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A two pack Solvetless Epoxy Finish designed
Protecton

Scope

A two pack solvent based inorganic zinc silicate primer for protection of steel against severe corrosive environment.

It provides outstanding cathodic protection and forms a tough abrasion resistant film. It is however, not recommended for contacts with strong acids or alkalis of pH below 5 or exceeding 10.

The coatings attains water resistance within 30 minutes of application and is unaffected by rain, condensation or dew.

Zinc Anode 304 MZ

Inorganic Zinc Silicate Coating

Uses

Recommended for use on steel structures, bridges, exterior of storage tanks, bulk handling equipments pipelines, etc.

Product Data

Type: Two pack self cured

Composition: Ethyl Silicate / Metallic Zinc

Mixing Ratio: Part A & Part B when mixed will give 24 Ltr paint.

Pot Life: 4-6 hours

Application: conventional and airless spray. Brush for small areas.

Recommended DFT: 65-75 microns per coat

Corresponding WFT: 108-125 Microns per coat

Theoretical Spreading Rate: 8.0 -9.2 Sq. Mtr/Ltr

Drying time:

TOUCH: 30 minutes

HANDLE: 2-4 hours

HARD: Overnight

Curing Time: 6-7 days

Overcoating Interval: Min: Overnight
Max: Indefinite

Flash Point: Below 22 degree C

Colour: Grey

Finish: Matt

Packing: 24 Ltrs.

Thinner / Cleaner: Thinner 870

Storage Life: Up to six months as long as the sealed containers are kept under cover in a dry place under

Resistance Guide

Chemical Resistance (with proper top coat)

Exposures	Splash and spillage	Mild Fumes / outdoor Resistance
Acids	Very Good	Excellent
Alkalis	Very Good	Excellent
Solvent	Excellent	Excellent
Salt	Excellent	Excellent
Water	Excellent	Excellent

Temperature Resistance:

Continuous: 400 degree C

Intermittent: 426 degree C

Weatherability : Excellent

Flexibility: Fair

Abrasion Resistance: Excellent
- Increases with age

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Surface Preparation

Remove grease, oil and other contaminants preferably by using Bison Degreasing Solvent. Blast clean to a minimum Sa 2 ½ Swedish Standards SIS 05 5900 with a surface profile not exceeding 50 microns. The surface should be clean and dry before application of Zinc Anode 304 MZ.

Application

Stir Part A and Part B thoroughly to uniform consistency. Mix the components in the recommended proportion with constant stirring - preferably with a mechanical stirrer. Continue stirring until the components are thoroughly mixed. Strain the mixture through a 80 mesh sieve. Allow the mixture to mature for 15-20 minutes before application. Stir again before use and from time to time during application. Conventional Spray: Add upto 5% Thinner 870 depending on conditions. Use any standard equipment at an atomizing pressure of 3..5-4.4 Kg/cm².

Airless spray: Apply preferably without thinning. Use any standard equipment having pump ratio 30:1. Tip size 0..38-0.48 mm. Tip pressure 110-160 Kg/cm²

Typical Painting Specifications

Surface 1st coat		2nd coat	3rd coat	4th coat
Steel	Zinc Anode 304 MZ	Epilux 4 HB MIO	Epilux 4 Enl or Epilux 155 HB or Epilux 89 Fsg	Epilux 4 Enl or Epilux 155 HB or Epilux 89 Fsg
-do-	-do-	Epilux 5 CTE or Epilux 555 CTE	Epilux 5 CTE or Epilux 555 CTE HB	
-do-	-do-	Epithane or Bergerthane Enl	Epithane or Bergerthane	
-do-	-do-	Lumeros HR/47 or Silicone Acrylic HR Ctg	Enl Lumeros HR/47 OR Silicone Acrylic HR Ctg.	

Overcoating of Zinc Anode 304 MZ

It must be fully cured and free from residual solvent before overcoating. This normally takes 10-12 hours but time may be extended under conditions of humidity below 80%.

While overcoating a mist coat should first applied to avoid bubbling which appears due to air entrapment.

Notes:

- 1 Use off the mixed paint within the stipulated pot life period . It cures by reaction with moisture and may be applied at high humidity provided the blasted surface itself is free from condensation and meets the requirement of Sa 2.5 Swedish Standard
- 2 Application equipment should be cleaned with Thinner 870 otherwise they are liable to be damaged. At lower relative humidity, drying and curing are likely to be extended.
- 3 Damaged areas can be touched up with Epilux 4 Zinc Rich Primer.

Health & Safety - Please refer to the separate safety data sheet available with detailed information.

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