EPODUX ZINC 52-80

Zinc-Rich Epoxy

DEFINITION

Epoxy primer containing zinc metal (content in the dry coat: min 80%) and reticulated with a polyamide hardener.

INTENDED USES

Protection of steel structures such as :
- Metallic frame structures,
- Emerged and semi immersed parts of sea structures,
- Pipelines,
- Containers, ?

EPODUX ZINC 52-80 may be used for small repairs on galvanised steel

PRINCIPAL CARACTERISTICS

- Excellent adhesion on Sa 3 but also Sa 2 1/2 blasted steel.
- Long therme protection of metallic structures subjected to an aggressive environment, such as maritime or industrial.

CERTIFICATIONS / APPROVALS

ACQPA : ACQPA 26541
Used in the following certified systems :
C3ANV1283, C4ANV1282, C3ANV1529, C4ANV1528.

TECHNICAL DATA

Gloss level	: Mat
Colours	: Metallic grey
Number of components	: 2
Mix ratio, by weight	: 93 / 7
Mix ratio, by volume	: 80,4 / 19,6
Specific gravity	: 2,50 +/- 0,10
Solids volume	: 52,0 +/-3%
Solids weight	: 83,0 +/-2%
Typical thickness (dry)	: 15 µm mini / 70 µm maxi
Typical thickness (wet)	: 30 µm mini / 140 µm maxi
Theoretical spreading rate	: 13 m²/l for 40 µm dry

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INSTRUCTIONS

SURFACE PREPARATION

New steel « heavy duty use »
Abrasive blast cleaning at Sa 3 according to ISO 8501-1: 2007
Roughness profile: Mid G according to ISO 8503-2 (Ra 10-12,5 µm)
Mechanical blasting by means of scraping/brushing to achieve a degree St3 is accepted in certain cases (e.g.: small repairs). Please contact our Technical Department.

APPLICATION

Mixing : The product is supplied in pre-measured kit form. Pour the hardener part into the base tub and mix, taking care not to incorporate air. The mixing temperature should be at least 10°C. If not, it is necessary to add thinner to get the application viscosity. N.B. excess thinner increases the risk of sagging.

Induction time : 10 minutes

Working pot life :

Temperature	Time
10°C	12 hours
20°C	8 hours
30°C	4 hours

Substrate temperature : Between +5°C and +40°C and at least 3°C higher than the dew point in order to eliminate any risk of condensation.

Weather conditions : The temperature should be between 5°C and 40°C
The relative humidity should be between 0% and 85%

AIRLESS SPRAY

Thinner : 67-232 v02
Dilution : 0 to 15 %
Nozzle : 0.011-0.015
Pressure at nozzle : 150-200 bars
Report pump Min: 45 / 1

AIR SPRAY

Thinner : 67-232 v02
Dilution : 0 to 15 %
Nozzle : depending on equipment
Pressure at nozzle : 3-5 bars

BRUSH

Thinner : 67-232 v02
Dilution : 0 to 10 %
Only recommended on small surfaces

ROLLER

Thinner : 67-232 v02
Dilution : 0 to 10 %
Only recommended on small surfaces

CLEANING SOLVENT : 67-232 v02

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CURING TIME

	Drying time		Overcoating interval	
Temperature	Touch dry	Hard dry	Minimum	Maximum
10°C	1 hour	2 hours	2 hours	unlimited*
20°C	45 minutes	1 hour 30	1 hour 30	unlimited*
30°C	25 minutes	45 minutes	0 hour 45	unlimited*

* However, check the absence of zinc salt formation.

COMPATIBILITY

Previous coat(s)	Please contact our Technical Department.
Subsequent coat(s)	EPODUX PRIMER 61-134 v01, EPODUX HV-PC, EPODUX BR 100, CHIMICOTE, FERROCOTE, PRIMODUX H, PRIMODUX SR 74-31, PRIMODUX EV... Warning : before using EPODUX ZINC 52-80 check for the absence of zinc salts.

REGULATORY SPECIFICATIONS

AFNOR RATING	AFNOR NFT 36 005 rating Family I Class 6b
VOC (Directive 2004/42/EC)	EU limit value for this product (cat. A/j) : 500 g/l (2010) This product contains max 310 g/l VOC

HEALTH AND SAFETY

Flash point	BASE : between 23°C and 55°C HARDENER : between 23°C and 55°C
Transport and labelling	Refer to the safety data sheet established as per applicable European directives
Shelf life	6 months in original full, sealed packaging. Store in a cool, ventilated place.
Precautions	Refer to the current material safety data sheet

PACKAGING

KIT	BASE	HARDENER
10 l	8,04 l	1,96 l

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