

Technical Data

Muki Z 2008



Product description

Muki Z 2008 is a two-pack, zinc ethyl silicate shopprimer. Designed to utilize extra high productivity in connection with advanced welding technology. Muki Z 2008 is excellent in corrosion protection of steel during normal storage and fabrication. Muki Z 2008 is compliant with ASTM D520 Type II zinc dust.

Recommended use

To be used as a preconstruction primer on blast-cleaned steel surfaces in automatic shoppriming plants to protect steel during transport, storage and fabrication.

Film thickness and spreading rate

	Minimum	Maximum
Film thickness, dry (μm)	15	20
Film thickness, wet (μm)	55	70
Theoretical spreading rate (m^2/l)	18,7	14

Comments

Dry film thickness measured on a smooth test panel.

Physical properties

Colour	Green, Grey
Solids (vol %)*	28 \pm 2
Flash point	14°C \pm 2 (Setaflash)
VOC	640 gms/ltr UK-PG6/23(97). Appendix 3
Gloss	Flat
Water resistance	Very good
Abrasion resistance	Excellent
Solvent resistance	Excellent
Chemical resistance	Excellent within pH range 6-10.
Flexibility	Limited

*Measured according to OCCA Monograph No. 4

Surface preparation

All surfaces should be clean, dry and free from contamination. The surface should be assessed and treated in accordance with ISO 8504.

Bare steel

Cleanliness: Blast cleaning to Sa 2½ (ISO 8501-1:2007). Roughness: using abrasives suitable to achieve grade Fine to Medium S/G (30-85 μm , Ry5) (ISO 8503-2)

Other surfaces

The coating may be used on other substrates. Please contact your local Jotun office for more information.

Condition during application

The temperature of the substrate should be minimum at least 3°C above the dew point of the air, temperature and relative humidity measured in the vicinity of the substrate. Recommended steel temperature: 30-40°C.

Application methods

Spray Use airless spray or conventional spray
Brush Recommended for touch-up purposes.

Application data

Mixing ratio (volume)	1:1
Mixing	1 part by volume Comp. A (Silicate solution) to be thoroughly mixed with 1 parts by volume Muki Z 2008, Comp. B (Zinc paste).
Pot life (23°C)	24 hours. (Reduced at higher temperatures).
Thinner/Cleaner	Jotun Thinner No. 4/25(No. 4 - Fast Evaporation) - (No. 25 - Slow evaporation).
Guiding data airless spray	
Pressure at nozzle	5 - 7 MPa (50 - 70 kp/cm ² , 700 - 900 psi).
Nozzle tip	0.38 - 0.58 mm (0.015 - 0.023").
Spray angle	40 - 80°
Note	<p>* Proper routines for cleaning and maintenance of the priming unit are necessary to achieve high productivity and uniform quality. Before start of work and after finishing with Muki Z 2008 it is recommended to circulate Jotun Thinner No. 4 or No. 25 through the entire spraying equipment for some minutes. During application it is necessary to use a mechanical stirrer.</p> <p>* The Comp. B (Zinc paste) must be stirred continuously while the Comp. A (Silicate solution) is added.</p>

Drying time

Drying times are generally related to air circulation, temperature, film thickness and number of coats, and will be affected correspondingly. The figures given in the table are typical with:

- * Good ventilation (Outdoor exposure or free circulation of air)
- * Typical film thickness
- * One coat on top of inert substrate
- * Relative humidity at 80 %

Substrate temperature	23°C	40°C
Surface dry	1-3 min	1-2 min
Through dry	3-5 min	1-2 min
Cured ¹	1 d	1 d
Dry to recoat, minimum ²	1 d	1 d
Dry to recoat, maximum ³		

1. Curing time to be verified by MEK-test (ASTM D 4752-87).
1. Recommended data given for recoating with coatings normally specified on top of shopprimers.
2. The substrate should be free from any zinc salts and other contamination prior to application of the subsequent coat.

