

X²Zinc

Selection & Specification Data

Generic Type Solvent Based Inorganic Zinc

Description Time-tested corrosion resistant primer that protects steel galvanically in the harshest environments. For over years, X²Zinc has been the industry standard for high-performance inorganic zinc protection on steel structures worldwide.

Features

- Meets Class B slip co-efficient and creep testing criteria for use on faying surfaces
- Rapid cure. Dry to handle in 45 minutes at 16°C and 50% relative humidity
- Low temperature cure down to -18°C
- High zinc loading
- Meets FDA requirements in gray color
- Available in ASTM D520, Type 2 zinc version
- Very good resistance to salting
- May be applied with standard airless or conventional spray equipment
- VOC compliant in certain areas

Color RAL 7003 and RAL 7046 (approximate colors)

Finish Flat

Primers Self Priming

Topcoats Not required for certain exposures. Can be topcoated with Epoxies, Polyurethanes, Acrylics, High-Heat Silicones and others as recommended by your Carboline representative. Under certain conditions, a mist coat is required to minimize topcoat bubbling.

Dry Film

Thickness

50-75 micron Dry Film .

Dry film thickness in excess of 150 micron per coat is not recommended.

Solids Content: By Volume: 62% ± 2%

Zinc Content in dry film: By Weight: 85% ± 2%

Theoretical Coverage Rate

12,4 m²/l at 50 micron.

8,3 m²/l at 75 micron.

Allow for loss in mixing and application

VOC Values

As supplied: 479 g/l

These are nominal values.

Dry Temp. Untopcoated:

Resistance

Continuous: 399°C

Non-Continuous: 427°C

With recommended silicone topcoats:

Continuous: 538°C

Non-Continuous: 649°C

Substrates & Surface Preparation

General Surfaces must be clean and dry. Employ adequate methods to remove dirt, dust, oil and all other contaminants that could interfere with adhesion of the coating.

Steel

Immersion : Sa3

Non-immersion: Sa2½

Surface Profile: 25-75 micron

Performance Data

Test Method	System	Results	Report #
ASTM D4541 Adhesion	1 ct. CZ 11	1500 psi Pneumatic	3306
ASTM A-325 Slip Co-efficient	Blasted steel 1 ct. CZ 11	0.668;meets requirements for Class B rating	2722
ASTM B117 Salt Spray	1 ct. CZ 11 at 2 mils dry film thickness over blasted steel	No rusting or blistering, cracking or delamination after 43000 hrs. Moderate salting of the surface only.	SR 405
ASTM D3363 Pencil Hardness	1 ct. CZ 11	Pencil Hardness "H"	3278
AASHTO M300 Bullet Hole Immersion Paragraph 4.6.9	1 ct. 11 over Abrasive blasted steel	No blistering or rusting of coating or rusting of bare steel area after 650 hrs. Immersion in 5% sodium chloride solution; 1.5" round bare area in coating.	2514

Application Equipment

Spray Application (General)

The following spray equipment has been found suitable and is available from manufacturers such as Binks, DeVilbiss and Graco. Keep material under mild agitation during application. If spraying stops for more than 10 minutes, recirculate the material remaining in the spray line. Do not leave mixed primer in the hoses during work stoppages.

Conventional Spray

Agitated pressure pot equipped with dual regulators, 3/8" I.D. minimum material hose, with a maximum length of 12,5m, .070" I.D. fluid tip and appropriate air cap.

Airless Spray

Pump Ratio: 30:1 (min.)

GPM Output: 3.0 (min.)

Material Hose: 3/8" I.D. (min.)

Tip Size: .019-.023"

Output BAR: 105-140

Filter Size: 60 mesh

Teflon packings are recommended and available from the pump manufacturer.

Brush For touch-up of areas less than one square foot only.
Use medium bristle brush and avoid rebrushing.

