

Product Data Sheet

Last update: September 2021

Description	Two component moisture - cured inorganic zinc silicate coating refer to SSPC paint 20 requirement.
Principal Characteristics	<p>Suitable for as a system primer for various paint system</p> <p>Has outstanding resistance against weathering and abrasion</p> <p>Good anticorrosive, primer for structural steel tanks, outsidehull,</p> <p>Chemical resistance within the Ph 5-9</p> <p>Can stand with substrate temperature from -90°C up to 500°C, under normal atmospheric exposure conditions</p>
Recommended use	As a general-purpose rust preventing primer for use in new construction and maintenance in severely corrosive marine and industrial environment.
Specification data on 20 °C	
Gloss	Flat
Colour	Greenish Grey
Specific gravity	2.30 ± 0.15 kg/litre
Solids by volume	65 ± 2 % (valued by mixed)
Recommended	Dry film thickness : 50 - 75 microns Wet film thickness : 77 - 115 microns
Coverage theoretical	13 m ² / litre - 50 microns; 8.7 m ² / litre - 75 microns
Drying time	Touch dry : 30 minutes at 30 °C Hard dry : 4 Hour
Full cure	7 days
Painting interval	Min : 12 hours ; max : unlimited (zinc salt must be removed)
VOC	563 g/litre (binder), 0 g/litre (pigment)
Flash point (DIN 53213)	Binder 18°C ; pigment Not applicable
Service temperature	Continuous : 600°C Periodic : up to 600°C
Pot life	12 hours, (after mixing the components)
Shelf life	Use within 6 months (for binder), 12 month (for pigment) keep in cool and dry place.

Surface Preparation

Substrate	Recommended
Steel	Blast cleaned in situ completely free from rust, scale, shop primer and other contamination to at least SSPC - SP 10, blasting profile (R _z) 40 - 70 microns
Shopprimed steel and galvanized steel	Sweep blasting, to remove zinc salts

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Subsequent coat : SIMACOVER EP BUILD COAT, SIMACOVER EP UNICOAT, SIMATHANE GLOSS

Application instruction

Condition	Recommended		
Temperatur	Min -20°C, max 40°C		
Relative humidity	Max 50-95 %		
Substrate temperature	should be at least 3 °C above dew point.		
Mixing ratio by volume	Binder : Pigment = 4 : 1, temperature of the mixture should be above 15°C		
Thinner use	Thinner 46-01 could be added after mixing the components, and stir well		
Method of application	Thinner	Nozzle orifice	Nozzle Pressure
	1. Airless spray	Not recommended	Not recommended
	2. Air spray	5-15%	2 mm
	3. Brush	Max. 5 %	-

- Add the zinc dust gradually to the container with binder, using a mechanical mixer.
- Stir the Pigment thoroughly through the binder
- Do not mix in reverse order, in order to avoid lumps in the paints.
- Strain mixture through 30 - 60 microns
- At high substrate temperatures (above 40°C) SIMAZINC SILICATE MC must be applied by spray gun and to avoid dry spraying, thinner 46-01 has to be added.
- Continue stirring during application by means of a mechanical agitator.
- At an application temperature above 40°C addition of 0 - 10 % volume of Sima Thinner 46-01 may be necessary

Over coating table :

Substrate temperature	-5 °C	0 °C	10 °C	20 °C
Min. interval	24 hours	24 hours	18 hours	12 hours
Max. interval	Several months when free from zinc salts and contaminant			

- Zinc rich primer can form zinc salts on the surface, they should not be weathered for long periods before over coating.
- An interval of several months can be allowed, however, under clean interior exposure conditions.
- In clean exterior conditions maximum interval of 14 days can be tolerated, but in industrial or marine conditions this interval should be reduced to the practical minimum.
- At all time visible surface contamination must be removed before over coating by high pressure water cleaning, sweep blasting or mechanical cleaning

Packing and size instruction

Packing size (two packs product) : 5 and 20 litres

Storage The product must be storage in accordance with national regulation. Preferred storage condition are to keep the containers in the dry space provided with adequate ventilation. The containers should be sealed tightly.

Safety Precaution Wear suitable protective clothing such as overalls, goggles, dust mask and gloves. Ensure that there is adequate ventilation in the area where the product is being applied. Do not breathe the vapour or spray. This product is flammable. Keep away from sources of ignition. Do not smoke.

HEALTH AND SAFETY: For detailed information on the health and safety hazards and precaution for use of this product, please see the SAFETY DATA SHEET (SDS).

The information in this data sheet is to the best our knowledge connects at date printing. The company reserves the right to the modify data without notice. Any change in data will normally be followed by issued of new data sheet. The user should check the data of printing and if more than 12 months have elapsed, then the data should on only be used after checking with our nearest self-office to establish that they are still valid. Since condition of application and services may be beyond our control, no liability can accept on basis of this data.