

# zandleven coatings

# MONOPOX® MICRO-ZINK EP80

epoxy

A two components epoxy anti-rust zinc dust paint which guarantees a lasting protection of blasted steel.

- Excellent weldable if applied in a dry film thickness of less than 25 µm.
- After a short time recoatable with epoxy, polyurethane, vinyl and chlorinated rubber paints.
- Use Monopox Metal sealer as an intermediate coat, if recoated with alkyd enamel is necessary.
- The product complies to SSPC Paint 20, Level 2 with respect to zinc content.

**Application** as anti-rust primer for steel structures under industrial, maritime and nuclear conditions.

To prevent zinc-salts it is advisable tot apply a sealer directly after drying.

### **Product information**

Finish Mat Colour Redgrey

approx. 2.4 kg/L (mixed product) Mass density

81 weight % dry film Solids content by volume approx. 58 volume %

VOC approx. 370 gr./L (volatile organic compound)

Recommended film thickness 25-60 µm d.f.t. per layer

45-100 μm w.f.t. per layer (undiluted)

Theoretical spreading rate At 25 µm d.f.t. 23.2 m<sup>2</sup>/L

At 50 µm d.f.t. 11.6 m<sup>2</sup>/L

Practical spreading rate Depending on several factors like shape of object, profile of surface,

method of application, application circumstances and experience.

A few guiding principles are:

Brush/roller 85-90% of the theoretical spreading rate 50-70% of the theoretical spreading rate Spraying

Base 23°C

30°C Hardener 2V8 Thinner FGM 631 26°C 14°C

Thinner WTD 107

180°C Dry temperature resistance

Durability At least 6 months, provided that it has been stored in closed

original packing at a dry and cool spot.



### **Drying times**

For d.f.t. up to 60 µm Dust dry Manageable Recoatable: Minimum interval Maximum interval 3

Flashpoint ISO 1523

30°C	20°C	10°C
20 minutes	½ hour	1 hour
1 hour	2 hours	4 hours
2 hours	3 hours	6 hours
7 days	14 days	1 month

\*) This period can be extended by cleaning and sandig the coating prior to application of the next layer

Because zinc-dust paints can develop zinc-salts on the surface, we recommend to recoat as soon as possible. Before recoating, remove possible pollution and zinc-salts.







**Application instructions** 

Mixing ratio Volume: Base – hardener 2V8 80:20

Mixing instructions

Base and hardener should be mixed and applied at temperatures above 10°C.

At lower temperatures extra thinner is needed which can effect the drying/curing

properties and the sag resistance.

The base and mixed product must be mixed carefully mechanically.

Pay attention to the side and the bottom of the can.

The mixing ratio is very limited, in particular when the packaging will be mixed

partly.

Induction time At 20°C not necessary

At 10°C at least 10 minutes

Pot life after mixing 10 litre packing: approx. 16 hours at 10°C

approx. 8 hours at 20°C approx.. 5 hours at 30°C

Optimal application Temperature : 15 – 25°C circumstances Humidity : 40 – 75%

Technical and esthetical properties can change when the product has

been applied under different conditions.

**Usage information** 

Type of thinner Recommended thinner (depending on application

and application)

Nozzle orifice

Nozzle pressure Typical d.f.t.

Cleaning of equipment

been applied ander amerent containers.			
ч			
31 / WTD 107			
5 vol. %			

0.43 – 0.48 mm 0.017 – 0.019 inch	2.0 – 2.5 mm
150 – 170 bar	3 – 5 bar
50 μm	40 μm
Thinner FGM 631 / WTD 107	

### **Surface conditions**

Obtaining the highest possible quality of the applied product it is very important that the substrate is prepared carefully and correctly. The required surface roughness and a dry and clean substrate are the main parameters. Prior to application of the paint, the substrate must be examined according to the ISO standard 8504:2000

Steel New steel:

Blasting according to the ISO standard 8501-1:1988 Sa 21/2.

Roughness profile Ra 10-12 μm Rz 50-60 μm.

Surface must be clean and dry.

Apply Monopox Micro-Zink on the blasted steel.

Repair and maintenance:

Clean the surface carefully with a suitable solvent containing cleaning preparation, or a water-soluble emulsifier to remove oil, grease and dirt.

Remove salts and other water-soluble impurity by spraying

with clean tap-water under high pressure.

Remove rust a.o. by (water)blasting Sa 2½ or derust mechanical until St. 2-3.

Touch up on a clean and dry surface with Monopox SF-HB Primer.

 Mechanical or hand derusting gives less quality than (water)blasting and will result in lower durability of the applied paint system.



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#### **Product Characteristics**

No coating work shall be carried out when the temperature of the surface is less than 3°C above dewpoint and when the substrate temperature is below 5°C.

Due to the presence of solvents, applying this product in confined spaces, adequate ventilation has to be ensured.

At low temperature and under humid conditions, amine blushing can occur, which can effect the intercoat adhesion negatively. Prior to the application of the next layer, the previous layer must be checked for this phenomena.

This coating product is based on epoxy technology. It is recommendable that it should be overcoated with a durable

Maximum film build in one coat is best attained by airless spray. Application by other techniques, it may be necessary to apply multiple coats in order to achieve the total specified dry film thickness.

## Safety description

Check safety data sheet

#### Ventilation rules

Minimum required quantity of air to comply with:			
	MAC	10 % LEL	
Monopox Micro-Zink	1860 m³/L	76 m <sup>3</sup> /L	
Thinner FGM 631	3995 m³/L	160 m <sup>3</sup> /L	
Thinner WTD 107	4085 m³/L	168 m³/L	

MAC = Maximum Accepted Concentration

LEL = Lower Explosion Limit

Also consult the safety information sheets.

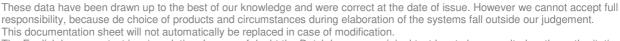
### Pretreatment / Labelling / Technical Terms (downloadable from www.zandleven.com)

- A 1 Labeling of paint products in the European Community
- A 2 Physical data
- A 4 General guidelines for steel preservation
- A 6 Pretreatment of construction steel
- material safety data sheet
- information hardeners and thinners
- sales & delivery conditions









The English language text is a translation. In case of doubt the Dutch language original text has to be consulted as the authoritative text.

