

Zinc Rich Epoxy Primer

General Description

Zinc Rich Epoxy Primer is a three-package, VOC conforming (2.8 lbs./gal.) low HAPS, zinc-rich epoxy primer. The resulting organic zinc-rich primer is designed to deliver excellent corrosion resistance.

Conforms to SSPC-20 Class I definitions for zinc-rich products containing 85% zinc in the dry film.

Typical Uses

As a high performance primer coating on properly prepared carbon steel or as a touch-up for inorganic zinc coatings where:

- An organic zinc-rich primer is required
- A zinc-rich product containing with 85% zinc in the dry film is required
- Spot application by brush (small areas) in addition to spraying, may be necessary

Compatibility with Other Coatings

Zinc Rich Epoxy Primer should be topcoated with other TCF coatings including, but not limited to Polyurethane Acrylic and Epoxy Mastic coatings, for a complete system. Contact your Twin City Fan representative for specific recommendations.

Not Recommended For

- Immersion service
- Marginally prepared surfaces

Performance Properties (when used in a system)

Adhesion	Excellent
Solvent Resistance	Excellent
Chemical Resistance (watch glass)	Excellent
Color & Gloss Retention	Excellent
Salt Fog & Humidity	Excellent

Color

Grey green

Application

Application Conditions

Do not apply if the application surface or ambient temperature is below 50°F (10°C) or above 95°F (35°C), or if the atmospheric temperature is within 5°F of the dew point. Relative humidity should be below 90%.

Surface Preparation

All surfaces must be clean, dry and free of loose rust, oil, grease and all other contamination.

Application Equipment

Apply by spray for best results. The Zinc Rich Epoxy Primer may also be applied by brush for small touch up areas.



Physical Properties of the Coating

Maximum Service Temperature:	250°F (121°C)
Gloss (ASTM D 523):	Flat @ 60° angle
Weight Solids (avg. varies by color):	86% ± 1%
Weight per gallon (avg. varies by color):	23.64 lbs. ± 2%
Flash Point (Tag Closed Cup):	20° to 70°F (-7 to 23°C)
Volume Solids:	55% ± 2%
Shelf Life:	12 months minimum
Theoretical Coverage per Gallon*:	886 @ 1 mil DFT 222 ft ² @ 4 mils DFT
Suggested Film Build**:	3 – 7 mils (75 – 175 µm) wet (WFT) 2 – 4 mils (50 – 100 µm) dry (DFT)

* Material losses during mixing and application will vary and must be taken into consideration when estimating job requirements.

** Application by brush and roller may require additional coats to achieve recommended films thickness.

Typical Properties of the Coating

Physical properties are for Zinc Rich Epoxy Primer. System properties will be enhanced when top coated with Polyurethane Acrylic or Epoxy Mastic. Topcoat for a complete system. For other system recommendations, contact your Twin City Fan & Blower representative.

Paint System: Zinc Rich Epoxy Primer

Type / Color: Epoxy Zinc-Rich / Grey green

DFT: 2 – 4 mils

Salt Fog Resistance (ASTM B117)	2000 hours	Scribe Rating: 10 Blister Rating: 10 - none
Humidity Resistance (ASTM D2247)	2000 hours	Blister Rating: 10 - none
Adhesion (ASTM D3359)	Initial	5 A - no failures
Humidity Adhesion (ASTM D3359)	2000 hours	5 A - no failures
Cyclic Corrosion Resistance (ASTM G85)	2000 hours	Scribe Rating: 10 Blister Rating: 10 - none
Impact Resistance (ASTM D2794)		30 inch pounds (forward only)
Mandrel Bend (ASTM D522)		Pass 1"
Stone Chip Resistance (ASTM D3170)		5
Pencil Hardness (ASTM D3363)		5H

Safety and Handling

For industrial use only by professional, trained painters. Before using, read and follow all label and MSDS precautions. If mixed with other components, mixture will have hazards of all components

Do not sand, flame cut, braze or weld dry coating without a NIOSH approved air purifying respirator with particulate filters or appropriate ventilation and gloves.

All technical advice, recommendations and services are rendered by the Seller gratis. They are based on technical data that the Seller believes to be reliable and are intended for professional use by persons having skill and know-how at their own discretion and risk. Seller assumes no responsibility for results obtained or damages incurred from their use by Buyer in whole or in part. Such recommendations, technical advice or services are not to be taken as a license to operate under or intended to suggest infringement of any existing patent.

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