

PRODUCT DESCRIPTION

Generic: Organic Zinc Rich Epoxy

General Description: A high performance, two component, organic zinc-rich primer with proven cathodic protection of steel structures.

This unique formula features a pre-mixed zinc base which, when converted, can be applied over commercial abrasive-blasted steel (SSPC SP-6, ISO-Sa-2). Most ICI Devoe Coatings High Performance Finishes can be applied as soon as solvents evaporate from the film without topcoat bubbling normally experienced over inorganic zinc-rich primers.

Typical Uses: Ideal for cathodic protection of steel structures, tanks, equipment, piping and other steel surfaces exposed in mild to severe industrial environments. Also ideal for touch-up and maintenance work because of its easy application, wide compatibility and fast dry-to-recoat.

Special Qualifications: Meets Class B slip and creep for faying surfaces.

SPECIFICATION DATA

Color: Green (315HB225)

Finish: Flat

Reduction Solvent: T-10 Thinner

Clean-up Solvent: T-10 Thinner

Weight/Gallon: 21.41 lbs./gal. (2.57 kg/L)

VOC: (EPA 24) 2.55 lbs./gal. (305 g/L)

Solids By Volume: (ASTM D 2697-7days): 73% ± 2%

Theoretical Coverage at 1.0 Mil Dry: 1171 sq. ft./gal. (29.2 m²/L)

Recommended Film Thickness: 3.0-4.0 mils (75-100 microns) dry – 4.1 mils (102-138 microns) wet

Systems: Please consult the appropriate system guide, the particular job specification or your ICI Paints' Representative for proper systems using this product. Systems must be selected considering the particular environment involved.

Minimum Dry Time (ASTM D 1640): At 3 mils (75 microns) DFT

Substrate Temperature	40°F (4°C)	77°F (25°C)	90°F (32°C)
To recoat	5 hours	2 hours	1 hours
Dry hard	20 hours	5 hours	2 hours

Ventilation, film thickness, humidity, thinning and other factors can influence the rate of dry.

As part of good painting practice, it is recommended that the surface must be clean, dry and free of any contaminants. All chalk and salts must be removed.

Recoat times with Devoe High Performance Coatings Brand epoxies and urethanes are extended. Consult your ICI Paints' Representative for details.

Warning: The above table provides general guidelines only. Always consult your ICI Paints' Representative for appropriate recoat windows since the maximum aged recoat time of this product may be significantly shortened or lengthened by a variety of conditions, including, but not limited to humidity, surface temperature, and the use of additives or thinners. The use of accelerators or force curing may shorten the aged recoat of individual coatings. The above recoat windows may not apply if recoating with a product other than those listed above. If the maximum aged recoat window is exceeded, please consult your ICI Paints' Representative for appropriate recommendations to enhance adhesion. Failure to observe these precautions may result in intercoat delamination.

Shelf Life: Over 24 months at 77°F (25°C) – unopened

Mix Ratio By Volume: 4.5 (base): 0.5 (converter) – see mixing instructions.

Induction: 15 minutes minimum below 60°F (16°C) – see mixing instructions.

Pot Life: 8 hours @ 77°F (25°C) & 50% R.H.

FEATURES

Advantages:

- Exceptional corrosion resistance
- Provides cathodic protection
- Easy to mix
- Zinc premixed in base component
- Fast dry to handle and recoat
- Formulated to resist topcoat bubbling
- Applies easily by brush, roll or spray
- Accepts a wide variety of topcoats for severe exposures
- Formulated without lead, chromate, or mercury components

Limitations of Use: Do not topcoat with alkyd or alkyd-urethane coatings. Not suitable for solvent or chemical immersion.

PERFORMANCE DATA

Salt Spray Resistance (ASTM B 117) – Excellent

Direct Impact Resistance (ASTM D 2794) – Good

Humidity Resistance (ASTM D 4585) – Excellent

Water Immersion (ASTM D 1308) – Excellent

Service Temperature Limits: 250°F (121°C) dry, intermittent

Hardness (ASTM D 3363, 7 day cure @ 77°F (25°C): 6H

GENERAL SURFACE PREPARATION

All surfaces must be sound, dry, clean and free of oil, grease, dirt, mildew, form release agents, curing compounds, loose and flaking paint and other foreign substances, and be structurally sound. Round off welds and sharp edges and remove weld splatter.

New Surfaces: Steel – Abrasive blast to minimum SSPC-SP6, (ISO-Sa2). A cleaner surface (i.e. SSPC-SP10, ISO-2½ near-white) will enhance primer and system performance. The blast profile should be jagged rather than "peened" and between 1.5

to 2.5 mils (38-62 microns). After blasting, vacuum or blow off all abrasive dust and ensure surface remains clean before painting.

Previously Painted Surfaces: Remove old paint to bare metal. Prepare surface and prime as for new steel. Achieve a minimum of SSPC-SP6 (SSI-Sa2) on rough or pitted steel.

DIRECTIONS FOR USE

Tinting: Do not tint.

Thinning: Thinning is not normally required or desirable. However, at lower temperatures, small amounts (10% or less) of Devco T-10 Thinner can be added to the mixed components depending on local VOC and air quality regulations.

