

## PRODUCT DESCRIPTION

A zinc rich epoxy powder coating intended for use as a primer on new steel surfaces.

### Benefits

- Durability
- Chemical resistance
- Corrosion resistance
- Enhanced charging and handling characteristics
- Provides good flow and leveling over a wide range of film thickness

\*Due to degradation that occurs through prolonged exposure to direct sunlight, epoxies are recommended for interior applications.

## APPLICATION

### Pre-cleaning:

Clean all surfaces to be coated in accordance with SSPC-SP-1, Solvent Cleaning prior to additional surface preparation or coating application. Surface must be clean, dry and free of any dirt, dust, oil, and all other visible contaminants that could potentially interfere with adhesion of the coating.

### Surface preparation:

#### Atmospheric exposure: ISO 12944 C1-C3

Pretreatment solution: Pretreat surfaces to be primed using either a iron or zinc phosphate pretreatment solution, making sure to rinse completely to obtain a surface that is free of any visible contaminants such as grease, oil, dirt, weld smoke, etc.

#### Industrial/Marine Exposure: ISO 12944 C3-C5

Abrasive blast clean all surfaces to be coated in accordance with SSPC-SP-10 or ISO SA 2.5, surface profile 1.5 to 2.0 mils (37 to 50 microns)

### Powder Application Conditions

Cure Schedule	Temperature	Time
	400 °F (204 °C)	10 minutes

  

Film Build	Minimum Thickness	Maximum Thickness
	2.0 mils (50.8 µm)	3.0 mils (76.2 µm)

\*Other curing schedules may be used upon technical approval.

**Equipment**

Electrostatic application to room temperature substrate is recommended. Suitable for Corona charging equipment. Reduced voltages can improve coating film thickness uniformity. This product may be applied to warm substrate for increased film thickness.

**APPEARANCE**

**Color:** Dark Gray  
**Gloss:** Satin  
**Finish** Smooth

If the significant surface is too small or unsuitable for the gloss to be measured with the glossmeter, the gloss should be compared visually with the reference sample.

**POWDER PROPERTIES**

<b>Property</b>	<b>Result</b>
Specific Gravity (S.G)	2.59 +/- 0.05
Theoretical Coverage at 1 mil (25.4 µm)	74.5 ft. <sup>2</sup> /lb (15.3 m <sup>2</sup> /kg)

**Storage**

Keep in a dry cool area. Maximum temperature of 77°F (25 °C) and maximum relative humidity 60%. If stored longer than 12 months a quality test is recommended.

**CAUTION**

Adequate health and safety precautions should be observed during storage, handling, use and curing periods.

**READ MATERIAL SAFETY DATA SHEETS BEFORE USING THIS PRODUCT**

**PERFORMANCE**

The technical data provided below are typical for this product when applied as follows:

Substrate: Cold Rolled Steel  
Film thickness: 2.0 – 3.0 mils (50.8 – 76.2 µm)

Typical values when tested.

Property	Standard	Result
Gloss @ 60°	ASTM D523-14	15 - 20
Adhesion	ASTM D3359	5B
Impact Resistance	ASTM D2794-90	120 in-lbs
Pencil Hardness	ASTM D3363	>H

**DISCLAIMER**

The technical data and suggestions for use in this product data sheet are currently correct to the best of our knowledge, but are subject to change without notice. Because application and conditions vary, and are beyond our control, we are not responsible for results obtained in using this product, even when used as suggested. The user should conduct tests to determine the suitability of the product for the intended use under then existing conditions. Our liability for breach of warranty, strict liability in tort, negligence or otherwise is limited exclusively to replacement of the product or refund of its price. Under no circumstances are we liable for incidental or consequential damages.