Roller Not recommended

Mixing & Thinning

Mixing

Power mix base, then combine and power mix as follows. Pour zinc filler very slowly into premixed base with continuous agitation. Mix until free of lumps. Pour mixture through a 30 mesh screen. DO NOT MIX PARTIAL KITS.

Ratio

Base : 10,5 liter

Zinc Filler 3,5 liter

Thinning

May be thinned up to 4% with Thinner 26 for ambient and warm surfaces. For extremely warm or windy conditions, may be thinned up to 4% with Thinner 33. In cool weather 16°C, thin up to 6% with Thinner 21. Use of thinners other than those supplied or recommended by Scandex may adversely affect product performance and void product warranty, whether expressed or implied.

Pot Life

8 hours at 24°C and less at higher temperatures. Pot life ends when coating becomes too viscous to use.

Cleanup & Safety

Cleanup

Use Thinner 21 or Isopropyl Alcohol. In case of spillage, absorb and dispose of in accordance with local applicable regulations.

Safety

Read and follow all caution statements on this product data sheet and on the MSDS for this product. Employ normal workmanlike safety precautions. Hypersensitive persons should wear protective clothing, gloves and use protective cream on face, hands and all exposed areas.

Ventilation

When used as a tank lining or in enclosed areas, thorough air circulation must be used during and after application until the coating is cured. The ventilation system should be capable of preventing the solvent vapour concentration from reaching the lower explosion limit for the solvents used. In addition to ensuring proper ventilation, appropriate respirators must be used by all application personnel.

Caution

This product contains flammable solvents. Keep away from sparks and open flames. All electrical equipment and installations should be made and grounded in accordance with the National Electric Code. In areas where explosion hazards exist, workmen should be required to use non-ferrous tools and wear conductive and non-sparking shoes.

Application Conditions

Condition	Material	Surface	Ambient	Humidity
Normal	4-35°C	4-43°C	4-35°C	40-60%
Minimum	-18°C	-18°C	-18°C	30%
Maximum	54°C	93°C	54°C	95%

This product simply requires the substrate temperature to be 3°C above the dew point. Condensation due to substrate temperatures below the dew point can cause flash rusting on prepared steel and interfere with proper adhesion to the substrate. Special application techniques may be required above or below normal application conditions.

Curing Schedule

Surface Temp. & 50% Relative Humidity	Dry to Handle	Dry to Topcoat	Dry to Immersion Service
-18°C	38°C	7 Days	NR
4°C	1 Hour	48 Hours	72 Hours
16°C	45 Minutes	24 Hours	48 Hours
27°C	45 Minutes	18 Hours	18 Hours
38°C	15 Minutes	16 Hours	14 Hours

These times are based on a 75 micron dry film thickness. Higher film thickness, insufficient ventilation or cooler temperatures will require longer cure times and could result in solvent entrapment and premature failure. Humidity levels below 50% will require longer cure times. **Notes:** Any salting that appears on the zinc surface as a result of prolonged weathering exposure must be removed prior to the application of additional coatings. Also, loose zinc must be removed from the cured film by rubbing with fiberglass screen wire if: 1) The X²Zinc 11 is to be used without a topcoat in immersion service and "zinc pick up" could be detrimental, or 2) When "dry spray/overspray" is evident on the cured film and a topcoat will be applied. **For accelerated curing or where the relative humidity is below 40%**, allow an initial 2-hour ambient cure followed by misting with water

or steam to keep the coated surface wet for a minimum of 8 hours and until the coated surface achieves a "2H" pencil hardness per ASTM D3363.

Packaging, Handling & Storage

Shipping Weight (Approximate)	<u>7 Liter</u> 18 Kg	<u>14 Liter</u> 36 Kg
Flash Point (Setaflash)	Part A: Zinc Filler:	13°C NA
Storage (General)	Store Indoors.	
Storage Temperature & Humidity	4-38°C 0-90% Relative Humidity	
Shelf Life	Part A: Zinc Filler:	12 months at 24°C. 24 months at 24°C.