



Are Gustafson Products Paintable?

Gustafson has had numerous inquiries on the painting of galvanized duct surfaces. In the course of responding to these inquiries we have compiled quite a bit of research on this topic. Some of the most important points for your consideration are listed below:

- The use of a “paint grip” or “mill phosphatized” surface is not necessary in order to facilitate surface painting.
- Gustafson recommends the use of “DTM” (Direct to Metal) paint products. These paints are available through all major paint manufacturers and are specifically designed to adhere to galvanized steel surfaces.
- Regardless of what types of paints or surfaces are used it is critical that all surfaces are cleaned of surface contaminants prior to the application of the paints. It is commonly recognized that today’s paints adhere equally well to either a galvanized or “paint grip” surface provided that all surface contaminants such as dust, dirt, mud, lubricant residue, etc. are removed prior to painting.
- Gustafson’s manufacturing incorporates water-soluble lubricants that leave little residue and can be easily removed prior to painting using only a soapy water solution.
- It should also be noted that all manufacturers use lubricants in their manufacturing processes to reduce the wear and tear on the manufacturing machinery caused by heat generated by friction between the machinery and the material’s surface. As a ‘paint grip’ surface is rougher it generates more heat than standard galvanized surfaces due to increased friction with the manufacturing machinery. Because of this increased friction the manufacture of ‘paint grip’ materials requires more lubricants which translates to more residue which must be removed prior to painting in order to ensure paint adhesion.”

• Most architects request a painted surface for aesthetic reasons. Desiring that the exposed ductwork in their buildings is attractive and free from unsightly surface blemishes. With this in mind, it is important to point out that Gustafson's Safe® is a self-sealing duct system which eliminates the need for the installer to manually apply external sealants, tapes, and mastics which are not only difficult to paint uniformly but which also deteriorate over time. If left unsealed, dust and dirt traveling through the air system (not removed by filters) inevitably results in "air marks" around any unsealed joints further detracting from the architect's aesthetic intentions for the duct system. We hope that some or all of the points uncovered in the process of our research will prove useful to you. Specification for galvanized sheet metal ductwork properly prepared for painting:

A. Surface shall be clean, dry, and free from spiral manufacturer's lubricants;

B. Remove dirt and grease from galvanized spiral ductwork with water and a non-petroleum based detergent (Simple Green, TSP, Krud Cutter, Dawn) and wipe dry with a clean cloth; and

C. Surface shall be free of foreign materials that will adversely affect adhesion or appearance of applied paint coating. "DTM" (Direct to Metal) paint will adhere properly to galvanized metal. Sherwin Williams, a major manufacturer of DTM painting systems, recommends the following dry-fall water-based painting system:

Galvanized Metal

Primer / Top Coat	Sherwin Williams	B42W series
Primer / Top Coat	Sherwin Williams	B42T1

Some important notes:

✓ When using oil based paints please refer to the manufacture's recommendations for surface preparation and primer requirements. For instance, alkyd oils will react with the zinc and saponify leading to paint failure.

✓ Anecdotal comments from a major paint manufacturer has implied that it has been their experience, when using paint grip, galvalume, and other similar surface