

STOPCOAT 50

Zinc-rich one-component epoxy primer

NATURE AND USE

Stopcoat 50 is a one-component Zinc-rich primer based on Ester-Epoxy resin with very high content of zinc dust in the dry film. Studied as primer whose characteristic is an optimum corrosion resistance, it is suitable to be used in many corrosion protection systems (epoxy, polyurethane, vinyl, chlorinated rubber, alkyl types etc.) operating in most severe ambient exercise conditions.

Suitable to protect steel substrates sandblasted at SA 2.5- SA 3 degree (refer to suggested roughness profiles in "Substrate preparation") is also suitable for small touch-up painting (A< 0,15 m² each) after preparation at the degree St 3- ISO 8501/1.

Thanks to its content of Zinc dust it offers a very performing corrosion protection on pipes, wharfs, steel marine structures etc. (cathodic protection).

Avoid applications in critical humidity or temperatures conditions and do not apply on substrates not correctly prepared.

TECHNICAL DATA



Specific Gravity:	Kg/l	2,55 ± 0,10 @ +20°C
Solids by Weight:	%	84 ± 2%
Solids by Volume:	%	53 ± 2%
Temperature resistance		Constant: + 120°C
In Air service – Dry conditions:	°C	Occasional (Picks) + 150°C
Colour:		Grey zinc
Appearance of the applied product:		Matt

SUBSTRATE PREPARATION

Steel substrates: The steel surface must be fully cleaned to avoid any traces of dirt or salt residuals.

The substrate must be free from deposits of oil, grease and any other contaminant. Blast cleaning at minimum SA 2,5 according to ISO 8501-1, medium roughness profile of 40 – 60 µm Rz DIN (cut-off 2,5 mm) or (for touch-up painting A< 0,15 m² each) brushing grade St3 – ISO 8501/1.

PRODUCT PREPARATION

Mix the product in the original can. Thin as necessary stirring the mix to reach complete homogenization. Let the mix rest 5 minutes before starting the application of the product.

APPLICATION DETAILS

Application method:	Standard Airless Spray with compression ratio 30:1 minimum Conventional Spray Brush only for touch-up painting
Thinning:	5-15 % Max. Thinner SINT400D according to the application system
Cleaning:	Thinner SINT400D
Drying @ +25°C:	Dust dry ≤60 minutes Touch dry ≤ 8 hours Through dry ≤24 hours
Overcoating interval @ +20°C:	24 hours Min.
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:	≤ 85%

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Thickness:	40 µm dry (DFT) Min. 70 µm dry (DFT) Max.
Typical dry film thickness:	50 µm DFT per coat (wet about 100 µm(WFT))
Theoretical spreading rate:	sqm/kg 4,50 – 4,5 at the thickness of 50 µm dry (DFT)

HANDLING STORAGE AND SAFETY PRECAUTIONS

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

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 inside enclosed areas (i.e rooms, containers, vessels) it is imperative to provide the necessary air circulation using adequate means and must be granted during the whole time required by application and coating polymerization, 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 imperative.

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

Shelf life: 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

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