

PRODUCT DESCRIPTION

Generic: Zinc Rich Epoxy

General Description: A zinc rich epoxy polyamide coating combining durability and easy application characteristics. It serves as an excellent maintenance primer for protection of structural steel in coastal or weathering environments. Cures to a hard, tough film.

Typical Uses: Specially formulated to provide excellent adhesion combined with sacrificial protection to steel where surface preparation may be less than the ultimate.

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

SPECIFICATION DATA

Color: Green (315K0225)

Finish: Flat

Reduction Solvent: T-10 Thinner

Clean-up Solvent: T-10 Thinner

Weight/Gallon: 26.5 lbs./gal. (3.18 kg/L)

VOC (EPA 24): 2.52 lbs./gal. (302 g/L)

Solids By Volume (ASTM 2697-7 days): 75% ± 2%

Theoretical Coverage at 1.0 Mil Dry: 1203 sq. ft./gal. (30.0 m²/L)

Recommended Film Thickness: 3.0-4.0 mils (75-100 microns) dry – 4.0-5.3 mils (100-134 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.

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

Substrate Temperature	40°F (4°C)	60°F (16°C)	80°F (27°C)
Minimum Recoat	5 Hours	2 Hours	1 Hour
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 12 months at 77°F (25°C) – unopened

Percent Zinc Content: 84% ± 2% in dry film

Induction: Above 75°F (24°C) – 30 minutes. Below 75°F (24°C) – 60 minutes.

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

FEATURES

Advantages:

- Surface preparation less stringent than for inorganic zinc rich coatings
- Topcoating less prone to cratering and pinholing
- Accepts a wide variety of topcoats
- May be topcoated in 2-4 hours @ 77°F (25°C)
- Meets SSPC Paint 20

Limitations of Use: Do not topcoat with alkyd or alkyd-urethane coatings.

PERFORMANCE DATA

Salt Spray (ASTM B 117) – Excellent

Adhesion (ASTM D 4541) – Excellent

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

GENERAL SURFACE PREPARATION

All surfaces must be sound, dry, clean, free of oil, grease, dirt, mildew, form release agents, curing compounds, loose and flaking paint and other foreign substances.

Surfaces: New Steel – Abrasive blast to commercial blast cleanliness in accordance with SSPC-SP6 (ISO Sa2) for general use. Blast profile should be 1/4 to 1/3 of total **system** dry film thickness, but **not** more than the dry film thickness

specified for the first coat. Where blasting is not possible, power tool cleaning (SSPC-SP3) is acceptable so long as a profile is created.

Previously Painted Surfaces: Not recommended over previously painted surfaces. Old coatings must be removed and profile established as in **New Surfaces**.

DIRECTIONS FOR USE

Tinting: Do not tint.

Thinning: If required by job conditions, may be reduced up to one pint per gallon with T-10 Thinner to obtain a full wet coat without dry spray. For brush and roller application, reduce with up to one pint T-10 Thinner per gallon. Any solvent reduction should be made after the induction (standing) period, but prior to straining, and should be in compliance with local VOC and air quality regulations.

Mixing: This coating is supplied as a three-component kit. Pour the Converter Portion into the Base Portion under constant agitation (explosion proof mechanical mixing is recommended). When thoroughly blended, sift in the Powder Portion, stirring constantly until smooth and free of lumps. Allow to stand 30 minutes prior to use if ambient temperature is 75°F (24°C) or above (60 minutes if ambient temperature is below 75°F (24°C), then strain through a 50 mesh screen.

Containers, pressure pots, equipment and fluid feed lines must be clean and dry. Dried paint left in any of these items may be softened and lifted by the solvent in this product and may cause clogging of the spray gun.

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, .070" or larger tip, 15 psi fluid pressure, fluid hose 1/2" ID 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" ID 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 300-401 sq.ft. per gallon (7.5-10 m²/L) depending on surface texture and porosity. Make allowances for any losses due to overspray or surface irregularities.

Topcoats: Do not apply topcoats until sufficiently cured (see Dry Time).

This product may be topcoated with converted epoxy, epoxy coal tar or acrylic latex coatings. Other topcoats may be suitable – consult your ICI Paints' Representative. To use alkyds or other conventional finishes as topcoats, first apply a barrier coat of double build epoxy.

If cratering or bubbling is encountered during topcoating, apply a first coat of topcoat reduced 1:1 with recommended solvent, the follow with a second, normal coat.

Dry Time: Dries to touch in 1 hour, recoat in 2 hours, and dry hard in 4-5 hours at 77°F (25°C) & 50% RH.

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.**

DS212-1003

SHIPPING

Flash Point: 80°F (27°C)
Packaging: 3.00 gallon kit (11.36L)
 1.74 gallon base
 0.24 gallon converter
 1.02 gallon powder

Shipping Weight: 3 gallon kit - 84 lbs. (38.92 kg)

315KXXX (7/06)
 Ad Stock #68772C



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