



## ZINCANODE 300

Zinc Silicate Shop Primer

### PRODUCT DESCRIPTION DESIGN FEATURES

A two component, fast drying, weldable zinc ethyl silicate pre-fabrication primer for application by manual or automatic spray equipment.

As a temporary protective primer for blasted steel substrates prior to the fabrication process. Fast drying for easy and quick handling of coated steel. Good anti-corrosive performance. Able to withstand continuous surface dry heat temperatures of up to 400°C. Approved as a weldable primer by Lloyd's Register of Shipping. Can be overcoated with a wide range of high performance coatings for use in a variety of environments such as offshore structures, petrochemical plants, bridges, pipelines etc.

### PHYSICAL CHARACTERISTICS

Recommended Application Data	Wet [ $\mu\text{m}$ ]	Dry [ $\mu\text{m}$ ]	m <sup>2</sup> /l
Theoretical Coverage	54	15	18.67
Volume Solids	28 %		
Dry Film Thickness Range	15 $\mu\text{m}$ to 25 $\mu\text{m}$		
Flash Point	4 °C		
Finish	Matt		
Colour Range	Grey, Grey Green & Red Oxide		
Standard Packing Size	20 litres set ( 10 litres Converter : 10 litres Paste)		
Mix Ratio (by volume)	1 Converter : 1 Paste		

### APPLICATION METHOD

**AIRLESS SPRAY** Tip Size : 0.43 – 0.58 mm (17 – 23 thou)  
Recommended method of application Pressure : 110 –160 kg/cm<sup>2</sup> (1600 – 2300 psi)

**CONVENTIONAL AIR SPRAY** Also recommended.

**BRUSH OR ROLLER** For touch up and small areas only.

Pour the Converter into the Paste component slowly whilst stirring with a mechanical agitator. Sieve material before application. Keep pot constantly agitated during spraying to prevent the zinc settling out.

### DRYING & CURING TIME

Substrate Temperature	Touch Dry	Hard Dry	Overcoating Interval		Pot Life
			Minimum*	Maximum	
15 C	3 minutes	5 minutes	6 hours	Indefinite*	8 hours
25 °C	3 minutes	4 minutes	3 hours	Indefinite*	6 hours
35 °C	3 minutes	3 minutes	2 hours	Indefinite*	4 hours

### USEFUL INFORMATION

**THINNER** : SOLVALUX 7-77 (Maximum 10% 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 300 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 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. The blast profile should have an angular configuration.
- 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 300 immediately after blasting to avoid oxidation and recontamination of the steel surface. In case of oxidation or recontamination, re-blast to the required standard.

<b>SUITABLE TOP COATS</b>	Epilux 610, Epilux 78, Epilux 218, Epilux 58, Epilux 58HS, Zincanode 668, Zincanode 685 Epimastic 3000HS, Epimastic 3100, Epimastic 5100, Epilux 82, Epilux 15HS, Epilux 18HS, Steelshield 1200, Luxatherm 5200, Luxatherm 5600, Luxatherm 6200
<b>NOTES</b>	<ul style="list-style-type: none"> <li>• Application by automatic spray is strongly suggested. If spraying by manual spray, care must be taken to avoid dry spray and over-application.</li> <li>• Typically for up to 9 months protection a dft of 25µm is required.</li> <li>• Over-application beyond recommended film thickness' would result in increased weld porosity and level of weld fumes.</li> <li>• 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 before overcoating.</li> <li>• This product is compatible with both sacrificial and impressed current cathodic protection.</li> <li>• Prior to overcoating this product, it is essential that all zinc corrosion products, soluble salts and other contaminants are thoroughly removed from the surface.</li> </ul>

## 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)**

## 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.*