

TECHNICAL DATA SHEET

TDS 117

ZINC RICH PRIMER 90%

(Conforms to BS5493: 1977. HPID & BS.4652 Type 2)

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 Galvanising). Recommended for Structural Steel work, Tankage, Harbour Installations, Jetty Piling, re-galvanising of roofs and gutters. It can also be used as a shop primer.

Colours: Metallic Grey

Drying Times@ 20°C*: Surface Dry: 20 minutes
Hard Dry: 2 hours approx.

Covering Capacity*: Theoretical: At 25 microns Dft 18.8 sq.m/l
Practical: Figures will be lower and will depend on type of structure, the application technique and prevailing conditions.

Wet Film Thickness*: To achieve 25 Microns Dft apply wet film thickness of 60 Microns.
To achieve 50 Microns Dft apply wet film thickness of 120 Microns.

Dry Film Thickness*: As a Blast Primer: 25 Microns
As a Full Coat: 50 Microns

PLEASE NOTE: The above figures are given as a guide only and may vary with temperature and method of application

Solids by Volume: 42% BS.3900 Part A10: 1976 and ASTM D2697-73.

Flash Point: 23°C (73°F)

Thinners: TH.2

Packages: 2.5 ltr and 1ltr.

Surface Preparation:

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 it is preferable to blast clean to SA 2.5 Swedish standard (second quality BS.4232). For highly corrosive conditions we recommend SA3 (first quality BS.4232). The surface profile should not exceed 100 Microns.

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(Issue 3 RG)

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REG. NO. FM 37897



Application:

Airless spray, Conventional spray or Brush.

Care must be taken to ensure that all edges, corners, nuts and bolts are adequately coated.

We recommend steel should be primed with TDS 117 immediately after blast cleaning, This primer should be applied directly to 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 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°C (45 °F) or where the steel temperature is less than 3°C above dew point.

For Airless Spray:

We recommend 17 to 21 Mils tip size and 1600 to 2100 lbs/sq. inch pressure at the gun nozzle.

For Conventional spray:

We recommend a tip size of 50Mils and 30 psi atomising Pressure with up to 20% (by volume) of TH.2 Thinner.

For Brushing:

May be used for small areas only.

Storage:

The high metallic pigment content results in rapid settlement.

Overcoating Systems:

May be overcoated with conventional and Chlorinated Rubber or conventional one-pack systems.

Where Primer is left exposed for long periods ensure all damaged areas are cleaned back to clean metal and re-primed. All sound paint must be thoroughly cleaned before overcoating.

Health & Safety Precautions

Toxicity:

Care must be taken to avoid inhaling the solvent vapour for any length of time. Good ventilation is essential.

Fire Risk:

The solvent vapour can form an explosive mixture with air and no naked lights of any kind can be allowed in the vicinity.

SMOKING MUST BE PROHIBITED

WARNING:

The liquid paint must not be exposed where it can be contaminated by water in any form, such as rain, splashes or drips. This can lead to spontaneous combustion.

This primer which contains a high percentage of metallic zinc should not be used on steelwork under conditions where fire proofing treatment is required without prior consultation with the manufacturers technical department.

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 the suitability of products for their specific use.