



ZINCANODE 310

Cold Galvanizing Spray Compound

PRODUCT DESCRIPTION

A single component, high performance epoxy zinc coating.

DESIGN FEATURES

A high performance metallic zinc based anti-corrosive coating specially developed for touch up on hot dip galvanized substrates.

Outstanding anti-corrosive performance.

Maintenance and repair coating for inorganic zinc rich coatings.

Fast curing with rapid handling features.

Continuous dry heat resistance up to 150°C and intermittent temp up to 250°C maximum

PHYSICAL CHARACTERISTICS

Recommended Application Data	Wet [μm]	Dry [μm]	m^2/kg
Theoretical Coverage	125	30	8
Volume solids	24 \pm 2%		
Dry Film Thickness Range	30 μm to 60 μm		
Flash Point	25 °C		
Finish	Metallic		
Colour Range	Silver		
Standard Packing Size	5 Kg		

APPLICATION METHOD

AIRLESS SPRAY	Tip Size : 0.48 – 0.53 mm (19 - 21 thou)
Recommended method of application	Pressure : 110 –160 kg/cm ² (1600 – 2300 psi)
CONVENTIONAL AIR SPRAY	Can be used however, may require additional dilution to achieve good atomisation.
BRUSH OR ROLLER	Can 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	1 hour	3 hours	12 hours	Indefinite	10 hours
25 °C	45 minutes	2 hours	8 hours	Indefinite	5 hours
35 °C	30 minutes	1 hour	6 hours	Indefinite	3 hours

USEFUL INFORMATION

THINNER	: Not Recommended
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 310 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.
- For substrates with rust scale, power tool clean to SSPC-SP3 or SSPC-SP11.
- Abrasive blast clean to a minimum standard of minimum Sa 2 SSPC-SP6 if the surface has mill-scales. heavy rusting or previously painted.
- 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.

HOT DIP GALVANIZED SUBSTRATE:

Clean the substrate using solvent as per SSPC-SP1. Power tool clean to SSPC-SP3 or SSPC-SP11 in case of rust scales. Apply 1 – 2 coats of Zincanode 310 as per the requirement.

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	Epimastic 3000HS, Epimastic 3100, Epimastic 5100, Epilux 82, Epilux 218, Epilux 15HS, Epilux 18HS, Epilux 4, Steelshield 1200, Luxacryl 5000, Luxachlor 5000
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NOTES

- The coating specifications given above are typical. For specific recommendations to suit individual applications please refer to your Berger Paints representative.
- 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.

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