

PERMAZINC 90

DESCRIPTION: PERMAZINC 90 is a two-component polyamide cured zinc rich epoxy primer. It is a high solid, high zinc dust containing product. It conforms to the compositional requirements of SSPC paint 20, level 2.

RECOMMENDED USE: Anti-corrosive protection of steel surfaces prepared by abrasive blast Cleaning. Suitable for primed with Tanks, pipe racks, piping, bridge, transportation heavy equipments. It can be used as primer for high performance Epoxy-Polyurethane systems. It may also be used as a repair primer for galvanized steel substrates and Inorganic zinc silicate coatings

RESISTANCE TO: Moisture – Excellent Weather – Excellent
Abrasion – Excellent Petroleum- Excellent

PRODUCT INFORMATION:

Colour: Grey
Finish: Matt
Volume solids %: 63 ± 2 % (ASTM-D2697-86)
V.O.C.: 315 g/l (NB. – Thinning will affect VOC compliance and volume solids)
Flash point: 25°C
Typical film thickness: 25 - 90 microns DFT
Mixing ratio: 6:1 by volume
Shelf life: 12 months from the date of manufacturing
Pot life: 6 hours at 23°C
Induction time: 15 minutes at 23°C
Pack size: 8.75 ltrs (Part A-7.5 ltr + Part B-1.25 ltrs)

FILM THICKNESS AND SPREADING RATE:	MIN.	MAX.	UNIT
Wet film thickness	79	142	μ
Dry film thickness	50	90	μ
Spreading rate	12.6	7	m ² /l (theoretical)

This figure makes no allowance for surface profile, uneven application, overspray or losses in containers and equipment. Film thickness will vary depending on actual use and specification.

SERVICE TEMPERATURE: 120°C maximum dry
RECOMMENDED THINNER: Thinner No.5 (5-20% as required based on application)

DRYING & CURING TIME:

SUBSTRATE TEMPERATURE	10°C	23°C	40°C
Touch dry	20 mins	10 mins	4 mins
Dried to over coat (minimum)	2 hours	1.5 hours	40 mins

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This datasheet supersedes the previous versions

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Through dry (Hard dry)
Dried for service

15 hours
7 days

12 hours
5 days

10 hours
2 days

These figures are given as a guide only. Factors such as air movement and humidity must also be considered

RECOMMENDED COATING SYSTEM:

Primer coat	PERMAZINC 90
Intermediate	PERMAGRIP MIO 80, PERMAGRIP IT 880/IT 653/IT 401
Topcoat	PERMATHANE T 137

SURFACE PREPARATION:

Remove all oil and grease in accordance with SSPC-SP1. Manually prepared surfaces should be prepared in accordance with SSPC-SP2 or SSPC-SP3. For more severe exposure, conditions blast cleaning to SSPC-SP 7 may be required. Abrasive blast clean to Sa 2 ½ BS7079:Part A1:1989. Average surface Profile 35 - 75 microns

RECOMMENDED APPLICATION METHODS:

Airless spray, conventional spray, roller
(short pile only), brush

APPLICATION EQUIPMENT DETAILS:

AIRLESS SPRAY:

Nozzle Size: 0.38mm (15 thou)
Fan Angle: 40°
Operating Pressure: 150 bar (2175 psi)

CONVENTIONAL SPRAY:

Nozzle Size: 1.27mm (50 thou)
Atomising pressure: 2.8kg/cm² (40 psi)
Fluid Pressure: 0.7kg/cm² (10 psi)

APPLICATION CONDITIONS AND OVER COATINGS:

This material should preferably be applied at temperatures in excess of 10°C. In conditions of high relative humidity, i.e. 80-85%, good ventilation conditions are essential. Substrate temperature should be at least 3°C above the dew point and always above 0°C. At application temperatures below 10°C, drying and curing times will be significantly extended, and spraying characteristics may be impaired. Application at ambient air temperatures below 5°C is not recommended

HEALTH AND SAFETY:

Please observe the precautionary notices displayed on the container. Do not breathe or inhale mist. Avoid skin contact. Spillage on the skin should immediately be removed with suitable cleanser, soap and water. Eyes should be well flushed with water and medical attention sought immediately. Consult Product Health and Material Safety Data Sheet for information on safe storage, handling and application of this product.

Disclaimer: The information detailed in this Data sheet is liable to modification from time to time in light of practical experience and normal product development. Please check with KPC to ensure it is the latest issue. We reserve the right to change the given data without notice. Any person or company using the product without first making enquiries with KPC as to the suitability of the product for the intended purpose does so at their own risk, and KPC accepts no liability for the performance of the product, or for any loss or damage arising out of such use.