

NATURE AND USE

Two-component inorganic zinc based primer with ethyl silicate and high content of zinc dust. Designed as primer for works to be protected while operating in severe environmental and temperature conditions, this product provides a long-lasting and performing active protection of galvanic type. The product is of wide versatility, and can be over-coated after a long interval. It can be applied in workshop as well as on field.

The product is part of certified coating system C5-I durability H according to ISO 12944
ref. Paint system A5I-05

Product Snam qualified for External coating systems for structures exposed to the atmosphere.

TECHNICAL DATA

Specific Gravity A+B:	kg/l	2,55 ± 0,10 @ +20°C
Solids by Weight:	%	86 ± 2 % A+B
Solids by Volume:	%	60 ± 2 % A+B
Mixing Ratio by Weight:	27 parts of Base / 73 parts of Hardener	
Mixing Ratio by Volume:	74 part of Base / 26 parts of Hardener	
**Pot life @ +20°C:	≥ ~ 6 hours	
Temperature Resistance In continuous service In Air – Dry conditions	°C	+350/+400°C
Colour/Appearance:	Matt Grey	



SUBSTRATE PREPARATION

Steel: Degrease the substrate, make free from oils, salt residuals and all type of contaminants. Sandblast to white metal SA3 according to ISO 8501/1. Roughness profile 50/70 µm. Remove all dust Very accurately to avoid adhesion failure.

PRODUCT PREPARATION

Mechanically mix the "Vehicle" component, then slowly add the zinc powder, keeping under constant Agitation. Continue to agitate until all lumps disappear and then filter using a 30 mesh filter. During the spray keep the application container under continuous mechanical agitation to avoid Zinc deposits. In case of interruption during the spraying for about 10 - 15 minutes, proceed to recycle the product left in the pipes. Do not leave the mix into the pipes during extended periods of no work.

** The "POT LIFE" time of two components products (time within which it is possible to apply the paint mix of Base and Hardener), is exponentially dropped by the increase of product temperature.

Note: The use of a mix of paint (Base + Hardener) over the POT LIFE time is irreparably compromising all the properties of the coating film.**

APPLICATION DETAILS

Application method:	Standard Airless Spray with compression ratio 30:1 minimum Conventional spray (non-optimal method)
Standard airless spray:	Nozzle Ø 0,018-0,021 inches Compression ratio 30:1 Air Pressure Exit 120-140 Kg/sqcm

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The content of the present technical data sheet is the most complete currently available, based on practical experience and given in good faith. Should any change be necessary, the present data sheet will be updated without prior notice. The applying conditions of use differ according to environmental conditions and subjective application factors outside the control of the Company. The user shall determine the suitability of the product for the intended use under his own risk and responsibility. No warranty is impressed or implied. The Company refuses all liability not directly related with defects of the product or consequent to deviations from written instructions.



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Company with quality management system UNI EN ISO 9001:2015 certified

Thinning:	Not necessary – The product is ready to use
Cleaning:	Thinner 4427/E
Hardening @ +25°C- 50%UR:	Touch dry 30 minutes – 1 hour Dry to handle 3 – 4 hours
Note	High thicknesses, poor ventilation or low ambient temperatures, will require long polymerization intervals with possible solvent entrapments and consequent early failure of the applied product. Also an ambient relative Humidity lower than 50% will require extra polymerization intervals : on this subject it will be possible, after 2-4 hours at +20/+25°C to accelerate the hydrolysis wetting often and abundantly with fresh water the coated substrates.
Overcoating Interval @ +20°C- 50%UR:	24 – 48 hours Minimum, unless the coating has reached the curing grade 4 or 5 according to ASTM D 4752 Maximum unlimited time (*)
(*) NB:	Before the overcoating of the substrates after time, be sure the surfaces are free from contaminants and free from Zinc salts. The surfaces therefore must be treated with solvents or water with detergents to remove oils, greases, etc.. The Zinc Salts will be removed with high-pressure washing.
Overcoatability:	Possible with Polyurethane, epoxy, acrylic, silicone and phenol based enamels. After the inorganic zinc primer it is necessary to apply one coat of intermediate or one coat Of epoxy or vinyl-epoxy product as tie-coat before the finishing. The suitability to the overcoating of the product can be checked referring to the method described in ASTM D 4752 (rub-test with MEK).
Application Ambient Temperature:	Between +5°C and +35°C
Suggested Temperature of the product:	+20 ÷ +30°C
Substrate Temperature:	+5 / +40°C always at least +3/5°C above dew point
Relative Humidity:	50 – 95 %
Typical dry Thickness (DFT):	75 µm dry (DFT) 50 µm dry (DFT) Min. - 100 µm dry (DFT) Max.
Theoretical spreading rate:	sqm/l 8,0 ; 3,1 sqm/Kg(at the suggested thickness)
More info by writing to sales@industri brunostoppa nipa nts.com or by calling +39 030 9745116	

HANDLING STORAGE AND SAFETY PRECAUTIONS

Warning: All handling and/or use activities of the material and its components must strictly refer to the given indications in the Safety Data Sheet (Base and Hardener). The following advices are stated by common sense and in good faith, they are uncompleted and do not substitute the content of each specific safety data sheet of the product.

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Handling: The material must be used only by professional and qualified applicators suitably trained. All the operations involving the use of the product, must be carried on in compliance with all the relevant National Health, Safety & Environmental standards and regulations.

Precautions: When the product is used in enclosed areas (rooms, containers, vessels, etc.) it is imperative to use adequate means providing the necessary air circulation, to be granted during the whole application and coating polymerization time, also to avoid conditions open to potential explosion danger.

All electrical installations must always be grounded. Where explosion hazards exist, the workmen should be required to use only non-ferrous tools and wear conductive non-sparking shoes and clothing. Explosion and flame-proof equipment too are required.

Storage and transport: Keep far from flames, sparks or heat sources. Do not leave exposed under direct solar action. Store under shelter in original unopened packaging, in cool, dry and ventilated areas, at temperatures between +5°C and +35°C.

Shelf life:

Base 6 months in the suggested storage conditions (original unopened packaging)

Hardener 12 months in the suggested storage conditions (original unopened packaging)

N.B.: **Product for professional use only**
and exclusively for the uses not regulated under CE Directive 2004/42/CE.

Refer to Material Safety Data Sheet



Access catalogues, data sheets and company presentations