SP ZINC RICH 55

TECHNICAL DATA

The Ultimate Protective Solution

A two pack Epoxy, polyamide cold cured **Zinc Rich Primer** heavily pigmented with metallic zinc dust.

INTEDED USES

A high performance anti-corrosive primer recommended to aggressive environments like offshore structures, petrochemical refineries, pulp & paper plants, power plants, bridges, ships, mining equipments etc., recommended for direct application on Ferrous metals only after shot blasting surface preparation. The zinc pigment (50%) in the dried film provides excellent cathodic protection by sacrificing itself. This product is compatible with our epoxy or polyurethane topcoats.

PHYSICAL PROPERTIES

Colour	: Grey (self standard)
Finish	: Matt
% Solids by Volume	: 60 ± 2 %
Flash Point	: Above 25^0 C
Mixing ratio (Base : Hardener)	: As mentioned on containers by Volume
Thinner intake	: 5 %
Maturation time	: Allow the mixed material for 10-15 minutes before use.
Recommended D.F.T.	: 50-60 µm per coat.
Drying time @ 30^oC & at recommended D.F.T.	: a) Surface Dry : 1 hr. b) Hard dry : 10-12 hrs. c) Complete Cure: 7 days (for chemical testing)
Over coating Interval	: 4 to 24 hrs. @ 30^0C
Recommended Thinner	: T-1000 for thinning & equipment cleaning
Pot Life	: 4 – 6 hrs. @ 30^0C
Shelf life	: 12 months (Individual sealed components under normal storage condition)
Theoretical Coverage	: 12 m^2/litre on smooth & non-absorbent surface @ recomd. DFT
Application method	: By Airless spray / Brush
Compatibility	: Can be over coated with Epoxy or Polyurethane topcoats.

SURFACE PREPARATION :

Remove all contaminants, oil, grease etc. by use of our thinner. Prepare the substrate by Abrasive blast cleaning only. Blast clean to Sa 2 ½ (ISO 8501-1), steel profile recommended 40 – 75 µm. Check the steel profile, if it is between 50 - 60 µm then the (DFT) thickness of the total paint system should be 150 – 180 µm. (The DFT of the total paint system should be thrice to profile of the blasted surface.)

APPLICATION EQUIPMENTS :

AIR SPRAY

Nozzle Size : 1.8 – 2.2 mm
Operating Pressure : 4-5 kg/cm^2 (50- 80 psi)

AIRLESS SPRAY

Nozzle Size : 0.38 – 0.48 mm
Operating Pressure : 115 kg/cm^2 (1600 psi)

The airless spray details given above are intended as a guide only. Details such as fluid hose length and diameter, paint temperature and job shape and size all have an effect on the spray tip and operating pressure chosen. However, the operating pressure should be the lowest possible consistent with satisfactory atomization. As conditions will vary from job to job it is the applicators' responsibility to ensure that the equipment in use has been set up to give the best results.

APPLICATION BY BRUSH

The material is suitable for brush application to small areas and for touch up purposes. Application of more than one coat may be necessary to give equivalent dry film thickness to a single spray applied coat.

EXPOSURE TO WEATHERING

If this primer has exposed to the weather for long period, there is a risk of the formation of zinc salts on the surface, which must be removed by flash blasting or washing down prior to overcoating, otherwise intercoat adhesion may be adversely affected.
The rate of zinc salt formation will vary from one location to another. Under severe conditions e.g. marine coastal, offshore or heavy industrial area, it is strongly recommended that overcoating by Epoxy or polyurethane paints takes place within 3-4 days.

APPLICATION CONDITIONS AND OVERCOATING :

This product should preferably be applied at temperatures in excess of 10^0 C. In conditions of high relative humidity i.e. 80-85% good ventilation conditions are essential. Substrate temperature should be at least 5^{0}C & above the dew point. This product can be over coated after 3-4 hrs.

The maximum air and substrate temperature for application is 50^{0}C providing conditions allow satisfactory application & film formation. If the air & substrate temperature exceed 50^{0}C & this coatings are applied under these conditions, paint film defects such as dry-spray, bubbles & pinholes etc. can occur within the coating.

Application at ambient air temperatures below 5^{o}c is not recommended. Do not apply when relative humidity rises above 90%. Do not apply during rain, fog or mist. Such conditions do not permit adhesion of coating with the substrate. **(For details please refer our painting procedure.)**

POT LIFE OF MIXED MATERIAL :

At the time of mixing the material, if the temperature exceed of 35^{0}C the pot life will be approximately halved. Use of this product outside of the pot life may result in inferior adhesion properties even if the material appears fit for application. Thinning the mixed product will not alleviate this problem.

Thinner should be added after mixing the Base & Hardner in recommended mixing ratio by volume.

ADDITIONAL NOTES :

Drying times, curing times and pot life should be considered as a guide only.
The curing reaction of this product commences immediately the two components are mixed, and since the reaction is dependent on the atmospheric **temperature**.

Numerical values quoted for physical data vary slightly from batch to batch & against the temperature.

Immediately close the partly used Hardner container, it is very sensitive to atmospheric moisture.

SAFETY PRECAUTIONS :

While applying this product in closed structures, arrangements for adequate ventilation must be ensured. Smoking and naked lights should not be permitted. Mask should be worn when spraying. To avoid skin contamination use barrier cream or disposable gloves. Wash hands and face regularly with hot water and soap. Brushes & equipment should be cleaned with recommended thinner immediately after use.

DISCLAIMER : The information in this data sheet is given to the best of our knowledge based on laboratory testing & practical experience. It is the user's responsibility to conduct all necessary trials & tests to confirm the suitability of any product or system to their intended use. Our all recommendations or suggestions whether in technical documentations in writing or verbal are given in good faith but without any type of warranty or liability on us. We have no control over either the quality or condition of the substrate, or the factors affecting the use & applications of the product. Therefore we do not accept any liability arising from loss, injury or damage resulting from such uses.

The Ultimate Protective Solution

SWARAJ POLYCOATS

B – 53, STICE, Musalgaon, Tal- Sinnar, Dist- Nashik – 422103, Maharashtra, INDIA.
Telefax : +91-2551-240182.
www.swarajpolycoats.com E-mail : swaraj.polycoats@gmail.com