with Foam sponges will give the best results

*Approximate number of cloths per pack.

For further information about galvanising please visit <https://galvanizing.org.uk/>

Touch-Up Paints & Aerosols

To complement our range of paints we have a variety of touch-up paints and aerosols for those finishing touches.

Brushable Paints to Match Powder Coating

Product	Application	Quantity	Code	Use For	Thinners Code
Gloss Green RAL 6005	Brush	1ltr	29PC1BG	To match powder coated finish	29002
Gloss Black RAL 9005			29PC1BB		
Black Sand			29PC1BBS		
Gloss Black Sand		125ml	29PC125TBS*		
Gloss Jet Black RAL 9005			29PC125TB*		
Gloss White RAL 9016			29PC125TW*		
Gloss Moss Green RAL 6005			29PC125TG*		

*Supplied with touch-up brush.

Aerosol Spray Paints

Extremely useful for all those small paint jobs and for repairing damage or scratches.

Product	ml	Code	Use For	Notes
RX-90 Red Oxide Primer	500	2904A	Base coat which protects against rust Effective on bare metal or light rust	Fast-Drying formula Use as an undercoat on most paints
ZG-90 Cold Zinc Galvanise Black RAL 9005	500	2902B	Can be used as an all-in-one finish	All the protection of a zinc rich spray in black, extremely fast-drying high performance glossy finish, zinc purity 98%
Smithy Black Matt Vinylast™	400	29RMBS	Repairs and small areas to Matt Smithy Black Vinylast™ paintwork	For spraying small areas or touching up, quick-drying and easy to use
Smithy Black Semi-Gloss Vinylast™	400	29RGSB	Repairs and small areas to Gloss Smithy Black Vinylast™ paintwork	For top-coating small areas or touching up, quick-drying and easy to use
Smithy Black Gloss Vinylast™	400	29RSBS	Repairs and small areas to Semi-Gloss Smithy Black Vinylast™ paintwork	For spraying small areas or touching up, quick-drying and easy to use

Visit <https://www.fhbrundle.co.uk/wrought-iron-components/paints> to check out our full range.

Touch-Up Paints & Aerosols



400ml Aerosols To Match Powder Coating

Colour	Sheen	Code
Moss Green RAL6005	Semi-Gloss	29PC400SG
Jet Black RAL 9005	Semi-Gloss	29PC400SB
Black Sand	Semi-Gloss	29PC400SBS
Traffic White RAL 9016	Semi-Gloss	29PC400SW
Signal Yellow RAL 1003	Gloss	29PC400SSY
Anthracite RAL 7016	Gloss	29PC400SA
Basalt Grey RAL 7012	Gloss	29PC400SAG
Serengeti Sand (Beige Grey) RAL 7016	Gloss	29PC400SSSG

Colour	Sheen	Code
Oyster White RAL 1013	Matt	29PC400SOW
Serengeti Sand (Beige Grey) RAL 7016	Matt	29PC400SSS
Umbra Grey RAL 7022	Matt	29PC400SUG
Pebble Grey RAL 7032	Matt	29PC400SLS
Mineral Grey RAL 7045	Matt	29PC400SMG
Terra Brown RAL 7928	Matt	29PC400STB
Basalt Grey RAL 7012	Matt	29PC400SAM
Beige Grey RAL 7006	Semi-Matt	29PC400SBG

400ml Touch-Up Paint For Synergised™ Original Aluminium Deck Boards

Colour	Code
Matt Anthracite RAL 7016	29PC400SASY
Matt Black RAL 9005	29PC400SBSY
Matt Serengeti Sand (Beige Grey) RAL 1019	29PC400SSSY

Coverage Guidance



One question we are often asked is, *"How much paint will I need to paint (x) metres of railings?"*

There isn't an easy answer because so many different factors come into play. Many paint manufacturers will offer a 'theoretical coverage' as a guide; however practical coverage is usually only a smaller percentage of this figure. In our case we are offering advice to people who will usually be painting ironwork. Even so, the work you are painting may vary considerably from one project to the next. It could be a simple hooped bar railing or it could be a very heavy, highly decorative pair of gates, with heavy duty posts. The latter will obviously use far more paint per metre than the simple hooped railings. Painting RSJ's with a brush or spray would be much closer to the theoretical coverage. There are many other factors which affect coverage so we will attempt to provide you with some information which may be useful.

We suggest that you record how much paint you have used to paint a particular job. You can then work out how many square metres you have painted and this will give you a litres per square metre figure. If you do this with a few of your jobs you will soon get a good idea of how much paint you are using for each style of work that you do and how much you need to order and allow for when you are preparing a quote.

Vinylast™

Theoretical Coverage

The theoretical coverage is 4 sq. metres/litre at 235 μ (microns) wet film thickness. The spreading rate of this product may vary considerably depending upon the method of application and the roughness and porosity of the surface. In practice, this figure may be reduced by up to 40%. Theoretical coverage is obtained by applying the paint onto a flat surface in ideal conditions. With a skilled operative the paint should cover one side of a 4 sq. metre surface to the given thickness.

Practical Coverage

In practice, painting ironwork is different. There are spaces between the bars and the ironwork needs painting on all sides and not just on one flat surface. Plain work will need less paint than very decorative work. Conditions, methods



Coverage Guidance

of application and equipment will all affect the theoretical coverage. People also apply different dry film thicknesses. The figures given below are what have been found, from experience, when painting typical ironwork. These figures are intended as a **helpful guide only** and we cannot accept responsibility for any variations you may find.

