Technical Data

ZINCTECT 1000 HA(S)

GENERIC TYPE
Pre-construction Primer

DESCRIPTION
Inorganic zinc rich shop primer for steel plates and shapes based on alkyl silicate binder and zinc powder

RECOMMENDED USE
Steel structure at marine or industrial severe corrosive environment

FEATURES
- No trouble in gas-cutting and welding
- Quick drying
- Excellent shop coat line applicability
- Excellent anti-corrosive performance
- Excellent resistance to weathering, resistance to oil and resistance to organic solvents and heat resistance

PHYSICAL PROPERTIES

<table>
<thead>
<tr>
<th>Colour</th>
<th>Grey</th>
</tr>
</thead>
<tbody>
<tr>
<td>Finish</td>
<td>Matt</td>
</tr>
<tr>
<td>Volume Solids</td>
<td>29 %</td>
</tr>
<tr>
<td>Typical Thickness</td>
<td>Dry : 17 microns / coat</td>
</tr>
<tr>
<td>Theoretical Coverage</td>
<td>16.7 m²/L at 17 microns DFT</td>
</tr>
<tr>
<td>Flash Point</td>
<td>10°C (Base)</td>
</tr>
<tr>
<td>Specific Gravity</td>
<td>1.3 g/cm³</td>
</tr>
<tr>
<td>VOC</td>
<td>572 g/L</td>
</tr>
<tr>
<td>Temperature Resistance</td>
<td>Non-continuous : 500°C, Continuous : 400°C</td>
</tr>
</tbody>
</table>

*Practical coverage varies depending on loss factors.
*These numerical values are subject to normal manufacturing tolerances, colours and testing variances.

SURFACE PREPARATION

- All surfaces to be coated should be completely clean, dry and free from contamination.
- Surface preparation method shall be in accordance with ISO 8504: 2000.
- Remove salt and other water-soluble contaminants by fresh water.
- Remove oil and grease with suitable detergent or solvent (SSPC-SP-1).
- Remove rust, mill scale and other loose material completely by abrasive blasting (ISO 8501-1:2007 Sa 2 1/2 or SSPC SP-10).

APPLICATION

Application Conditions
Ambient temperature shall be above 0°C and relative humidity shall be above 50%. Surface temperature shall be a minimum of 3°C above dew point. Adequate ventilation shall be provided in confined spaces to ensure proper drying.

Mixing
Stir each component with a power agitator well before mixing. Then power mix two components.

Mixing ratio
Liquid/Powder = 42.2/57.8 (by weight)

Induction Time
Not required

Application Method
Airless spray
Thinner : ZINCTECT 1000HA Thinner (0–20% by weight)
Nozzle pressure: Not less than 10MPa
Nozzle Tip : No.163-515~621

Brush
Thinner : ZINCTECT 1000HA Thinner (0–5% by weight)
Power mix thinner if required.

*Too much thinning results in sagging and slower cure.
Clean Up

Clean all the equipment with thinner immediately after use.

Pot Life

<table>
<thead>
<tr>
<th>Temperature</th>
<th>5 °C</th>
<th>20 °C</th>
<th>30 °C</th>
</tr>
</thead>
<tbody>
<tr>
<td>Time</td>
<td>5 hour(s)</td>
<td>24 hour(s)</td>
<td>24 hour(s)</td>
</tr>
</tbody>
</table>

*Use all mixed paint within pot life.

Drying Time

<table>
<thead>
<tr>
<th>Temperature</th>
<th>5 °C</th>
<th>20 °C</th>
<th>30 °C</th>
</tr>
</thead>
<tbody>
<tr>
<td>Surface dry</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>Touch dry</td>
<td>5 minute(s)</td>
<td>3 minute(s)</td>
<td>1 minute(s)</td>
</tr>
</tbody>
</table>

*Drying time may vary depending on film thickness, ventilation, humidity, undercoat paint condition etc.

Overcoating Interval

<table>
<thead>
<tr>
<th>Temperature</th>
<th>5 °C</th>
<th>20 °C</th>
<th>30 °C</th>
</tr>
</thead>
<tbody>
<tr>
<td>Minimum</td>
<td>24 hour(s)</td>
<td>24 hour(s)</td>
<td>24 hour(s)</td>
</tr>
<tr>
<td>Maximum</td>
<td>6 month(s)</td>
<td>6 month(s)</td>
<td>6 month(s)</td>
</tr>
</tbody>
</table>

*The overcoating intervals are based on overcoating with same or same type of paint.

SAFETY PRECAUTIONS

Detail information is given on Safety Data Sheet (SDS). Avoid inhalation of spray mist or vapour. Avoid skin and eye contact. Paint contacted with skin should be immediately removed with water and/or suitable cleanser. Eyes should be flushed with water and seek immediate medical attention. Since this product contains flammable solvents, keep away from sparks and open flames. Application and handling of this product should be in compliance with relevant national regulations.

STORAGE

Store in dry, cool condition and away from sources of heat and ignition. Containers must be kept tightly closed. Store conditions shall be in accordance with national regulations.

SHELF LIFE

6 months from date of production.

GENERAL REMARKS

- This product is moisture sensitive and store in cool and dry indoor area.
- Zinc powder in mixed paint tends to sink due to heavy specific gravity. Stir slowly during application to prevent zinc powder settling.
- Contamination of other thinner may spoil paint film formation. Wash spray equipment sufficiently with ZINCTECT 1000HA THINNER before using.
- Cracking may occur when total thickness is more than 50 microns by short interval (within 7 days) application.
- Thickness shall be controlled from 15 to 25 microns for ideal cutting welding work.
- Oil and alkyd paint is not suitable for overcoating.
- Wear protection mask and supply good ventilation when cutting and welding work.

*If any inquiries, please consult Kansai Paint representative for further information.

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