



## ZINCANODE 668

Epoxy Zinc Primer

### PRODUCT DESCRIPTION

A two component epoxy zinc primer. It conforms to the composition and performance requirements of SSPC Paint 29.

### DESIGN FEATURES

A high performance zinc rich anti-corrosive primer for corrosive atmospheres such as onshore and offshore steel superstructures, pipelines, bridges etc.  
 Maintenance and repair coating for inorganic zinc rich coatings.  
 Excellent anti-corrosive performance.  
 Fast curing with rapid handling features.  
 Long term recoatability properties.  
 Dry heat resistance up to 150 °C.

### PHYSICAL CHARACTERISTICS

Recommended Application Data		Wet [ $\mu\text{m}$ ]	Dry [ $\mu\text{m}$ ]	m <sup>2</sup> /l
Theoretical Coverage		114	50	8.8
Volume solids	44% (based on ASTM D2697)			
Dry Film Thickness Range	50 $\mu\text{m}$ to 75 $\mu\text{m}$			
Flash Point	25 °C			
Finish	Matt			
Colour Range	Grey			
Standard Packing Size	5 litres set ( 3.75 litres Base : 1.25 litres Hardener) 20 litres set (15 litres Base : 5 Litres Hardener)			
Mix Ratio (by volume)	3 Base : 1 Hardener			

### APPLICATION METHOD

AIRLESS SPRAY	Tip Size : 0.53 – 0.58 mm ( 21 - 23 thou )
Recommended method of application	Pressure : 110 –160 kg/cm <sup>2</sup> (1600 – 2300 psi)
CONVENTIONAL AIR SPRAY	Possible application method. However, may require additional dilution to achieve good atomisation.
BRUSH OR ROLLER	May be used for difficult shapes or touch-up; however, additional coats may be required to achieve the recommended film thickness. These application methods are recommended for stripe coating welds, edges, rivets, etc.

### DRYING & CURING TIME

Substrate Temperature	Touch Dry	Hard Dry	Overcoating Interval		Pot Life
			Minimum	Maximum	
15 °C	60 minutes	4 hours	4 hours	Indefinite	12 hours
25 °C	45 minutes	3 hours	3 hours	Indefinite	6 hours
35 °C	35 minutes	2 hours	2 hour	Indefinite	3 hours

### USEFUL INFORMATION

THINNER	: SOLVALUX 7-45 (Maximum 5% addition)
CLEANER	: SOLVALUX 7-77
STORAGE	: Store in a cool dry shaded area.
SHELF LIFE AT 25 °C	: 12 months minimum when stored as prescribed in the MSDS.



## SURFACE PREPARATION

The service life span and the service performance of ZINCANODE 668 are 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 necessary removes 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 with an average surface profile of 40 to 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 668 immediately after blasting to prevent 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, Epilux 4, Luxathane 5075, Luaxthane 5150HS, Luxthane 5000HB

## 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.
- Not recommended for acidic or alkaline atmospheres and immersion service conditions unless a suitable topcoat is applied over ZINCANODE 668.
- Do not overapply. Over application may lead to slower dry times and subsequent cohesive failure on overcoating.
- Exposure to very low temperatures and/or high humidity during and/or immediately after application may result in incomplete cure that may compromise subsequent intercoat adhesion.

## SAFETY PRECAUTION

Avoid contact with eyes and skin. Wear suitable protective clothing such as overalls, goggles, dust mask and gloves. Use barrier cream.

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)**

## 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.*