The following figures were obtained by a skilled sprayer, in a spray booth, and gave a dry film thickness (d.f.t.) of approximately 40 microns d.f.t. Please remember that:

- More than one coat is often necessary to achieve the minimum recommended d.f.t. of 80 microns
- In coastal areas we would recommend 120 microns d.f.t. and some customers would require it
- Some local authorities will ask for 120 microns d.f.t.
- To achieve 120 microns d.f.t. you probably need to apply more than 2 coats. This depends upon your equipment and the skill level of the operator and how much thinners have been used
- We recommend using a contrasting colour (such as dark grey under black) for the first coat to make it easier to see what you have already painted and to ensure that the whole of the work is covered with the following coat. This also has the advantage of being able to use up any paint of a different colour left over from a previous job
- Check the film thickness of the paint with a film thickness gauge. Details can be found below
- The symbol for microns is μ

The figures below are an approximate guide for painting **both** sides of the ironwork with Vinylast™:

Brush:	250ml per square metre per 40 microns (μ m) d.f.t. coat
Conventional Spray:	Using a 1.8mm nozzle on a gravity feed gun, 750ml of Vinylast™ was used per sq. metre at per 40 micron d.f.t.
Electrostatic Spray:	With electrostatic equipment, 430ml of Vinylast™ was used per sq. metre, per 40 micron d.f.t. coat.
Rollers:	We have no figures available at present but would expect a similar figure to brushing
Thinners:	For best results with Vinylast™ use our 5ltr Brundle thinner. code: 29002

Convert Wet & Dry Film Thicknesses:

Should you need to convert wet and dry film thickness you can do this with the following formulae. You need to know the percentage of solids in the paint.

WFT	= Wet film thickness	= 'W'	
DFT	= Dry film thickness	= 'D'	
Percentage of solids in the paint	= 'P'	(By volume)	
Percentage of Added Thinners	= 'T'	(By volume)	

No Added Thinners

$$W = \frac{D}{P} \quad D = W \times P \quad P = \frac{D}{W}$$

With Added Thinners

$$W = \frac{\frac{D}{P}}{(1 + T)} \quad D = W \times P \times (1 + T) \quad P = \frac{D \times 1}{W (1 + T)}$$

To obtain a dry film thickness of 81 microns using Vinylast™ it will require a total of approx. 300 microns dry film thickness.

Other Brundle Paint Products

The theoretical coverage rates for our other paints are as follows:

Enamelrite:	10.7m ²	per litre at 30 microns dry film thickness (d.f.t.)
Brundle Brushable Enamel:	10.7m ²	per litre at 30 microns dry film thickness (d.f.t.)
Primers (typically):	Approx. 18.7m ²	per litre at 30 microns d.f.t.

In practice these figures may well be reduced depending on equipment and application.

Please Note:

This information is intended to be a helpful guide based on 'hands on' experience. No guarantee can be given that these amounts will be the exact quantities for your own particular job. Painting ironwork can vary tremendously from one job to the next. As we have no control over application, film thickness, the skill of the operator, the equipment used, local conditions, basic materials, or the particular situation, it is therefore impossible to offer any specific guarantees. The only way to be certain of the amount which you will need is to try a sample on the work which you are painting, using your own equipment, and calculate from that the amount of paint you will need. F.H..Brundle can accept no responsibility for incorrect amounts ordered.

- Drying times may vary according to temperature and humidity
- Always handle newly painted products with care. Some coatings may take a considerable time to become fully cured

We strongly recommend the use of film thickness gauges* to ensure consistent coating thickness and help you avoid applying either too much or too little paint.

*Inexpensive plastic wet film thickness combs are widely available and are simple to use.

*More precise digital electronic film thickness gauges are available at ELCOMETER www.elcometer.co.uk
(Tel: 0161 371 6000 or e-mail: sales@elcometer.com.)

Troubleshooting

Vynylast™ (this information may also be used for other paint products)

Vynylast™ is a high quality, low maintenance finish specially designed for painting decorative ironwork. It can be applied onto hot dip galvanised work to give a beautiful appearance which can also be enhanced by highlighting with our range of Patinas. Since Vynylast™ was developed in 1990, it has been used on decorative ironwork in the UK, and around the world, with very few problems. However, should you experience anything but total satisfaction, here is a guide to what may have occurred, possible solutions, and how to avoid potential problems the future.

Generally, to avoid problems, just follow the paint instructions. Clean off any sharp or unsightly areas on newly galvanised work. All work must always be clean and dry, and free from dust, oil, or grease before paint is applied and you must always apply paint to the recommended dry film thickness (d.f.t.). We recommend a minimum d.f.t. of 80 microns (μm), and up to 125 microns in adverse locations or coastal areas. Always use the correct thinners and apply the correct amount. Please read our detailed information on preparation.

In the unlikely event that you have a problem, please make a note of the batch number found on the can and the date it was purchased and contact one of our staff. This will be required to allow the product to be traced and checked against the sample which is taken from each batch produced. Information such as the type of thinners used, how much the paint was thinned down, how the work was painted, was the work galvanised and any photos of the work are invaluable in solving any problems.

For best results make sure that all work is completely dry before painting. Keeping a reasonable temperature in the spray area is also important but always avoid having any naked flames in any area where paint is being applied. We also recommend leaving the work a minimum of 2-3 days after painting before installing it, and to avoid any heavy handling before the paint has fully cured which can take some time depending on the temperature and the film thickness. Careful handling during transportation and installation of the work can save you time in touching up scratches. Drying times may vary according to temperature and humidity. Always handle newly painted products with care. Some coatings may take a considerable time to become fully cured.

Storage and Application Temperatures

Ideally paint should be stored between 5 and 28°C and never below 0°C. Application temperature should be between 12 and 22°C. Please note that very low or high temperature can cause viscosity variations which can affect results.

N.B. Never mix other products with our paint (other than our recommended thinners). They may be incompatible and cause problems for you.



Possible Problems and Their Solutions

1. Small bubbles or blisters appear on the surface of newly painted work

The most likely cause is moisture on the galvanised work. Trapped moisture tries to evaporate and causes small blisters to appear

Solution:

- If this occurs you can try letting the paint thoroughly dry and then lightly abrade the surface and apply another light coat, otherwise you may need to strip off the paint and leave it to dry for 48 hours before repainting

Prevention:

- Always ensure that work is thoroughly dry before painting. Although galvanised ironwork may feel dry to touch, moisture can be trapped in corners where scrolls or bars are welded. Often people are in rush to get the job done and spray the work as soon as it arrives from the galvanisers but unfortunately it will take even longer if the work is not completely dry. Remember that your work may have been in a bath of water when it came out of the galvanising tank, or it may have rained on the journey back to you from the galvanisers. In an unheated workshop in winter, it can easily take up to 48 hours or more to dry properly

2. The paint is flaking

This is usually an adhesion problem. If the film thickness is checked and the correct film thickness has been applied then several things must be considered:

- This is commonly caused by insufficient paint being applied, especially on the first coat
- Was the work a very shiny galvanised finish?
- Was the work sufficiently dry before coating?
- Had it been properly prepared and any contaminants cleaned off?
- The coating may not have been given enough time to thoroughly dry and fully harden (*see section 5*)
- Adding too much thinners can contribute to adhesion problems
- Has the correct thinners been used?

