

## 416 ZINC GRAPHITE PRIMER

### **MATERIAL TYPE:**

An excellent anti corrosive zinc graphite heat resistant primer formulated based on modified silicone resin.

### **RECOMMENDED USE:**

Designed to be a heat resistant primer for steel structures subjected to temperatures up to 600°C of industrial environment -: petrochemical plants, power stations an offshore structures etc.

To be overcoated with high resisting aluminium finish.

Capable of withstanding dry heat up to 600°C.

### **PRODUCT DATA:**

- ◆ Excellent anti-corrosive property
- ◆ Excellent resistance to moisture
- ◆ Excellent resistance to aliphatic solvents
- ◆ Moderate resistance to corrosive chemicals
- ◆ Excellent resistance to weather

### **PHYSICAL DATA:**

<b>Volume Solid</b>	53%
<b>Theoretical Coverage</b>	13.2 m <sup>2</sup> /litre @ 40 microns DFT
<b>Type</b>	2 components
<b>Packing Ratio</b>	4.35 litres Resin : 0.65 litres Cure
<b>Colour Availability</b>	Grey
<b>Flash Point</b>	38°C
<b>Recommended Thickness</b>	40 microns DFT
<b>Recommended Thinner</b>	Thinner No. 2

### **APPLICATION:**

#### **PRACTICAL APPLICATION RATES**

Micron Per Coat	Airless Spray	Brush	Brush	Brush
<b>Dry</b>	40	40	40	40
<b>Wet</b>	75	75	75	75

#### **AVERAGE DRYING TIME**

Ambient Temperature	Touch Dry	Hard Dry	Overcoating Interval		Potlife
			Minimum	Maximum	
15°C	15 minutes	2 hours*	32 hours	Indefinite	32 hours
25°C	10 minutes	1 hours*	16 hours	Indefinite	24 hours
35°C	5 minutes	1/2 hours*	8 hours	Indefinite	16 hours

\* This product will cure only when the temperature is raised to above 200°C for a minimum of 5 hours.

<b>Application Method</b>	Brush/Roller, Conventional Spray and Airless Spray.
<b>Mixing Ratio (by volume)</b>	4.35 Parts Resin to 0.65 Parts Cure.
<b>Thinner</b>	Thinner No. 2
<b>Thinner Consumption</b>	Brush/Roller – 0-5% Conventional Spray – 5-10% Air Spray – 0-5%



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<b>Airless Spray</b>	Nozzle Size	: 0.48-0.53mm (19-21 thou)
	Fan Angle	: 80°
	Operating Pressure	: 140-165 kg/cm <sup>2</sup> (2000-2400 psi)
<b>Conventional Spray</b>	Nozzle Size	: 1.27mm (50 thou)
	Atomising Pressure	: 3.5 kg/cm <sup>2</sup> (50 psi)
	Fluid Pressure	: 0.7 – 1.0 kg/cm <sup>2</sup> (10-15 psi)
<b>Brush</b>	This product is suitable for brush application.	
<b>Roller</b>	This product is suitable for roller application.	



Application Method



65° Spraying Tip



Pratice Proper Cleaning

### ***SURFACE PREPARATION:***

**Steel :** Remove all wax, oil and grease by solvent cleaning in accordance with the guideline given by SSPC-SP1.

Abrasive blast clean to Sa2.5 (ISO8501-1:1:1988) or SSPC-SP10.

An average surface profile in the range of 50-75 microns is acceptable.

The surface to be coated must clean and dry and free from all visible traces of surface contaminants.

### ***APPLICATION CONDITIONS AND OVERCOATING:***

This product should preferably be applied at temperature 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.

At application temperature below 10°C, drying and curing time will be significantly impaired.

**Application at temperature below 5°C is not recommended.**

If it is desired to overcoat outside the times stated on the data sheet, please seek advice from **Alspect** representative.