

# 751 EPOXY ZINC PRIMER

**Description**

Two component zinc rich epoxy primer, hardened with polyamide. It presents high concentration in metallic zinc dust which acts as a pigment that satisfies the high standards for the protection from electrocathodic corrosion of iron and steel surfaces (cold galvanization). It contains at least 85% per weight zinc in the dry film. It is recommended for every area where strong anticorrosive protection is needed like chemical plants, energy production plants, shipyards and harbor equipment.

**Technical Information**

Shade Grey of metallic zinc  
 Gloss Mat  
 Specific Weight (A) 2,90 kg/lit, (B) 0,95 kg/lit  
 (A+B) 2,50 (±0,05) kg/lit (EN ISO 2811)  
 Solids (A+B) 88% (±2) per weight (EN ISO 3251, non-volatile)  
 60% (±2) by volume  
 Theoretical Coverage 12 m<sup>2</sup>/lit (50 µm), 4,70 m<sup>2</sup>/kg (50µm)  
 The actual spreading rate may be less, depending on the application technique, the conditions and the surface to be covered.  
 Mixing ratio A:B-10:1 by weight, (A:B-3,3:1 by volume)  
 Temperature Resistance Up to 140 °C (service temperature, dry exposure)  
 Pot Life 6 hr (25°C)  
 VOC (A + B) 378 g /lt  
 Ready to use maximum (+10% thinner): 495 g /lt  
 limits EE 2010: 500 g / lt  
 SUBCATEGORY: j - Special two-component coatings, primer coat for ferrous substrates, Type SB

**Drying Time**  
(50µm, 60%RH)  
(5°C)  
(15°C)  
(25°C)  
(35°C)

Pot life	Touch dry	Dry	Dry to recoat (Min)	Dry to recoat (Max)	Full Dry
8 hr	2 hr	12 hr	10 hr	No limit	20 days
7 hr	60 min	8 hr	6 hr	No limit	8 days
6 hr	45 min	6 hr	4½ hr	No limit	5 days
5 hr	30 min	4 hr	3 hr	No limit	3 days

*The above pot lifetimes refer to material without addition of thinner. After adding thinner, a small increase in the pot life is expected. The above times are indicative and depend on the thinning percentage, substrate conditions, film thickness, weather conditions (relative humidity, wind, sunshine).*

**Surface Preparation**

All applications on steel, including welding, cut with flame and smoothing, must be terminated before the preparation of the surface. Cleaning of the surface from dust and other materials like oil, grease etc. using special detergent and fresh water under high pressure. The alkaline remnants of the recent welding joints as well as the traces of soap, must be removed with fresh water and rubbing. For better results, sandblast is recommended at least Sa 2 ½, ISO 8501-1.

**Application**

A component, B component and the thinner are mixed together. It is important to stir both around the walls and at the bottom of the mixing container, so the hardener is evenly distributed. Applied 10 minutes after mixing.

It is applied with:

AIRLESS after 5% thinning with thinner (nozzle 0,43-0,58mm (0,017-0,023in)).

AIR PISTOL (diameter: 2,0-2,2 mm, pressure: 3-5 bar) after thinning 5% with thinner.

Suggested film thickness 40-75 µm (film thickness higher than 100-120 µm can cause mud cracking)

Application temperature	5-35°C
Substrate temperature	5-35°C
Dew point	The substrate temperature must be at least 3°C higher than the dew point.
Relative humidity	<80%
Suggested thinners	1131-1120 The choice of suitable thinner depends on the application method, the temperature and the humidity conditions. For the suitable choice, please contact with the technical department of our company.

The above conditions must be followed both during the application process and throughout the drying.

It should not be applied when rain is expected (at least 24h). It is necessary to protect the primer from the moisture (>80%) and the rain for about 24 hours after the application.

The surface where the product will be applied on must be clean and dry. All damaged surfaces due to transportation or use must be repaired.

Final coating is done with any topcoat system, one or two components.

## Storage

Up to 12 months in a dry and cool place. (5-35°C) protected from direct solar radiation and adverse weather conditions, stored in the original unopened containers.

## Safety

Please consult the Material Safety Data Sheet. Available upon request.

**This Technical Data Sheet replaces and cancels every previously issued. The information, instructions, recommendations and specifications mentioned in this data sheet, represent the results and experience obtained from testing under controlled or specially adapted conditions. The accuracy and relevance of these results to the actual conditions, in which you apply the product, must be determined and depend only on the purchaser and/or applicator.**