Solution:

- In many cases additional paint will cure the problem. We suggest adding at least one more thick coat to a small section and checking the results. Please check the film thickness with a mechanical or electronic gauge and if this is the case additional coats may be required to obtain the recommended dry film thickness of between 80 – 120 μm (microns). Please see Advice Sheet 2 - Coverage Information
- The alternative is to strip the paint and start again

Prevention:

- Always prepare well before painting - clean off all dirt, mill scale, weld spatter, oil and grease, etc. Any oil or grease can be removed with Brundle Panel Wipe (Degreaser) code: **29PW05**, prior to painting
- Very bright shiny metal surfaces must either be lightly abraded or treated with Brundle Mordant Solution code: **29MTW05** to achieve better adhesion
- Mild steel could be prepared by grit-blasting and painting as quickly as possible
- Do not use too much thinners. Ideally with Vinylast™ the minimum necessary amount of thinners should be used. Always use the recommended thinners for Vinylast™ which is code: **29002** No. 1 Industrial QD Thinners. Other products may require our White Spirit code: **29WS05**. Always check if you are unsure. See Paint Advice Sheet No. 10

3. Rust has developed

If the work was not hot dip galvanised, either the metal was already rusty and this was not fully removed, or the paint coating is too thin. If the work is galvanised, one other problem which can occur is if customers call after a few weeks and say that the work is rusting. They will say that there are a lot of spots which have gone rusty. This can happen if an installer has accidentally cut or ground some steel with an angle grinder close to the painted surface. The result is that you get tiny specks of rust on the surface which have been caused by the hot sparks of metal embedding themselves into the surface of the paint. It can appear as if rust is coming through the paint, but this is not the case, and the simple solution is to paint over this area and cover the tiny pieces of metal

Solution:

- It all depends on the severity of the rust. In severe case the surface may need full preparation with the rust being removed. Work that is severely rusty may require blast-cleaning before painting. If you do blast-clean, then please paint as soon as possible after this process. The recommended minimum film thickness is 200 microns wet and 80 microns dry. However, for coastal environments this must be increased to 125 microns dry film thickness (d.f.t.) for the best results. Always make sure that the surface is clean, dry, and free from rust before painting
- Repaint, ensuring that sufficient paint is applied and making sure that paint gets into corners and crevices

Prevention:

- One suggestion to help achieve the required film thickness is to use a different colour as a first coat. We usually suggest a first coat of dark grey and followed with black to ensure that the sprayer covers every part at least twice to help obtain the correct minimum film thickness. Black on black is hard to see and therefore it is difficult to assess the coverage correctly. You can also use most colours as a base for most colours of topcoat, which enables any surplus or redundant stock to be used up easily, so there is never a need to have any waste material with Vinylast™. With experience it is possible to judge the appropriate thickness quite well
- Often this problem can be traced back to thinning the paint excessively. Please note that for a conventional sprayer no more than 10% thinner should be used if possible and if more is needed consider buying a new spray unit
- To ensure that the correct film thickness is applied a film thickness gauge should always be used. These are available in mechanical and electronic versions for use on dry product or simple, inexpensive wet film thickness combs can be used. These can be plastic or slightly more expensive metal combs. A quick rule of thumb is that the wet film thickness is about 2.5 to 3 times the dry film thickness (d.f.t.). The difference between wet and dry film thickness is due to solvents evaporating during the drying process

4. The paint is peeling off the galvanised surface

This may be an adhesion problem but could also be caused by applying FAR too much paint in a single coat

Solution:

- The paint may still be soft, so it could be worth allowing more drying time
- Usually, the solution is to strip the paint, start again, with good preparation and applying coats as recommended

Prevention:

- All surfaces must be clean and oil free before painting. Please see Advice Sheet 1 on how to prepare the work for painting
- Peeling can also be caused by applying FAR too much paint
- If the galvanised surface is bright and shiny apply Brundle Mordant 'T' Wash code: **29MTW05** before painting
- Bright shiny galvanising could also be abraded first before painting with Vinylast™

5. The paint is not drying and is very soft

The thicker the coating, and the more thinners that has been added, the longer it will take to dry and develop the final hardness. When too much paint is applied at one time, the paint can stay soft for days but it will harden over time as solvents gradually evaporate. Please note: Drying times may vary according to temperature and humidity so it will dry better in a warm dry atmosphere. Always handle newly painted products with care. Some coatings may take a considerable time to become fully cured

Solution:

- Leave to dry in a warm, dry place until the paint is completely dry. This can take some time, but the surface will eventually harden

Prevention:

- Building up the thickness with two or three thinner coatings and leaving to dry for a couple of hours between coats, will lead to much faster hardening than one thick coat, because the solvent will evaporate more quickly
- Apply several thinner coats. Too thick a coating will surface dry and trap the residual solvent in the film which then acts as a plasticiser keeping the film soft for several days, and if it is damaged or removed you would find residual solvent smells. In these early stages it could appear that the coating is peeling if damaged or cut into. (See peeling.) Too thick a coating will dry hard throughout eventually, but in severe case it can take up to two weeks
- Do not add more thinners than you need



- Please check that you have used the correct thinners for the product. Other thinners may slow down the drying process or cause other problems

6. The colour of the paint does not match the colour on my previous order

If you painted and installed external work several years ago and then added some new work or have repainted a part of the work recently, then a colour difference can sometimes be noticeable as all paint changes in sunlight over a period of time. Even internal work will change colour over time.

