

# PEACOZINC S

Product Code: 6519

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## PRODUCT INTRODUCTION

- One component Zinc Epoxy Primer
- can be applied and dries at temperature down to  $-10^{\circ}\text{C}$  provided that the surface is free from moisture or ice
- designed for repair of Zinc rich two component epoxy primers, Zinc Silicate primer and hot dipped galvanized substrate
- can be used as a recondition for aged derusted galvanized steel
- good anticorrosive properties; the dry film contain 90% Zinc by weigh
- dry heat resistance  $125^{\circ}\text{C}$  with peaks up to  $175^{\circ}\text{C}$
- very good flow for a Zinc rich primer
- good adhesion on cold rolled steel
- Contains not less than 85% metal Zinc and conforms to BS4652:1995

## PHYSICAL PROPERTIES

Colours and gloss	gray - flat
Mass density	approx. $2.5\text{g/cm}^3$
Solids content (by volume)	approx. 76% by volume
VOC	<250 g/litre
Recommended dry film thickness	35-50 $\mu\text{m}$
Theoretical spreading rate	21.7 $\text{m}^2/\text{l}$ for 35 $\mu\text{m}$ 15.2 $\text{m}^2/\text{l}$ for 50 $\mu\text{m}$
Touch dry after	30 mins. at $10^{\circ}\text{C}$ , 5 mins. at $15^{\circ}\text{C}$ , 4 mins. at $20^{\circ}\text{C}$
Overcoating interval	min. 2 hours max. several months
Curing time	7 days
Shelf life (cool and dry place)	at least 12 months
Flash point	$42^{\circ}\text{C}$

## APPLICATION CONDITIONS AND TEMPERATURE

- Steel; blast cleaned to ISO-Sa2½
- Aged hot-dip galvanized steel with rusty spots; thoroughly derusted to grade ISO-St3 or ISO-Sa2.5
- Zinc-rich epoxy and Zinc Silicate; dry and free from any contamination
- Substrate temperature should be at least  $3^{\circ}\text{C}$  above dew point

## INSTRUCTION FOR USE

	AIR SPRAY	AIRLESS SPRAY
Recommended thinner	Thinner 066 (flash point $26^{\circ}\text{C}$ )	Thinner 066 (flash point $26^{\circ}\text{C}$ )
Volume of thinner	20-25%	<0-10%
Nozzle orifice	1.5-3 mm	0.43 mm
Nozzle pressure	0.2-0.310-15MPa (approx. 2-3 at 28-42 psi)	10-15MPa (Approx. 100-150 at; 43-57 psi)

## BRUSH AND ROLLER

Recommended thinner	Thinner 066 (flash point $26^{\circ}\text{C}$ )
Volume of thinner	0-3%

## CLEANING SOLVENT

Thinner 068 (flash point  $30^{\circ}\text{C}$ )

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## OVERCOATING TABLE

substrate temperature	10 <sup>0</sup> C	20 <sup>0</sup> C	30 <sup>0</sup> C	40 <sup>0</sup> C
minimum interval	6 hours	4 hours	3 hours	2 hours
maximum interval	several months without Zinc salt contamination			

- Zinc rich primers can form Zinc salts on the surface; preferable they should not be weathered for long periods before over coating
- an interval of several months can be allowed, under clean interior exposure conditions
- in clean exterior conditions a maximum interval of 14 days can be tolerates, but in industrial or marine condition this interval should be reduced to the practical minimum
- before over coating visible surface contamination must be removed by high pressure water cleaning, sandwiching, sweep blasting or mechanical cleaning
- when a long over coating interval is required, it is recommended to overcoat PeacoZinc S as soon as possible with a specified sealer coat