

PRODUCT SPECIFICATIONS

Product Description

A two component, high build, inorganic zinc rich alkyl silicate primer. It conforms to composition and performance requirements of SSPC Paint 20 Level 1 with 85% zinc on dry film.

Design Feature

- A high performance primer to provide corrosion protection to blasted steel substrates in highly corrosive environments, e.g. onshore and offshore steelworks, pipelines, bridges etc.
- A post fabrication primer for long-term protection prior to subsequent overcoating in the field.
- Minimum 85% zinc on dry film providing outstanding long-term anti-corrosive performance.
- Fast drying primer.
- Able to withstand surface dry heat temperature of up to 400°C.

Physical Characteristics

Recommended Application Data		Wet [µm]	Dry [µm]	m²/l
Theoretical Coverage		121	75	8.27
Volume solids	:	62 % (based on ASTM D2697)		
Dry Film Thickness Range	:	50 µm to 75 µm		
Flash Point	:	12 °C		
Finish	:	Matt		
Colour Range	:	Grey		
Standard Packing Size	:	5 litres set (4.82 litres Converter : 5.82 kg Powder)		
Mix Ratio (by volume)	:	4.18 Converter : 0.82 Powder		

Application Method

AIRLESS SPRAY	:	Tip Size : 0.43 – 0.58 mm (17 –23 thou)
Recommended method of application	:	Pressure : 110 –160 kg/cm² (1600 – 2300 psi)
		Use an inbound pressure approximately 10 psi above the level at which “pig-tails” occur. Hose length should be limited to not more than 20 metres.
CONVENTIONAL AIR SPRAY	:	May be used. Use the lowest air pressure that will achieve good atomisation in order to minimise over-spray. The spray gun should be held about 8 inches (i.e. 20cm) from the surface, using a 6 to 8 inch (i.e. 15 – 20cm) spray fan.

Filter the zinc powder through a screen of 250µm to 500µm to remove any large particles. Stir liquid converter thoroughly and then add the filtered powder while stirring. Ensure that the liquid converter and the powder are homogenous and thoroughly mixed. Maintain continuous stirring during application.

Drying & Curing Time

Substrate Temperature	Touch Dry	Hard Dry	Overcoating Interval		Pot Life
			Min.	Max.	
15 °C	35 mins.	2 hours	9 hours	Indefinite	12 hours
25 °C	15 mins.	1 hours	5 hours	Indefinite	6 hours
35 °C	10 mins.	30 mins.	2 hours	Indefinite	3 hours

*The overcoating times given in the table is for a relative humidity level above 70%. Below 65% relative humidity, the overcoating intervals need to be doubled, i.e 20 hours at 35 °C.

**Useful
Information**

THINNER : SOLVALUX 7-45 (Maximum 5% addition)
CLEANER : SOLVALUX 7-77
STORAGE : Store in a cool dry shaded area.
SHELF LIFE : 6 months minimum when stored as prescribed in the MSDS.

**Surface
Preparation**

The service life span and the service performance of ZINCANODE 330 is directly related to the degree of surface preparation.

STEEL

- Remove all wax, oil and grease by solvent cleaning in accordance with the guidelines given by SSPC-SP1. Where necessities 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 Sa2½ (ISO 8501-1:1988) or SSPC-SP10. For optimum performance a blast to Sa 3.0 White Metal or SSPC-SP5 is recommended. An average surface profile of 50 microns is acceptable, but this average should not exceed 75 microns.
- Ensure that all surface defects detected after blast cleaning is ground, filled or treated in a suitable manner.
- After blasting, remove dust from the surface. Ensure that the surface to be coated is clean, dry and free from any contaminants.
- Apply Zincanode 330 immediately after blasting to avoid oxidation and recontamination of the steel surface. In case of oxidation or recontamination, re-blast to the required standard.

To avoid condensation of moisture onto substrate prior to coating application, relative humidity should not exceed 85% and substrate temperature should be more than 3°C above Dew Point.

**Suitable
Overcoats**

Epilux 610, Epilux 78, Epilux 218, Epilux 58, Epilux 58HS, Epimastic 3000HS, Epimastic 3100, Epimastic 5100, Epilux 82, Epilux 15HS, Epilux 18HS, Steelshield 1200, Luxatherm 5200, Luxatherm 5600, Luxatherm 6200

Notes

- Apply suitable tie coat or mist coat of finish paint before final application of top coat to avoid craters or blisters development after finish coat application.
- This product requires moisture in the atmosphere to cure. It will not cure completely or adequately if the Relative Humidity falls below 50%. In such cases, a steam or water spray may be required to complete cure.
- Do not exceed 120 microns dried film thickness to avoid mud-cracking phenomenon.

**Safety
Precaution**

- Avoid contact with eyes and skin. Wear suitable protective clothing such as overalls, goggles, dust mask and gloves. Use barrier cream.
- This product contains low flash point solvents, do not use in poorly ventilated areas especially in confined tank interiors.
- Ensure that there is adequate ventilation in the area where the product is being applied. Do not breathe in vapour or spray mist.
- 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.

First Aid

Eyes : In the event of accidental splashes, flush eyes with warm water immediately and seek medical advice.
Skin : Wash skin thoroughly with soap and water or approved industrial cleaner. Do Not Use solvents 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.

For further safety information, please refer to our **Material Safety Data Sheet (MSDS)**

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.

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