However, if you painted a job just last week and opened a new can of the same colour which was noticeably different, then something is amiss. In this case, please make a note of the batch number on the base of the can or date and colour on the front label and contact us.

The colour on the work can also depend on having a consistent thickness of paint, this is particularly noticeable in bright colours such as reds, oranges, and yellows, and extra coats may be needed to get an even colour with these more transparent shades (in some cases the base metal colour may be showing through in areas where the coating is thinner).

The colour can also appear to vary a little depending on the sheen level.

- Thicker coats will give a higher sheen level
- A very thin coat will look flat and dull

With a little practice the operator will become skilful and always apply a similar thickness throughout the job and achieve a consistent finish.

Prevention:

- Always order enough paint to complete your job and ask if it can come from the same batch numbers. Batches should be consistent but occasionally there may be a very slight difference

7. A pale grey powder can be seen on the paint

After work has been installed for a few weeks, a grey powder-like film can be seen on the paintwork. 'White Rust' is formed by water reacting with zinc on a galvanised surface and is usually caused by insufficient paint thickness when found on painted galvanised metalwork.

Solution:

- Clean the affected area thoroughly, make sure it is dry and apply additional paint to reach the recommended dry film thickness. We recommend using a film thickness gauge. (See Advice Sheet 2.)

Prevention:

- Always apply to the recommended dry film thickness. This can save time and negate the necessity for return visits

8. The paint in the can is very thick

If the paint is very thick when you first open the can, it may be caused by the length of time the paint has been stored. The majority of paints have an unopened shelf life of about a year or a little more if stored in good conditions. (Some types of cellulose base paints may only last for six months.) Paint will always thicken up as solvents evaporate. All our paints have a batch number on the can, so in the event of any problem, please make a note of the batch number and your invoice number so we can trace when it was made and purchased. This makes it easy to check against retained samples which are taken from each batch.

Solution:

- Do not open cans until you will be using the paint. This will help to slow the rate of solvent evaporation
- Always thoroughly mix the paint before use. If it is still too thick to spray, then add a small amount of the appropriate thinners and mix well

Prevention:

- If you have paint left over, make sure the lid fits tightly into place to prolong the usable life of the paint
- Try to use your paint within a few months of buying it
- If you are using Vinylast™ please remember that you can use any remaining paint as the first coat on the next job if you are spraying, even if it is a different colour. This helps avoid any leftover paint and makes it more economical
- If you only use part of a can, then make sure the lid is sealed well after use

9. The painted work has a misty appearance after drying

This is called 'bloom'. It can happen if the temperature is quite low, or the paint is too cold. It can also happen if too much thinners is added. Storing the paint above 5°C and applying between 12 and 22°C should prevent this problem.

Solution:

- If 'bloom' occurs, try wiping the surface with white spirit code: **29WS05**. A quick wipe may restore the finish to black. You may also try to spray a mist of xylene, but do not rub the surface with a cloth if xylene is used as it will soften the surface and may drag the paint

10. How to repair any handling damage after installation

- Always transport and handle painted work with care – this can save time repairing damage to the paintwork cause during transportation or installation
- For a small area, installers find that using a matching aerosol gives better results than painting by brush. It can easily be faded into to the rest of the work and built up slowly. Check our website for Aerosol details
- If there is a deep scratch use a small amount of Brundle No. 1 Industrial QD Thinners (Product Code: 29002) on a clean cloth (use our 29SW68 or 29RT150 Lint Free and Low Lint cloths) to wipe the edges of the scratch. This will help to give a smooth appearance. Then follow up by spraying several coats with an appropriate F H Brundle aerosol. You can also use a brush to apply several layers of thinned Vinylast™ paint

Should you experience any problems with any of our paints please see our Report Form on Page 27.

Important:

- Correct Health and Safety procedures must be followed at all times
- Always wear appropriate clothing and PPE. Please consult our Health and Safety Data Sheets. Full Data sheets are available from our all our branches
- Basic information is available on the cans, but we strongly recommend all users to read the full data sheets for each product
- Data sheets can be viewed or downloaded from our website at www.fhbrundle.co.uk by searching for the product and then clicking on the SDS icon. You can also call +44 (0) 1282 965872 (Mon-Fri 08:30–16:30) and we will be happy to email MSDS information or post a copy to you
- NEVER have any naked flames in the vicinity when you are painting or spraying

Tip

- Always use the correct thinners for the type of paint you are using. If different solvents are used there could be a reaction between them and the paint. If in any doubt we suggest that you try a small area before painting the whole piece
- Please see our other Advice sheets for other useful tips and information about painting ironwork

Finally...

We hope this information has been useful. As always we try our best to provide a friendly and helpful service, so if you have any further questions please do not hesitate to contact our staff who will be pleased to help. If they don't have the information to hand then they will do their best to find it for you.

Please visit www.fhbrundle.co.uk for a full range of products and our online order service. You can find a list of all our depots and contact numbers on our website. You can also e-mail sales@brundle.com for prompt attention.





Important:

Correct Health and Safety procedures must be followed at all times. Basic information is available on the cans, but we strongly recommend all users to read the full material data sheets (SDS) for each product.

- Always use appropriate PPE (Personal Protective Equipment) including eye protection, gloves and suitable clothing
- Ensure adequate ventilation
- If spaces are difficult to ventilate please use an airfed mask/hood
- Never have naked flames or sparks in the vicinity of your work area
- Never smoke near paints and solvents
- We strongly recommend using respiratory protection
- Avoid skin contact with any paints or solvents
- If a spillage occurs ventilate the area to remove fumes, mop up all spilled paint with absorbent material and dispose of in closed metal containers
- Seek medical help if you accidentally ingest and paint or get it into your eyes

Health & Safety Data Sheets:

These are available online at www.fhbrundle.co.uk by searching for the product code and clicking on the SDS button, where you can download a copy or please ask at any of our branches. You may also call 01282 965872 (Mon-Fri 8:30-16:30) and we will be pleased to post or e-mail a copy to you.

