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TECHNICAL DATA SHEET: PAINTS & COATINGS

WOCO ZINC RICH PRIMER TDS 117

DESCRIPTION

A primer for bare steel and containing a high percentage of zinc dust. The film contains 90% metallic zinc resulting in zinc to steel contact and the latter is protected by cathodic or "sacrificial" action of the zinc (cold galvanizing). Recommended for structural steelwork, tankage, harbor installations, jetty piling, re-galvanising of roofs and gutters. It can also be used as a shop primer.

APPLICATIONS

Grease and oil on the surface of the steel work must be removed by solvent (white spirit) prior to treatment. Can be applied on a wire brushed substrate but is preferable to blast clean to SA 2.5 Swedish standard (second quality BS 4232). For highly corrosive conditions we recommend SA3(first quality BS4232). The surface profile should not exceed 100 microns. Woco zinc rich primer comes supplied at the correct viscosity for brush application. For airless spray application we would recommend a tip size of 17-21 thou and 1600-2100 psi at the gun nozzle. For conventional spray application we would recommend a tip size of 50 mils and 30 psi atomizing pressure and thinning the product with up to 20% (by volume) of TH2 Thinners. We recommend steel should be primed with TDS 117 immediately after blast cleaning. This primer should be applied directly to the clean bare steel, not over existing paintwork. In workshop conditions the maximum interval between blasting and coating should not exceed four hours. Where steel is primed before fabrication, the dry film thickness must not exceed 25 microns to enable welding frame cutting to taking place. Application should not be carried out when the ambient temperature is below 7 deg c or where the steel temperature is less than 3 deg c above the dew point. Care must be taken to ensure that all edges, corners, nuts and bolts are adequately coated. Woco zinc rich primer may be overcoated with conventional chlorinated rubber or conventional one pack coatings.

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BENEFITS

Woco Zinc rich Primer offers the following benefits.

- Contains metallic zinc pigment that offers sacrificial protection of the steel.
- Excellent adhesion to steelwork.
- Can be overcoated with conventional oxidisable and chlorinated rubber systems.
- Suitable for use in areas where high corrosion is expected.
- Available in 1.0 and 2.5 litre pack sizes.
- Fast drying for rapid handling.

SPECIFICATIONS

Theoretical coverage:	18.80 square metres per litre at 25 microns dft.
Wet film thickness:	60-120 microns (2.40-4.80 mils).
Dry film thickness:	25-50 microns (1.00-2.00 mils).
Solids by volume:	42.0%.
Flash point:	23 degree centigrade.
Thinner:	TH2.

PERFORMANCE LEVELS

Surface dry:	20 minutes at 20 degree c.
Hard dry:	2.0 hours at 20 degree c.
Overcoating:	8.0 hours at 20 degree c.

The information contained herein together with the suggestions for use and application is to the best of our knowledge, true and reliable. Since conditions of application and use are beyond our control, no warranty is expressed or implied in respect of these recommendations or products. Users are recommended to carry out confirmatory tests to check suitability of products for their specific use.

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