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## INDUSTRIAL COATINGS

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### Zinc Rich Epoxy Primer, series 706176

#### Description and main features

Two pack zinc rich epoxy primer. Very high zinc content, featuring the best anti corrosive and adhesion properties. Compliant to SSPC Paint 20, type 2, level 1.

Fast drying, solvent resistant, it withstands severe atmospheric exposure. The product must be over coated if exposed to welding fumes, acid spillages or chemical agents.

**Recommended use:** as a primer on two-three coat paint systems on blasted steel surfaces and equipment under severe chemical and environmental exposure; it can be over coated by epoxies, two pack acrylics, vinyl epoxies, chlorinated rubbers.

#### Technical data

<b>Finish</b>	Flat
<b>Color</b>	Grey
<b>Specific gravity</b>	2,52 ± 0,05 kg/dm <sup>3</sup> at 23 °C, cured with 701488; 2,69 ± 0,05 kg/dm <sup>3</sup> at 23 °C, cured with 701455 according to ISO 2811-1 (*)
<b>Solid content</b>	<b>By weight</b> 82 ± 3% when cured with 701488; 87 ± 3% when cured with 701455 (*)
	<b>By volume</b> 50 ± 3% when cured with 701488; 64 ± 3% when cured with 701455 (*)
<b>VOC</b>	130 g/kg when cured with 701455 (*)
<b>Viscosity</b>	Brookfield on the base at 23 °C (spindle 5, 0.5 RPM) : > 300.000 mPas according to internal method MS 007 (*) (**)
<b>Drying time</b>	At 23 °C ,50% RH, good ventilation, DFT 70 µm, <b>Touch dry:</b> 4 h according to internal method MS 035 based on ISO 4622 <b>Hard dry:</b> 20 h according to internal method MS 036 based on ISO 4622 (*)
	<i>Drying times can vary depending on DFT and environmental conditions</i>

#### Mixing and thinning

<b>Mixing ratio</b>	<b>By weight:</b> 100:10 with 701488 100:5 with 701455 <b>By volume :</b> 2,8:1 with 701488 5,7:1 with 701455 <i>Mix carefully before and after the curing process</i>
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<b>Pot life</b>	> 8 h at 20 °C - <i>Data vary with temperature and thinning.</i>
<b>Thinning</b>	5 % with 900033 winter type 5 % with 906007 summer type/slow <i>Chose the thinner according to the environmental and application conditions in order to allow at least 5-10' drying time.</i>

### Application data

<b>Method</b>	Airless o air mix; it can also be applied by brush	
<b>Airless or air mix</b>	<b>Pump ratio</b>	30:1
	<b>Nozzle orifice</b>	015-017"
	<b>Nozzle pressure</b>	140-180 atm
	<i>Filters must fit the used nozzle.</i>	
<i>Indicative data; it is the user's responsibility to chose the right equipment.</i>		
<b>Suggested Primers</b>	None	
<b>Suggested intermediate</b>	Retron Acrilico series 773.000, Epoxy primer or intermediate series 706.000, 706.250,706.300 AR, 703.000 or 7073.000, Vinyl Epoxy primer series 704.000 or chlorinated rubber series 741.000.	
<b>Application conditions</b>	<p>A sandblasting to SA 2 ½ according to ISO 8501-1: 1988 is strongly recommended; mix carefully the quantity to be applied. Pick up the mixture from a can continuously stirred to prevent a quick settling of the zinc dust, due to its high specific gravity. Application suggested between 5°C and 35°C and at least 3°C above dew point. Substrate perfectly dry and clean, no rain nor fog. Temperatures lower than 5 °C can impair the film formation.</p> <p>The product can be over coated after 16 h from the application; no max over coating time. After a long time, a careful cleaning is needed before over coating. Over coating with alkyd paints is not recommended.</p> <p>Data vary with DFT and environmental conditions</p>	

### Recommended DFT

<b>Recommended DFT</b>	60-80 µm
<b>Theoretical consumption</b>	approx. 300-400 g/m <sup>2</sup> when cured with 701488 approx. 250-340 g/m <sup>2</sup> when cured with 701455 (*)
<b>Practical spreading rate</b>	30-40% lower than the theoretical, by airless application.
<b>Number of coats</b>	ONE



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### Specific tests

**Cross-cut test according to ISO 2409**  
≤ Gt 2

**Pull-off adhesion test according to ISO 4624**  
≥ 2 MPa

**Zinc content**  
≥ 85% dry. Compliant to SSPC Paint 20, type 2, level 1.

**Heat resistance**  
> 200 °C

**Electric conductivity**  
The paint film is conductive according to ASTM D149/IEC 60468

### Storage indications

Shelf life: 12 months (base only: 18 months), provided the cans are kept sealed and undamaged, into a cool and dry place with temperature between 5 and 35 °C.

(\* ) indicative value, depending on the color - (\*\* ) parameters subject to testing for each batch

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