Scope
A two pack solvent based inorganic zinc silicate primer for protection of steel against severe corrosive environment.

It provides outstanding cathodic protection and forms a tough abrasion resistant film. It is however, not recommended for contacts with strong acids or alkalis of pH below 5 or exceeding 10.

The coatings attains water resistance within 30 minutes of application and is unaffected by rain, condensation or dew.

Product Data
Type: Two pack self cured
Composition: Ethyl Silicate / Metallic Zinc
Mixing Ratio: Part A & Part B as per supply packs [4.128:1]
Pot Life: 4-6 hours
Application: conventional and airless spray. Brush for small areas.
Recommended DFT: 65-75 microns per coat
Corresponding WFT: 108-125 Microns per coat
Theoretical Spreading Rate: 8.0 -9.2 Sq. Mtr/Ltr
Drying time:
TOUCH: 30 minutes
HANDLE: 2-4 hours
HARD: Overnight
Curing Time: 6-7 days
Overcoating Interval: Mn: Overnight Max: Indefinite
Flash Point: Below 22 degree C
Colours: Grey
Finish: Matt
Packing: 20 Ltrs. [16.1 ltrs & 3.9 ltrs]
Thinner / Cleaner: Thinner 870
Storage Life: Up to six months as long as the sealed containers are kept under cover in a dry place under normal temperature conditions.

Resistance Guide
Chemical Resistance (with proper top coat)
Exposures: Splash and spillage outdoor
Resistance
Acids: Very Good
Alkalis: Very Good
Solvent: Excellent
Salt: Excellent
Water: Excellent

Temperature Resistance:
Continuous: 400 degree C
Intermittent: 426 degree C

Weatherability: Excellent
Flexibility: Fair
- Increases with age

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Uses
Recommended for use on steel structures, bridges, exterior of storage tanks, bulk handling equipments pipelines, etc.
Surface Preparation
Remove grease, oil and other contaminants preferably by using Bison Degreasing Solvent. Blast clean to a minimum Sa 2 ½ Swedish Standards SIS 05 5900 with a surface profile not exceeding 50 microns. The surface should be clean and dry before application of Zinc Anode 304 MZ.

Application
Stir Part A and Part B thoroughly to uniform consistency. Mix the components in the recommended proportion with constant stirring - preferably with a mechanical stirrer. Continue stirring until the components are thoroughly mixed. Strain the mixture through a 80 mesh sieve. Allow the mixture to mature for 15-20 minutes before application. Stir again before use and from time to time during application.

Conventional Spray: Add upto 5% Thinner 870 depending on conditions. Use any standard equipment at an atomizing pressure of 3.5-4.4 Kg/cm2.

Airless spray: Apply preferably without thinning. Use any standard equipment having pump ratio 30:1. Tip size 0.38-0.48 mm. Tip pressure 110-160 Kg/cm2

Typical Painting Specifications

<table>
<thead>
<tr>
<th>Surface</th>
<th>1st coat</th>
<th>2nd coat</th>
<th>3rd coat</th>
<th>4th coat</th>
</tr>
</thead>
<tbody>
<tr>
<td>Steel</td>
<td>Zinc Anode 304 MZ</td>
<td>Epilux 4 HB MIO</td>
<td>Epilux 4 Enl or Epilux 155 HB 155 HB or Epilux 89 HB</td>
<td>Epilux 4 Enl or Epilux 155 HB or Epilux 89 HB</td>
</tr>
<tr>
<td>-do-</td>
<td>-do-</td>
<td>Epilux 5 CTE or Epilux 555 CTE</td>
<td>Epilux 5 CTE or Epilux 555 CTE HB</td>
<td>-do- -do-</td>
</tr>
<tr>
<td>-do-</td>
<td>-do-</td>
<td>Bergerthane</td>
<td>Bergerthane</td>
<td>-do- -do-</td>
</tr>
<tr>
<td>-do-</td>
<td>-do-</td>
<td>Lumeros HR/47 or Silicone Acrylic HR Ctg</td>
<td>Lumeros HR/47 OR Silicone Acrylic HR Ctg</td>
<td>-do- -do-</td>
</tr>
</tbody>
</table>

Overcoating of Zinc Anode 304 MZ

- It must be fully cured and free from residual solvent before overcoating. This normally takes 10-12 hours but time may be extended under conditions of humidity below 80%.
- While overcoating a mist coat should first applied to avoid bubbling which appears due to air entrapment.

Notes:
1. Use off the mixed paint within the stipulated pot life period.
2. It cures by reaction with moisture and may be applied at high humidity provided the blasted surface itself is free from condensation and meets the requirement of Sa 2.5 Swedish Standard.
3. Application equipment should be cleaned with Thinner 870 otherwise they are liable to be damaged.
4. At lower relative humidity below 50%, curing is likely to be severely retarded. Contact the Technical personnel for special application tips.
5. Damaged areas can be touched up with Epilux 4 Zinc Rich Primer.

Health & Safety - Please refer to the separate - Safety data sheet available with detailed information.

Disclaimer
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Data Sheet No.099 / Rev 02
Issue Date: Aug 2001