NB:

- Please note that the xylene based solvents used in Vinylast™, and our No.1 Industrial Thinners, code: **29002**, may react with items like some types of electrical cables or plastics such as bubble wrap, and therefore we always recommend testing samples if used next to rubber or plastic materials. If Vinylast™ is to be used on light fittings and may come into contact with cables, a barrier of clear varnish **MUST** be used
- Drying times may vary according to temperature and humidity. Always handle newly-painted products with care. Some coatings may take a considerable time to become fully cured
- This information is as accurate as possible but should be treated as a helpful guide only. F.H.Brundle cannot accept any responsibilities for the information contained in our Advice Sheets. As we have no control over application, film thickness, the skill of the operator, the equipment used, local conditions, basic materials or the particular situation, it is therefore impossible to offer any specific guarantees. If you require information about a project please do not hesitate to ask. We will arrange for a specialist technician to contact you with advice if necessary

Safety Data Sheets are provided by:

F.H.Brundle
24-36 Lamson Road,
Ferry Lane North,
Rainham
RM13 9YY
Tel: 01708 25 35 45
Fax: 01708 25 35 50
Email: sales@brundle.co.uk
Web: www.fhbrundle.co.uk

Safety Data Sheets can be viewed and downloaded from our website by searching for the product code. They can be emailed to you upon request. You can also request them in person at any of our branches.

Please Note:

This information is as accurate as possible but should be treated as a helpful guide only. F.H.Brundle cannot accept any responsibilities for the information contained in our Advice Sheets. As we have no control over application, film thickness, the skill of the operator, the equipment used, local conditions, basic materials or the particular situation, it is therefore impossible to offer any specific guarantees. If you require information about a project please do not hesitate to ask. We will arrange for a specialist technician to contact you with advice if necessary.

Quick Check Charts



Top Coat Finishes

We offer beautiful vinyl and enamel finishes, including our Vinylast™, hammered finishes and metallics. Everything you need to complete your project.

Product	Best Used For	Also Used For	Sheen	Colour Range	Application Method	Undercoat / Primer	Thinners	Notes
Vinylast™	Galvanised Decorative Ironwork	Non-galvanised steelwork	Matt, Satin, Semi-Matt, Semi-Gloss	Our standard colour range plus any RAL or BS number to order. (Min. 5L quantities may apply for special colours)	Spray, roller or brush to 80 -120 microns d.f.t.*	Not necessary providing the correct film thickness is applied	Brundle No.1 Industrial QD Thinners code: 29002	High Quality Low Maintenance N.B. Vinylast™ Gloss can only be used as a top coat
Vinylast™ Gloss	Galvanised Decorative Ironwork	Non-galvanised steelwork	Gloss	Standard Colours plus any RAL or BS number to order (Min. quantities may apply for special colours)	Spray, roller, or brush	For best results always use a first coat of Vinylast™ Matt or Semi-Gloss to a total of 80-120 microns d.f.t.*	Brundle No.1 Industrial QD Thinners code: 29002	N.B. Vinylast™ Gloss should only be used as a top coat
Vinylast™ Metallics	Galvanised Decorative Ironwork	Non-galvanised steelwork	Semi-Matt	Dark Grey, Pale Grey, Sparkle Silver. This range contains a slight sparkle	Spray, roller or brush to 80 -120 microns d.f.t.*	Not necessary providing the correct film thickness is applied	Brundle No.1 Industrial QD Thinners code: 29002	Exceptionally High Quality Low Maintenance
Aerosols	Touching up work painted with Vinylast™	Painting small areas	Matt, Semi-Gloss, Gloss	Black (other colours may be made to order except Graphite and Anthracite)	Aerosol spray	N/A	N/A	Useful for painting small areas or repairing scratches or damage. Special colours to order - min. qty. of 6 cans
Brundle Brushable Enamel	General purpose	Decorative ironwork	Semi-Gloss, Gloss	Black RAL 9005 Special colours on application	Brush	Brundle Brushable ZP Primer code: 29BZPGP05	Brundle White Spirit code: 29WS05 N.B. Do not use with xylene based solvents	Use where a brushable enamel finish is required. Use if the ironwork will come into contact with other 'plastic' materials, such as cables, Bubble Wrap, etc.
Brundle Enamelrite	General purpose	Decorative ironwork	Semi-Gloss, Gloss	Black RAL 9005 White RAL 9010 Special colours on application	Spray	Zincaphos QD Sprayable ZP Primer code: 29ZQDP05	Brundle No.1 Industrial QD Thinners code: 29002	Use where a Sprayable enamel finish is required
Hammered Finish	Excellent for painting uneven or imperfect metal surfaces	Machinery, rusty ironwork	Hammered Finish	Hammered Black Hammered Silver Grey	Brush	Zincaphos QD Sprayable ZP Primer code: 29ZQDP05 Brundle Red Oxide	Brundle No.1 Industrial QD Thinners code: 29002	

- d.f.t. = Dry Film Thickness
- For further information please read our Paint Advice Sheets at <https://www.fhbrundle.co.uk> on our Resource Centre



WE CAN OFFER ANY RAL OR BS COLOUR MADE TO ORDER*

**Minimum order may be required.*



Quick Check Charts

Primers

F.H.Brundle stocks a wide range of primers for protecting steelwork against rust. These cover most requirements from every day use to high quality coatings designed to offer prolonged protection against rust. In some cases, primers may not be necessary. If steelwork is not galvanised it is important to consider the most appropriate primer to achieve the quality of protection you require. If you have galvanised steelwork and are using Vinylast™ you simply need to achieve the correct total dry film thickness.

