
ZOLATONE AUTOMOTIVE, INDUSTRIAL & MARINE

TECHNICAL DATA SHEET



DESCRIPTION

Zolatone 20 Series is a polychromatic, modified nitrocellulose coating with a flat background color under accenting fleck colors. This coating system provides an unusual decorative and comouflaging effect that is also durable, flexible and simple to maintain and repair when needed.

PHYSICAL DATA

- ◆ Pot Life at 70°F: N/A
- ◆ Flash Point: 71.6 F (TCC)
- ◆ VOC Ready to Spray: 4.03 lbs/gal or 483 max grams/liter
- ◆ Coverage: Up to 125-175 sq. ft./gal depending on substrate, particle size, color, and application method.



SUBSTRATES

Zolatone 20 Series is designed for use with Zolatone basecoat primers over ferrous metals, fiberglass, plastic, woods, ceramic tile etc.



MIXING

Product comes ready to use. Stir only. Do not shake. Do not tint. Do not add water. Do not thin.



APPLICATION

- ◆ Over properly prepped and primed surface; Select the proper primer / sealer base color for the Zolatone finish color. Refer to page 5 in the Zolatone Master Catalog or page 2 of this Technical Data Sheet.
- ◆ Use a pressure pot system with a conventional or HVLP spray gun with a fluid tip of .080 to .090 inch or 2.0 to 2.4 mm.
- ◆ Apply Zolatone in a two step process. Sheer Coat followed by Pattern Coat.

Sheer Coat: Spray gun 12 inches from surface with fluid needle valve nearly in the closed position.

Conventional Gun Air Pressure: 50-60 psi.

HVLP Gun Air Pressure: 40-50 psi.

Pot/Fluid Pressure: 10 psi (assumes 2 Liter pressure pot is used)

Pattern Coat: Total film thickness not to exceed 8 mils wet film thickness.

Spray gun 24-36 inches from surface with fluid needle valve opened one turn from step above.

Conventional Gun Air Pressure: 20-30 psi.

HVLP Gun Air Pressure: 20-30 psi.

Pot/Fluid Pressure: 10 psi (assumes 2 Liter pressure pot is used)

Premium Multicolor Coatings Since 1952

Zolatone Automotive, Industrial & Marine • Division of Advanced Refinish Technologies

850 Ladd Road – Building E, Walled Lake, Michigan 48390

Toll Free: (800) 810-2785 Fax: (248) 668-8121 www.zolatoneaim.com

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SUGGESTED APPLICATION EQUIPMENT

Below is suggested application equipment.

Item	DeVilbiss #	Sharpe #	Sata #
HVLP Spray Gun	170161	5666	78147
2 Liter Pressure Pot	120033	7003	16733
Air & Fluid Hoses	220019	7130	19869
Air Adj. Valve	180006	1410	27771
Pot Liner	192025	N/A	N/A



DRYING

Air Dry Times

To Touch – 2 hours air dry at 70°F and 50% humidity.

To Use – (light) overnight.

Full Cure – achieved in 5-7 days.

Tape Free – overnight.

Force Dry

Force dried at 140°F in 30-60 minutes. Allow 30 minutes flash time if using force air or baking. Can be clear coated (optional) after cooling.



BUFFING

Not necessary.

RECOMMENDED BASECOAT PRIMER COLORS

(For each Zolatone 20 Series Color)

20-02 White/ White – White	20-75 Bright Red – Gray
20-06 Black/ Black – Black	20-77 Bright Blue – Gray
20-11 Apollo Gray – Gray	20-78 Dark Red – Black
20-42 Hamlet Black – Black	20-79 Jungle Camo – Black
20-45 Medusa Gray – Gray	20-80 Desert Camo – Black
20-54 Camille White – White	20-82 Teal Green – Black
20-59 Lilith Charcoal – Black	20-84 Midnight Blue – Black
20-63 Marble Stone – White	20-85 Emerald Green – Black
20-64 Gray Stone – Gray	20-86 Harvest – White
20-71 Onyx Black – Black	20-87 Char Brown – Gray
20-72 Silver Gray – Gray	20-88 Admiral Blue – Gray
20-74 Basic Blue – Gray	20-89 Bright Yellow - White

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TECHNICAL DATA & TEST RESULTS

Pencil Hardness: ASTM D3363

48 hrs. – F / 2 weeks – H-2H

Color Stability / QUV Weather

Meter Exposure:

1,000 hrs. – no color change, >95% gloss retention

2,000 hrs. – very slight color change, >90% gloss retention

3,000 hrs. – slight color change, >70% gloss retention

Cross Hatch Adhesion: ASTM D3359, Method B / 4B pass

Solvent Resistance: ASTM D5402 (10 double rubs)

Gasoline – no effect

Diesel – no effect

Oil – no effect

Xylene – no effect

Salt Spray Resistance: ASTM

B117 (250 hrs)

Slight stain on scribe, slight stain on field, no blister on scribe, no blister on field, no rust

Abrasion Resistance: ASTM D4060

(Taber abraser)

CS10 wheel / 1,000 gms. / 1,000 cycles

112 mgm. loss w/o clear, 68 mgm. loss w/ clear

CS17 wheel / 1,000 gms. / 1,000 cycles

197 mgm. loss w/o clear, 112 mgm. loss w/ clear

Impact Resistance: ASTM D2794

Direct at 80 in/lbs. – pass

Flexibility: ASTM D522 Method A

1/8" conical mandrel - pass

Chemical Resistance: ASTM D1308 (24 hr. covered contact)

10% Hydrochloric acid – slight stain, no damage to film

10% Sulfuric acid – no effect

10% Acetic acid – no effect

10% Phosphoric acid – no effect

10% Sodium hydroxide – swelling of film

10% Ammonium hydroxide – no effect

10% Iodine – no effect

Antifreeze – no effect

Human blood – no effect

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