

ZINCANODE 330 Inorganic Zinc Silicate Primer

PRODUCT DESCRIPTION

A High performance two pack self-curing inorganic zinc primer as a new construction or maintenance primer.

- Solvent based ethyl silicate pigmented with zinc powder.
- Fast drying primer with outstanding anti-corrosive protection.

DESIGNED USE

- Anti-corrosive primer or blast cleaned steel
- Will withstand surface temperatures up to 400°C

PHYSICAL DATA

VOLUME SOLIDS (Based on ASTM D2697)	62 % $\pm$ 2 %
TYPICAL DRY FILM THICKNESS	75 microns
WET FILM THICKNESS	120 microns
THEORETICAL COVERAGE	8.27 m ² /litre @ 75 microns dft
COLOUR	Greenish Grey
FINISH	Matt

APPLICATION DETAILS

METHOD OF APPLICATION :					
AIRLESS SPRAY			This is the recommended method of application: Maximum 5% Thinner may be added. Tip Size: 0.43 - 0.58 mm (0.017 - 0.023 in) Pressure: 110 - 160 kg/cm ² (1600 - 2300 psi)		
CONVENTIONAL SPRAY			This is also a suitable method of application. Maximum 20% Thinner may be added Tip Size: 1.80 - 2.20 mm (0.071 - 0.087 in) Pressure: 2.75 - 3.45 kg/cm ² (40 - 50 psi)		
BRUSH OR ROLLER			May be used for difficult shapes or touch-up. However, additional coats may be required to achieve the recommended film thickness.		
DRYING TIME:					
Surface Temperature	Touch Dry	Hard Dry	Over coating Interval		Pot Life
			Minimum	Maximum	
15°C	35 mins	18 Hrs	36 Hrs	Indefinite	10 Hrs
25°C	15 mins	16 Hrs	24 Hrs	Indefinite	8 Hrs
35°C	10 mins	10 Hrs	18 Hrs	Indefinite	4 Hrs
45°C	5 mins	6 Hrs	12 Hrs	Indefinite	2 Hrs
NO. OF COMPONENTS			Two		
Mixing Ratio			1 part liquid to 2 parts Zinc powder		
Application Conditions			Do not apply this product if the Relative Humidity exceeds 85% or if the substrate temperature is within 3°C of the dew point		

ADDITIONAL INFORMATION

Thinner / Cleaning solvent	Solvalux 7-45
Storage Instruction	Store in a cool shaded dry area
Flash Point	Mixed 18°C
Packaging	20 liters
Shelf Life	6 months from the date of manufacture.

SURFACE PREPARATION

- Remove all wax, oil and grease by solvent cleaning in accordance with the guidelines given by SSPC-SPI.
- Where necessary remove weld spatter and round off all rough weld seams and sharp edges to a smooth surface.
- Abrasive blast clean to a minimum standard of Sa 2 ½ Swedish Standard SIS 05 59 00 or ISO 8501-1 : 1988.
- Any surface defects revealed by blast cleaning should be ground, filled or treated in a suitable manner.
- An average surface profile of 50 microns is acceptable, but this average should not exceed 75 microns.
- After blasting, remove dust from the surface.
- The surface to be coated must also be clean and dry.
Before over coating this product ensure that the surface is clean, dry and free from zinc salts.
- If the surface shows sign of breakdown, a sweep blast may be necessary.

APPLICATION

Stir liquid converter thoroughly and add powder. Continue stirring until thoroughly mixed. Filter through a 30 to 60 mesh screen to remove any large particles before use. The continuously mixed material should be applied by spray. Rinse equipment with Solvalux 7-45 before use. When application is made by conventional spray, use the lowest air pressure that will achieve good atomization in order to minimize overspray. Apply the material in one wet coat, overlapping each pass 50% and holding the spray gun at right angles to the surface at all times. The spray gun should be held approximately 8 inches (20cm) from the surface, using a 6 to 8 inch (15-20cm) fan.

When application is made by airless spray, use an inbound pressure approximately 10 psi above the level at which "pig-tails" occurs. Hose length should be limited to not more than 20 meters.

PRODUCT USE RESTRICTIONS

- This product will cure more slowly if the Relative Humidity falls below 50%.
- Dry heat resistance up to 400°C.
- May also be applied between 50 and 75 microns DFT.

SAFETY PRECAUTIONS

- Avoid contact with the skin and eyes. Wear suitable protective clothing such as overalls, goggles, dust masks and gloves. Use a barrier cream.
- Ensure that there is adequate ventilation in the area where the product is being applied. Do not breathe vapor or spray.
- This product is flammable. Keep away from sources of ignition. Do not smoke. Take precautionary measures against static discharge. In case of fire – blanket flames with foam, carbon dioxide or dry chemicals.
- Refer to MSDS for further information.

FIRST AID

- Eyes: In the event of accidental splashes, flush eyes with water immediately and obtain medical advice.
- Skin: Wash skin thoroughly with soap and water or approved industrial cleaner.
- DO NOT USE solvent or thinners.
- Inhalation: Remove to fresh air, loosen collar and keep patient rested.
- Ingestion: In case of accidental ingestion, DO NOT INDUCE VOMITING.
Obtain immediate medical attention.

DISCLAIMER

The information provided on this data sheet is not intended to be complete and is provided as general advice only. It is the responsibility of the user to ensure that the product is suitable for the purpose for which he wishes to use it. As we have no control over the treatment of the product, the standard of surface preparation of the substrate, or other factors affecting the use of this product, we are not responsible for its performance nor would we accept any liability whatsoever or howsoever arising from the use of this product unless specifically agreed to in writing by us. The information contained in this data sheet may be modified by us from time to time, and without notice, in the light of our experience and continuous product development.