

ZINGACERAM HS

Zingaceram HS is a high solid 2 pack intermediate coat to be applied as a sealer over ZINGA. Due to its high solid (HS) content it shows good compatibility on ZINGA. Zingaceram HS has very good abrasion resistance and excellent corrosion protection properties.

PHYSICAL DATA AND TECHNICAL INFORMATION

WET PRODUCT

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| Components | Epoxy resins pigmented with micaceous iron oxide and ceramic fillers, cross linked with a phenalkamine hardener. |
| Density | - Paint: 1,76 kg/dm ³ - Hardener: 1,00 kg/dm ³ - Paint + Hardener: 1,64 kg/dm ³ |
| Solid content | - 88% by weight (±2%) - 78% by volume (±2%) |
| Type of thinner | HS Thinner |
| Flash Point | 32°C |
| Potlife | 2,5 - 3 hours |
| VOC | 196 g/L (= 120 g/kg) |

DRY FILM

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| Colour | Grey |
| Special characteristics | - High solid Content - High chemical resistance - Temperature resistance of dry film: 95-100°C with peak up to 120°C - pH resistance: 2,5 pH to 13 pH |

PACKING

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| 5 L | 4 L part A and 1 L part B |
| 20 L | 16 L part A and 4 L part B |

CONSERVATION

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| Shelf life | 1 year in the original and closed container. |
| Storage | Store in a dry place at temperatures between 5°C and 25°C |

CONDITIONS

SURFACE PREPARATION

When the waiting time between the successive coats is abnormally prolonged or in extremely polluted areas, the Zingaceram surface can become contaminated. All contaminations that hamper the adhesion of the paint should be removed by appropriate means. Salt deposits or other water-soluble contaminations should be removed with water and brush, water under high pressure or steam. Possible white rust on ZINGA should be removed with water and rigid nylon brush.

ENVIRONMENTAL CONDITIONS DURING APPLICATION

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| Ambient temperature | - Minimum 5°C |
| Relative humidity | - Maximum 85% - Do not apply on a damp or wet surface |
| Surface temperature | - Minimum 3°C above the dew point. - No visual presence of water or ice - Maximum 60°C |

APPLICATION INSTRUCTIONS

GENERAL

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| Application methods | Zingaceram HS can be applied on top of ZINGA by brush and roller or conventional spray-gun or by airless spraying. |
| Stripe coat | it is always recommended to treat corners, sharp edges, bolts and nuts before applying a uniform coat. |

APPLICATION BY BRUSH AND ROLLER

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| Dilution | For optimal use, dilute Zingaceram up to 5% (v%) with HS Thinner. |
| Type of brush or roller | Industrial round brush Short hair roller (mohair) |

APPLICATION BY CONVENTIONAL SPRAY-GUN

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| Dilution | 10-15% (v%) with HS Thinner depending on nozzle size. More dilution for same nozzle size will give a smoother surface finish; which will increase the abrasion resistance of the Zingaceram HS layer. |
| Pressure at the nozzle | 2 to 3 bar for a structured aspect; higher pressure for a smoother aspect. |
| Nozzle opening | 3 mm for a structured aspect; smaller (2,2 to 2,5 mm) for a smoother aspect. |

APPLICATION BY AIRLESS SPRAY

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| Dilution | 0-5% (v%) with HS Thinner depending on nozzle size. More dilution for same nozzle size will give a smoother surface finish. |
| Pressure at the nozzle | 150-250 bar |
| Pump ratio | 45/1 |
| Nozzle opening | 0.021 - 0.025 inch / 0,38 - 0,63 mm |

APPLICATION ON ZINGA

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| Mist (tie) coat | <ul style="list-style-type: none"> - Application at least 6 hours after ZINGA is touch dry. - 25-30 µm DFT - Diluted according TDS |
| Full coat | <ul style="list-style-type: none"> - 2 hours after touch dry of mist coat - DFT = specified DFT - 25-30 µm DFT - Diluted according TDS |

OTHER INFORMATION

COVERAGE AND CONSUMPTION

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| Theoretical coverage | <ul style="list-style-type: none"> - For 60 µm DFT: 13 m²/L - For 120 µm DFT: 6,5 m²/L |
| Theoretical consumption | <ul style="list-style-type: none"> - For 60 µm DFT: 0,077 L/m² - For 120 µm DFT: 0,15 L/m² |
| Practical coverage and consumption | Depends upon the roughness profile of the substrate and the application method. |

DRYING PROCESS AND OVERCOATING

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| Drying time | <p>For 60 µm DFT at 20°C in a well-ventilated environment:</p> <ul style="list-style-type: none"> » Dust proof: 3 hours » Dry to handle: 6 hours » Fully cured: 18 hours » Fully resistant: 7 days |
| Overcoating with a topcoat | <ul style="list-style-type: none"> - Overcoatable after minimum 8 hours after touch dry. - Maximum overcoat time depends on environmental conditions. Maximum 3 days. |

RECOMMENDED SYSTEM

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| <p>ISO 12944</p> | <p>Tested according to ISO12944 in industrial zones with high humidity and aggressive environment (continuous condensation and high pollution) (C5 I) and in coastal zones and marine zones with high salinity (continuous condensation and high pollution) (C5 M) with high classification (Life expectancy > 15 years):</p> <p>ZINGA 1 x 60-80 µm DFT + Zingaceram HS 1 x 120 µm DFT</p> <p>ZINGA 1 x 60-80 µm DFT + Zingaceram HS 1 x 120 µm DFT + Zingaceram EP 1 x 60 µm DFT</p> <p>ZINGA 1 x 60-80 µm DFT + Zingaceram HS 1 x 120 µm DFT + Zingaceram PU 1 x 60 µm DFT</p> |
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For more specific and detailed recommendations concerning the application of Zingaceram HS, please contact the Zingametall representative. For detailed information about the health and safety hazards and precautions for use, refer to the Zingaceram HS safety data sheet.