Mixing: CATHA-COAT® 315HB Primer is supplied in a 3 gallon kit which contains the proper ratio of ingredients. The entire contents of each container must be mixed together. The zinc metal is ready-mixed in the base portion. Stir thoroughly with a slow speed mixer while slowly adding the converter. Continue to mix at slow speeds to a homogeneous condition. At temperatures of 60°F (16°C) or above, allow a 15 minute induction time before using. Add about 10 minutes for each 10°F (6°C) lower temperature. The pot life, 8 hours at 77°F (25°C), will be longer at lower temperatures and shorter at higher temperatures.

Application: Spray, roller or brush. Use brush and roller primarily for touch-up and repair. Spray is preferred for uniform film build. Use agitated spray pots. For air spray, use .070" or larger tip, 15 psi fluid pressure, fluid hose 1/2" I.D. and maximum 50 ft. length. For airless spray use a sprayer capable

of 3,000 psi (207 bars) and able to support a .025" diameter tip, fluid hose 3/8" I.D. and maximum 50 ft. length. Pressure pots or pumps should be at same level or above spray guns. Keep fluid pressures to minimum. Rough or heavily pitted steel requires higher (or increased) dry film thickness for optimum protection. Care should be taken to ensure that proper film thicknesses are applied. Brushing and rolling may require multiple coats to achieve correct film thickness and/or hiding.

Spreading Rate: Apply at 293-390 sq.ft. per gallon (7.3-9.7 m²/L) depending on surface texture and porosity. Make allowances for any losses due to overspray or surface irregularities.

Topcoats: CATHA-COAT 315HB can be readily recoated by itself for easy touch-up. May be topcoated with DEVCO® 224HS or BAR-RUST® Epoxy Coatings. No tie coat is required before applying finish coat. Do not topcoat with alkyd or alkyd-urethane coatings.

Dry Time: At 77°F (25°C) & 50% R.H., dries to recoat in 2 hours; hard 5-6 hours.

Clean-up: Use T-10 Thinner.

PRECAUTIONS

DANGER! FLAMMABLE LIQUID AND VAPOR. CORROSIVE. CAUSES EYE AND SKIN BURNS. HARMFUL OR FATAL IF SWALLOWED. ASPIRATION HAZARD-CAN ENTER LUNGS AND CAUSE DAMAGE. HARMFUL IF INHALED. MAY CAUSE CENTRAL NERVOUS SYSTEM EFFECTS, INCLUDING DIZZINESS, HEADACHE OR NAUSEA. CAUSES RESPIRATORY TRACT IRRITATION. MAY CAUSE ALLERGIC SKIN AND RESPIRATORY REACTION. MAY BE HARMFUL IF ABSORBED THROUGH SKIN. OVEREXPOSURE MAY CAUSE BLOOD, LIVER, KIDNEY DAMAGE. CONTAINS CRYSTALLINE SILICA WHICH CAN CAUSE LUNG CANCER AND OTHER LUNG DAMAGE IF INHALED. USE ONLY WITH ADEQUATE VENTILATION. KEEP OUT OF THE REACH OF CHILDREN. NOTICE: Products in this series contain solvents. Reports have associated repeated and prolonged occupational overexposure to solvents with permanent brain and nervous system damage. Intentional misuse by deliberately concentrating and inhaling the contents may be harmful or fatal. For emergency information call (800) 545-2643. **Note: These warnings encompass the product series. Prior to use, read and follow product-specific MSDS and label information.** Keep away from heat, sparks and flame. **Do not smoke.** Vapors may ignite. Extinguish all flames, burners, stoves, heaters and pilot lights and disconnect all electrical motors and appliances before use and until all vapors are gone. Prevent build-up of vapors by opening all windows and doors to achieve cross-ventilation. If sanding is done, wear a dust mask to avoid breathing of sanding dust. Do not breathe vapors or spray mist. Ensure fresh air entry during application and drying. Avoid contact with eyes and skin. If you experience eye watering, headaches, or dizziness, leave the area. If properly used, a respirator may offer additional protection. Obtain professional advice before using. Close container after each use. **FIRST AID:** In case of skin contact, wash **thoroughly** with soap and water. If any product remains, gently rub petroleum jelly, vegetable or mineral/baby oil onto skin, then wash again with soap and water. Repeated applications may be needed. Remove contaminated clothing. For eye contact, flush **immediately** with large amounts of water, for at least 15 minutes. **Obtain emergency medical treatment.** If swallowed, **obtain medical treatment immediately.** If inhalation causes physical discomfort, remove to fresh air. If discomfort persists or any breathing difficulty occurs, **get medical help.** **KEEP FROM FREEZING.**

DS240-1003

SHIPPING

Flash Point: 80°F (27°C)
Packaging: 3 gallon kit (18.925L)
 2.7 gallon base
 0.3 gallon converter

Shipping Weight: 3 gallon kit - 70 lbs. (31.5 kg)

Will be packaged in a 5 Gallon Pail

315HBXXX (7/06)
 Ad Stock #67014E



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