

SIPKYD ZINCROME 410

Alkyd Based Anticorrosive Primer

Product No. 6410

Features

- Anti-corrosive, one-pack primer.
- Economical and easy to use.
- Very good overcoatability with a wide range of systems.
- Approved under APCS-4 & 6.

Recommended Use

- As a primer or intermediate coat in an alkyd based system on steel surfaces in mild to moderately corrosive industrial and marine environments.

Physical Data

Finish	: Semi-gloss
Colours	: Green, Grey & Oxide Red
Volume Solids	: Approx. 50%
Recommended Film Thickness:	
40 microns dry = 80 microns wet	
Theoretical Coverage:	
12.5 m ² /ltr. at 40 microns	

Density	: 1.36 kg/ltr.
Drying and Recoating Times	
(25°C/65% RH):	
Dry to Recoat	: 04 Hours
Hard Dry	: 08 Hours
Maximum recoating time	: 06 Months
Heat Resistant	: 90°C
Flash Point	: 42°C

Specification Data

Preparation

The substrate should be thoroughly degreased in accordance with SSPC-SP1. All burs should be removed and sharp edges or rough weld seams should be ground down. Dry shot or grit blasting is recommended, the required standard of cleanliness being in accordance with SIS 05 5900 Grade Sa 2 or SSPC-SP6 or better.

All blast cleaning equipment should be of an approved type and fitted with a suitable moisture trap and grease/oil filters. Ensure that all dust, loose abrasive particles and other foreign matter are removed from substrate prior to painting.

In case blast cleaning is not possible, substrates should be power tool cleaned according to St3 or SP3.

Paint System

Can be applied on a blast cleaned and/or shop primed substrate which is uncontaminated and intact. Subsequent coats must be alkyd type only.

It is recommended to apply the second coat of the system within a few days.

Application Data

Thinning The paint is supplied ready for brush or airless spray application. If the paint is too thick, in cold weather for example, then add a small amount Thinner 710 / Thinner 0104 to obtain the suitable viscosity. The amount of thinner that may be added is dependent on the application conditions and methods. Overthinning will lead to poor results.

Application Conditions Application temperature: 5 - 50°C.
The minimum temperature required for satisfactory drying is 5°C. The surface temperature must be at least 3°C above the dew point to prevent condensation. Never apply paint under adverse weather conditions.

Mixing Advice Prior to application, mix paint thoroughly to obtain a homogeneous product. Use a mixer for this, which is powered by air or a flameproof electric motor.

Application Methods and Details

	<u>Airless spray</u>
Recommended thinner	Thinner 710 / Thinner 0104
Thinner Addition	Approx. 5% vol.
Nozzle Orifice	0.015" - 0.019"
Working Pressure	120 - 140 bar

	<u>Brush/Roller</u>
Recommended Thinner	Thinner 710 / Thinner 0104
Thinner addition	Approx. 3% vol.

The recommended method of application is by airless spray. However, brush, roller or conventional spray may also be used. Where brush and roller are to be used it will be necessary to apply multi-coats in order to achieve the required film thickness.

Cleaning of Equipment Use Thinner 710 / Thinner 0104.

Storage Information

Pack Size	5 and 20 ltr. (Single component material)
Storage	Store generally in original sealed container, indoors, at a temperature between 5 and 40°C and relative humidity below 70%.
Shelf Life	1 Year

Safety Information

See the material safety data sheet and product label for complete safety and precaution requirements.

Disclaimer

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