



ZINKY-10 INORGANIC ZINC SHOP PRIMER

TECHNICAL DATA SHEET

PRODUCT DESCRIPTION

Zinky-10 Inorganic Zinc Shop Primer is a two-pack, fast-drying, solvent-based coating composed of ethyl silicate and zinc dust. The type of zinc dust used complies with ASTM D 520 (Type II).

INTENDED USE

It is designed for use as a temporary primer on blast cleaned steel surface by automatic and manual spray to protect steel during production, storage and transport. Suitable for welding and gas cutting.

GENERAL PROPERTIES

| | |
|--------------------------|---------------------------------------|
| Colour | : Grey |
| Gloss Level | : Matt |
| Volume Solids, % | : 32 ± 2 % |
| Specific Gravity | : 1.30 kg/l (Mixed) |
| Flash point | : Base: 12°C Hardener: 12°C Mix: 12°C |
| VOC | : 584 g/L (EPA Method 24) |
| Typical Thickness | : 13 µm dry film : 40 µm wet film |

SURFACE PREPARATION

All surfaces should be clean dry, and free from contamination. The surface should be assessed and treated in accordance with ISO 8504. Oil or grease should be removed in accordance with SSPC-SP1 solvent cleaning.

Abrasive Blast Cleaning

Abrasive blast cleaning to Sa 2½ (ISO 8501-1:2007). If oxidation has occurred between the blasting and application of this product, the surface should be re-blasted to the specified visual standard. Surface defect revealed by the blast cleaning process should be ground, filled or treated in the appropriate manner.

Damaged Area

Damaged area should be prepared with abrasive blast cleaning to Sa 2½ (ISO 8501-1:2007). After the surface preparation, repair the damaged area using recommended zinc epoxy primer or Zinky-10 (Zinky-10 is only for small areas or touch ups)

Zinky-10 Inorganic Zinc Shop Primer should be applied over a surface that is dry and free from dirt, grease, oil and other contaminants and must be applied within the overcoating intervals specified (refer to application section for details).

Other Surfaces

The coating should not be used on the other substrates. Please contact your local Nippon Paint office for more information.



ZINKY-10 INORGANIC ZINC SHOP PRIMER

TECHNICAL DATA SHEET

CONDITION DURING APPLICATION

Avoid paint application when the temperature is below 5°C and above 45°C, or humidity is below 50%. Increase the humidity by spraying water when humidity is below 50%. To achieve the best film performance, humidity should be kept above 65%.

APPLICATION GUIDE

| | |
|-----------------------------|--|
| Mixing Ratio | : Base : Hardener = 1 : 1.8 (by volume) |
| | Base and hardener should be mixed thoroughly before use. |
| | After that, hardener should be added to base and be agitated with mechanical agitator. |
| | Mixed paint should be filtered before apply and should be agitated during application |
| Pot Life | : 25°C 6 hours |
| Theoretical Coverage | : 25 m ² /litre at 13 µm DFT |
| Thinner | : Zinky-1000 Thinner |

APPLICATION METHOD

Conventional Air and airless spray are recommended for application. Brush and roller are recommended for stripe coating and small areas. Care must be taken to achieve the specified dry film thickness. Avoid mud cracking.

APPLICATION DETAILS

| | | |
|--------------------------|-------------------------|-------------------------------|
| Airless Spray | : Tip Size | : 0.015" – 0.017" |
| | Pressure at nozzle | : 50 - 100 kg/cm ² |
| Typical Thickness | : 13 µm dry film | |
| | : 40 µm wet film | |
| Drying Time | : Substrate Temperature | : 25°C 40°C |
| | Surface Dry | : 2 mins 2 mins |
| | Through Dry | : 3 mins 3 mins |
| | Cured * | : 3 days 3 days |
| | Dry to recoat (min)* | : 24 hrs 24 hrs |

Remarks: All zinc salts should be removed prior to overcoating

* Depends on humidity conditions

The given data must be considered as guidelines only. The actual drying time/times before recoating may be shorter or longer, depending on film thickness, ventilation, humidity, underlying paint system, requirement for early



ZINKY-10 INORGANIC ZINC SHOP PRIMER

TECHNICAL DATA SHEET

handling and mechanical strength etc. A complete system can be described on a system sheet, where all parameters and special conditions could be included.

RECOMMENDED PAINTING SYSTEM

The following coating system is recommended for Zinky-10:

On Sa 2½, 1 coat x 13 µm dry film thickness

For the choice of coating system for different application, refer to the product brochure or contact Nippon Paint for professional recommendation.

PACKAGING

| Unit | Base | | Hardener | |
|-------|-------|----------------|----------|----------------|
| | Vol | Container Size | Vol | Container Size |
| 4.2 L | 1.5 L | 5 L | 2.7 L | 5 L |

STORAGE

Shelf life : Part A: 6 months (25°C)
Part B: 6 months (25°C)

Subject to re-inspection thereafter. Higher temperature during storage may reduce the shelf life and may lead to gelling in the tin. Frequent temperature cycles may also shorten the shelf life.

Store in tightly closed container in a dry, cool and well ventilated space, keep away from sources of heat and ignition.

SAFETY PRECAUTION

- This product is intended for use of professional applicators. Refer to the safety information display on the container and in the safety data sheet (SDS) before using the product.
- Use this product in well-ventilated area, avoid skin contact, spillage on the skin should immediately be removed with suitable cleanser, soap and water.
- Eye should be well flush with water and seek for medical attention immediately upon contact with this product.
- During the application, naked flame, welding operation and smoking is not allowed. Adequate ventilation should be provided.
- If you have any doubt regarding the suitability of use, refer to Nippon Paint for further advice.

DISCLAIMER

The information in this data sheet is given to the best of Nippon Paint's knowledge and practical experience. Users may consult with Nippon Paint on the general suitability of the product for their needs and



ZINKY-10 INORGANIC ZINC SHOP PRIMER

TECHNICAL DATA SHEET

specific application practices though it remains each user's responsibility to determine the suitability of the product for the user's particular use. The condition of the substrate and application are not within Nippon Paint's control. Therefore no implied conditions, warranties or other terms will apply to the Product. Nippon Paint does not and cannot warrant the results which the user may obtain by using the product. In no event will Nippon Paint be liable to the user for any kind of loss (whether direct or indirect) even if Nippon Paint was previously advised of it. In line with Nippon Paint's policy for continuous development, Nippon Paint reserves the right to modify the product and the information in this data sheet without prior notice. It is the user's responsibility to check with Nippon Paint for the latest version of this data sheet. This data sheet has been translated into various languages. In the event of any inconsistency, the English version shall prevail.