Product	Colour	Application	ltr	Code	Best Used For	Also Used For	If Needed	Notes
Zincaphos QD Sprayable ZP Primer	Grey	Spray	1 5 20	29ZQDP01 29ZQDP05 29ZQDP20	Excellent Zinc Phosphate grey primer for use with Brundle Enamelrite	General purpose quick-drying primer, containing zinc phosphate	Brundle No.1 Ind. QD Thinners Code: 29002	A quick-drying quality primer, containing zinc phosphate for excellent protection
Brundle Matt Red Oxide	Matt Red	Brush or Spray	2.5 5 20	29BRO025 29BRO05 29BRO20	High quality fast drying Red Oxide Primer with zinc phosphate	Good quality general purpose primer for metalwork	Brundle No.1 Ind. QD Thinners Code: 29002	A high build quick-drying quality primer, containing zinc phosphate for excellent protection.
Brushable ZP Primer	Matt Grey	Brush	5	29BZPGP05	General purpose grey brushable primer with zinc phosphate	Excellent value for priming steelwork	Brundle White Spirit Code: 29WS05	A general purpose zinc phosphate primer, offering excellent value
Brundle Matt Black Primer	Black	Spray	2.5 5 20	29BBP025 29BBP05 29BBP20	A high build quick-drying zinc phosphate primer	Excellent value for priming steelwork	Brundle No.1 Ind. QD Thinners Code: 29002	General purpose primer when a black finish is required
RX-90 Red Oxide	Red	Aerosol Spray	0.5	2904A	Red Oxide Aerosol Primer	Painting small areas or touching up damaged paintwork	N/A	Very useful for smaller jobs
Vinylast™	Any RAL or BS Number	Brush or Spray	2.5 5 20	Any Vinylast™ Paint, except *Vinylast™ Gloss	High quality Vinyl coating	Ideal for decorative ironwork	Brundle No.1 Ind. QD Thinners Code: 29002	*Please note that Vinylast™ Gloss can only be used as a top coat on top of Matt or Semi-Gloss

Cold Zinc Galvanise Coatings

We have some excellent zinc rich primers and touch up aerosol sprays when you need high quality protection against rust or are touching up hot dipped galvanised steelwork.

Product	Application	ml	Code	For Use With	Notes
ZG-90 Bright Cold Zinc Galvanise Aerosol	Spraying newly-galvanised steelwork	500	2902A	Can be over-coated by many top coats, or as a combined undercoat and top coat	Extremely fast-drying Comes with 2 applicators
ZG-90 Cold Zinc Galvanise Aerosol Black RAL 9005	All the protection of a zinc rich spray in Black	500	2902B	Can be used as an all-in-one finish	Extremely fast-drying High performance glossy finish Zinc purity 98%
Light Zinc Spray Aerosol	Aerosol	400	2902L	Suitable for various hardware	–
MX-90 Matt Cold Zinc Galvanise Aerosol	Spraying weathered galvanised steelwork	500	2902M	Can be over-coated by many top coats, or as a combined undercoat and top coat	Long term protection Extremely fast-drying Zinc purity 98%
Glossy Silver Cold Zinc Protection	By brush	500	2902ABR	Can be over-coated by many top coats or used as an all-in-one finish	High performance corrosion protection Shower proof in 15 mins at 20°C Thinners: Brundle No.1 Ind. QD Thinners Code: 29002
Galvalast zinc rich paint	For use with newly-galvanised steelwork	500	2903	Can be over-coated by many top coats	Can be thinned with Brundle White Spirit code: 29WS05

Quick Check Charts



Thinners & Solvents

We have two thinners (or solvents) which can be used with our products and a range of solvents for various uses. For best results we recommend that you add the least amount of thinners that is necessary when thinning your paint. Too much thinner can mean the paint taking longer to dry or may mean that an additional coat is necessary. It is essential that the correct type of solvent is used for the paint you are using.

Thinners

Product	ltr	Code	Application	Use With Coating	Notes
Brundle White Spirit	5	29WS05	Mix thoroughly into the paint	Patinas Staygold Gold code: 29014 Brundle Brushable Enamels Brushable ZP Grey Primer code: 29BZPGP05	Essential for these products
Brundle Industrial QD Thinner	5 25	29002 290025	Mix thoroughly into the paint	Brundle Red Oxide Brundle Grey & Black Primers Enamelrite Zincaphos QD ZP Primer Vinylast™	Excellent value For quicker drying. Recommended for use with Vinylast™

Solvents

Product	ltr	Code	Application	Use With Coating	Notes
Mordant 'T' Wash	5	29MTW05	Usually brush	Pre-treatment of bright shiny newly-galvanised steelwork or aluminium	—
Brundle Gunwash	5	29GW05	Brush or cloth	Cleaning spray-guns and equipment	—
Brundle Panelwipe	5	29PW05	Brush or cloth	Preparation prior to painting Degreaser	For cleaning off any oil, grease or dirt

Aerosol Spray Paints

Our aerosols are extremely useful for all those small paint jobs and for repairing damage or scratches. We also have our high temperature black paint which is particularly useful to blacksmiths. Also see **Cold Zinc Galvanise Coatings and Paints To Match Powder Coating** for further aerosol cans.

Product	ml	Code	Application	Use With Coating	Notes
RX-90 Red Oxide Aerosol Primer	500	2904A	Aerosol	Base coat which protects against rust Effective on bare metal or light rust	Fast-Drying formula. Use as an undercoat on most paints
ZG-90 Cold Zinc Galvanise Aerosol Black RAL 9005	500	2902B	All the protection of a zinc rich spray in Black	Can be used as an all-in-one finish	Extremely fast-drying High performance glossy finish Zinc purity 98%
Smithy Black Matt Vinylast™ Aerosol	400	29RMBS	For spraying small areas or touching up	Repairs and small areas to Matt Smithy Black Vinylast™ paintwork	Quick-drying and easy to use
Smithy Black Semi-Gloss Vinylast™ Aerosol	400	29RGBS	For top-coating small areas or touching up	Repairs and small areas to Gloss Smithy Black Vinylast™ paintwork	Quick-drying and easy to use
Smithy Black Gloss Vinylast™ Aerosol	400	29RSBS	For spraying small areas or touching up	Repairs and small areas to Semi-Gloss Smithy Black Vinylast™ paintwork	Quick-drying and easy to use

Brushable Paints To Match Powder Coating

A small range of paints designed to match powder coated products for use when touching up.

