Technical Data

ZINCTECT 1500 QD–85

**GENERIC TYPE**
Zinc Rich Paint

**DESCRIPTION**
Inorganic zinc rich paint based on alkyl silicate resin and zinc powder

**RECOMMENDED USE**
Steel structure at marine or industrial severe corrosive environment

**FEATURES**
- Excellent anti-corrosive performance
- Excellent water, sea water, oil and organic solvent resistance
- Excellent heat resistance up to 400°C continuously.
- High build coating and 75 μ per coat is achieved.
- Conforms to SSPC paint 20 Level 1

Product ID No.(PN) Liquid: PN103, Powder: PN104

**PHYSICAL PROPERTIES**
- Colour: Grey
- Finish: Matt
- Volume Solids: 57 %
- Typical Thickness: Dry : 75 microns / coat
- Theoretical Coverage: 7.6 ml/L at 75 microns DFT
- *Practical coverage vary depending on loss factors.
- Flash Point: 20°C (Liquid)
- Specific Gravity: 2.54 g/cm³
- VOC: 373 g/L
- Temperature Resistance: Non-continuous : 500°C, Continuous : 400°C

*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).
- Ambient temperature shall be above 5°C and relative humidity shall be below 85%. Surface temperature shall be a minimum of 3°C above dew point.
- Adequate ventilation shall be provided in confined spaces to ensure proper drying.

**APPLICATION**

**Application Conditions**
Ambient temperature shall be above 5°C and relative humidity shall be below 85%. 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 power agitator well before mixing. Then power mix two components.

**Mixing ratio**
Liquid/Powder = 1 / 2 (by weight)

**Induction Time**
Not required

**Application Method**
Airless spray
- Thinner : SD Zinc 1500 Thinner (0–10% by weight)
- Nozzle pressure: Not less than 6Mpa
- Nozzle Tip : No.163-519~621
- Air spray - small area. Thinner : SD Zinc 1500 Thinner (0–20% by weight)
- Brush suitable - small area only. Thinner : SD Zinc 1500 Thinner (0–5% by weight)
- Rollar not recommended

*Too much thinning results 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>4 hour(s)</td>
<td>3 hour(s)</td>
<td>3 hour(s)</td>
<td></td>
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</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>60 minute(s)</td>
<td>15 minute(s)</td>
<td>15 minute(s)</td>
</tr>
<tr>
<td>Touch dry</td>
<td>90 minute(s)</td>
<td>30 minute(s)</td>
<td>30 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>18 hour(s)</td>
<td>4 hour(s)</td>
<td>4 hour(s)</td>
</tr>
<tr>
<td>Maximum</td>
<td>- month(s)</td>
<td>- month(s)</td>
<td>- month(s)</td>
</tr>
</tbody>
</table>

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

Typical undercoat
ZINCTECT 1000

Typical topcoat
EPOTECT HB(M), EPOTECT HB(M)QD, EPOTECT AL
Prior to overcoating, verify a value of 4 via ASTM D4752 MEK rub test.

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 (store in cool and dry indoor area)

GENERAL REMARKS
- Mixed paint shall be screened with 60–100 mesh and remove foreign material and lump before application.
- Zinc powder in mixed paint tends to sink due to heavy specific gravity. Stir slowly during application to prevent zinc powder settling.
- One coat spray application is standard method. In case of brush application, two coats are required. Coating interval between the two coats shall be 30 minutes to two hours.
- This product is moisture cure type and although its surface can dry by solvent evaporation, true curing progress by chemical reaction with moisture gradually. In order to accelerate the curing, sprinkle water to surrounding environment.
- Sagging, cracking or peeling may occur when over thickness by one coat 150–200 μ.
- The minimum overcoating interval is dependant upon the relative humidity during cure.
- It is recommended that prior to overcoating a solvent rub test to ASTM D4752 should be undertaken. A value of 4 indicates a satisfactory degree of cure for overcoating purposes.
- For high temperature systems, the minimum overcoating interval at relative humidity above 51% is 40 hours.

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

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