Product	Quantity	Code	Application	Used For	Notes
Gloss Green RAL 6005	1l	29PC1BG	Brush	Matching powder coated finish	Thinners code 29002
Gloss Black RAL 9005		29PC1BB			
Black Sand		29PC1BBS			
Gloss Black Sand	125ml	29PC125TBS*			
Gloss Jet Black RAL 9005		29PC125TB*			
Gloss White RAL 9016		29PC125TW*			
Gloss Moss Green RAL 6005		29PC125TG*			

**Supplied with touch-up brush.*



Quick Check Charts

Aerosols To Match Powder Coating

Product	Application	Sheen	ml	Code	Notes
Moss Green RAL6005	Aerosol Spray	Semi-Gloss	400	29PC400SG	To match powder coated finish
Jet Black RAL 9005				29PC400SB	
Black Sand				29PC400SBS	
Traffic White RAL 9016				29PC400SW	
Signal Yellow RAL 1003		29PC400SSY			
Anthracite RAL 7016		29PC400SA			
Basalt Grey RAL 7012		29PC400SAG			
Serengeti Sand (Grey Beige) RAL 7016		29PC400SSSG			
Oyster White RAL 1013		29PC400SOW			
Serengeti Sand (Grey Beige) RAL 7016		29PC400SSS			
Umbra Grey RAL 7022		29PC400SUG			
Pebble Grey RAL 7032		29PC400SLS			
Mineral Grey RAL 7045		29PC400SMG			
Terra Brown RAL 7928		29PC400STB			
Basalt Grey RAL 7012		29PC400SAM			
Beige Grey RAL 7006		Semi-Matt		29PC400SBG	

Touch-Up Paint For Synergised™ Aluminium Deck Boards*

Product	ml	Code
Matt Anthracite RAL 7016	400	29PC400SASY
Matt Black RAL 9005		29PC400SBSY
Matt Serengeti Sand (Grey Beige) RAL 1019		29PC400SSSY

*Did you know that our Synergised™ Original Decking is manufactured from structural grade 6063 T6 aluminium finished with a Qualicoat™ powder coating? Installation couldn't be easier. This product has been tested by the UK's leading fire test centre to EN 13823, EN13501, and EN ISO 1716 and achieves Euroclass Classifications of A1 and A2fl-s1. Synergised™ is perfect for high rise balconies, walkways, terraces, pubs and gardens. Our staff are always happy to provide further information.

Patinas

Perfect for highlighting and decorative finishes.

Product	ml	Code	Application	Thinners Code	Use With Coating	Notes
Copper Patina	375	29P001	Sponge or brush	29WS05	For highlighting on top of other coatings	Best with Matt or Semi-Gloss
Gold Patina		29P002				
Silver Patina		29P003				
Verdigris Patina (Dark Green)		29P004				

Metalic Paints Including Staygold

Product	ltr	Code	Application	Thinners Code	Use With Coating	Notes
Staygold*	1.0	29007	Brush	29WS05	Use for painting railheads and decorative parts on ironwork	Long-lasting, high quality gold paint
Sparkle Silver Vinylast™	2.5	29RSS025	Spray or brush small areas	29002	Use as a main coat for a modern appearance on ironwork	Beautiful finish Long-lasting
Dark Grey	2.5	29RA025				
Pale Grey	2.5	29RSGG025				

*Use for small solid areas of colour such as finials and rosettes.

Miscellaneous Products

Product	Quantity	Code	Application	Use With Coating	Notes
Foam Pieces	N/A	29FOAM	Load with patina and wipe gently	Highlighting with our Patinas. Applying Patina with Foam sponges will give the best results	Apply a small amount initially and add more to achieve the desired effect
Lint Free Cloth	400 pieces	29SW68	N/A	For use with Brundle Panelwipe and general purposes	Has many uses around the workshop
Low Lint Cloth	150 pieces	29RT150	N/A	General purpose cloths	Has many uses around the workshop

*Approximate number of cloths per pack.

Powder or Wet Paint?

This section compares wet paint and powder coating. We are writing about external products. Internally either are fine. Both powder coating and wet paint have pros and cons depending on your project and the material to be painted, and we sell many powder coated products at F.H. Brundle. We also offer a range of paints for protecting mild steel and ironwork. Both finishes have benefits. Washing is especially important close to coastal areas where salt can damage fences and gates leaving a salt residue which can dull the appearance and leave a chalky looking finish.

Powder:

- Is very durable, weather resistant, and is available in many colours and sheens
- It is tough but is not as easy to overcoat as liquid paint if it requires refreshing as most traditional paints will struggle to adhere to the smooth non-porous powder coat
- Polyester is a synthetic fibre in the resin family and has strong waterproof qualities
- Requires cleaning off every few months to prevent build-up of any dirt or grime to prevent breakdown of the surface
- It is hard to predict just how long a powder coat will last due to the endless possibilities of the environment in different locations
- Powder can only be applied with specialist equipment

Liquid Paint:

- Has a huge colour range, and lower start-up costs
- Convenient and can be done almost anywhere
- It is easy to overcoat to refresh or change the colour
- It is simple to repaint or change the colour on site
- Requires cleaning off every few months to prevent build-up of any dirt or grime to prevent breakdown of the surface

Pre-Galvanised Products:

Powder and wet paint can be used over galvanised finishes. The Galvanizers Association provides useful information here: <https://galvanizing.org.uk/corrosion/corrosion-map/>. You can type in your post code and find out how long the average life of a galvanised product is for your locality. It will last even longer if coated with paint or powder as well as improving the appearance. Industrial and coastal areas are usually less than rural inland areas.





Overcoating Paint Or Powder

Over-Painting Powder Coating

Although powder coating will last for many years eventually it might require refreshing, and painting can help seal any scratches or chips, refresh the appearance, and help to extend the life of the product. Powder coating has a smooth finish, so you should always increase the adhesion capabilities by sanding and applying an appropriate primer. Success will lie in the preparation. Painting over powder coating requires a little more preparation, but it is possible to achieve a long-lasting, beautiful finish.

N.B. Because paints can vary, we would always suggest testing a small area first.

- Always ensure that any loose material, dirt or grease is removed as this will allow better adhesion
- Next use a cleaner or degreaser with a power washer or with a soft brush
- Rinse well and allow to dry thoroughly before sanding the surface with a fine grit sandpaper (around 180-220 grit) to aid adhesion. The aim is not to remove the powder coat but to roughen the surface
- Make sure any dust is removed
- The next step then depends on the top coat you will be using, and whether it is a vinyl such as F.H.Brundle's Vinylast™ which might go straight on or whether it is a water based or white spirit based which may require a specialist primer. There are a number of specialist primers which are available on the internet, such as Zinsser Bulls Eye 1-2-3 Primer, but they are not recommended for applying beneath Vinylast™
- If you are using primer, follow instructions, and wait to dry before applying paint. This will create a bond for your top coat
- Apply the top coat, which may need several coats, allowing to dry between each coat
- If you chose Vinylast™ as the top coat simply apply to a dry film thickness of 80 microns. A range of colours is available from stock or any RAL or BS colour can be made to order

Over-Painting Liquid Paint:

Different types of paint may require different repainting techniques. For example, our Vinylast™ products simply require the work to be clean and dry and then you can simply add another coat to refresh the appearance and protect your fence, gates or balustrades for many more years. However, enamels and glossy finishes may require sanding, an undercoat or primer, and a topcoat, as painting on gloss may reduce adhesion.

- Always ensure that any dirt or grease is removed and make sure your work is dry before starting as this will allow better adhesion. There are products which can do this, but you could also try the eco-friendly method of using a mixture of white vinegar and water
- If your fence or gates have signs of green algae or moss, this must be removed before painting
- Because different paints can vary, we would always suggest testing a small area first, especially if the existing paint is unknown



Cleaning Powder or Painted Products:

Whatever the finish on your products to get the best life expectancy from them, we recommend that you should check them over every few months and give them an occasional wash. We have touch-up paints and aerosols for any scratches or wear and tear damage that may occur.

N.B. We do not recommend using bleach for cleaning as this can be harmful and can cause discoloration.

Cleaning Powder Coated Products

Wash well at annual intervals, with soap if necessary, and wax the clean, dry surface with a thin layer as you would a car. When the wax is dry polish off with a soft cloth to restore the appearance. This is even more important in coastal region and the frequency should be increased up to four times a year as required

- It's best to start by wiping the surface gently with a wet sponge to remove any loose dirt and debris. You can also use a soft brush for this purpose. A wire brush would be too harsh since it would also remove the finish. You should try to remove most of the surface dirt and dust if you can
- Next remove salt and any other deposits from the surface of the fence and gate with a soft brush and a mild household detergent
- Choose a detergent that is free from both solvents and petroleum-based chemicals when cleaning your powder-coated fence. The product you use should be safe for your skin. If you need to protect your skin by wearing gloves when using the product, it's probably too harsh for the gate, fence or railings
- Thoroughly rinse the fence or gate using lukewarm water. Next, allow it to either dry naturally or use a clean, dry cloth to dry it off if you would like to get a cleaner look
- Ensure it is thoroughly dry before touching-up any scratches or blemishes if necessary

Cleaning Painted Products:

- Wash well at least once a year depending on your location. You can use a mild soap in warm water. Remove any dust, dirt, or green algae (which can sometimes be found in shady areas or under trees). In severe cases there are products which will remove moss and algae.
- Thoroughly rinse the fence or gate using lukewarm water. Next, allow it to either dry naturally or use a clean, dry cloth to dry it off if you would like to get a cleaner look.
- Ensure it is thoroughly dry before touching-up any scratches or blemishes if necessary

Finally...

We hope this guide has been useful. As always, we try our best to provide a friendly and helpful service, so if you have any further questions please do not hesitate to contact any member of staff who will be pleased to help. If the information isn't available to hand then we will do our best to find it for you.

Please visit www.fhbrundle.co.uk for a full range of products and our online order service. You can also find a list of all our branches and their contact numbers on our website. You can also e-mail sales@brundle.com for prompt attention.

Liveconfigurator™

Would you like to be able to configure your balustrade, stairway, fence or handrails and receive a free set of technical drawings for free? Go to liveconfigurator.co.uk

Brundle Design Studio

F.H.Brundle has also produced a web app to assist our customers. It can help convert enquiries into sales by enabling you to design ironwork with, or for, your customers. Our FREE Brundle Design Studio can be found on our main website at www.fhbrundle.co.uk/design-app where you can register.

Brundle Design Studio also contains useful Calculators to help with estimating and designing your work, and a shared Design Library.



Paint Report Sheet

We get remarkably few issues with our paints, but if you should have any problems we require a little information to be able to help promptly.

First we ask you to read the Troubleshooting section of this brochure which includes problem solving and application advice, coverage, etc. You can also find help on our website in our Resource Centre and Technical PDFs found at: www.fhbrundle.co.uk/groups/PAINTTEC__Paints

This information will be updated and more will be added from time to time. It is useful to be aware of this Information, and it can save time.

If you are still having a problem we will do our best to help, but to do that we will need a little information from you so that we can get to the root of the problem and help them and perhaps other customers as well.

This is a list of the information we need so that it is really helpful to find out if possible please:

Full Name	
Account Number	
Date Problem First Reported	
Company Name	
Company Address	
Post Code	
Contact Number	
email Address	
Original Date of Purchase	
Please Give As Much Detail As Possible of the Issue	
Batch Number on Can (for tracking purposes)	
Method of Application (please circle)	Brush Spray Roller Electrostatic Spray
Was the Work Galvanised? (please circle)	Yes No
If Galvanised Was the Work 'T' Washed with mordant solution (please circle)	Yes No
Which Thinners Were Used (please circle)	Yes No
Approximate Percentage of Thinners Used	%
Was This Used Over An Undercoat or Primer (please state which)	
How Many Coats Were Applied	
Have You Used This Product Before	
How Many Square Metres Were Painted	
How Much Paint Was Used	
Had the Work Been Painted Previously	
Did You Stir the Paint Thoroughly Before Use	
Was Anything Other Than Thinners Added to the Paint	
Can You email Photo's of the Problem with the Paintwork	
Any Other Notes	
Branch Salesperson and Branch Location	

Please fill in as much of this information as possible. Next please forward a copy of this form on to your local branch and we will do our best to help



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