

Technical Data



ZINC LINE 80

PRODUCT DESCRIPTION : ZINC LINE 80 is a two-pack, zinc silicate shopprimer designed for high productivity in connection with advanced welding technology. ZINC LINE 80 is excellent in corrosion protection of steel during normal storage and fabrication conditions.

RECOMMENDED USE : To be used as a pre-construction primer on blast cleaned steel surfaces in automatic shop-priming plants to protect steel during transport, storage and fabrication.

TECHNICAL INFORMATION :

Colour	:	Grey	Water resistance	:	Very good
Solids (% by volume)*	:	28 ± 2	Abrasion resistance	:	Excellent
Flash point	:	14°C ± 2 (Setaflash)	Solvent resistance	:	Excellent
Flexibility	:	Limited	Chemical resistance	:	Excellent within pH range 6 - 10
Gloss	:	Flat			

* Measured according to ISO 3233:1998 (E)

	Film thickness per coat in microns		Theoretical spreading rate m ² /l
	Dry*	Wet	
Typical specification :	15 - 20	55 - 70	18.7 - 14.0

* Dry film thickness measured on a smooth test panel.

APPLICATION DATA :

Application methods : Airless spray. Conventional spray or brush may be used for touch-up purposes.
Mixing ratio : 1 part by volume Comp. A (Silicate solution) to be thoroughly mixed with 1 parts by volume Comp. B (Zinc paste).
Pot life (23° C) : 24 hours. (Reduced at higher temperatures).
Thinner/Cleaner : Jotun Thinner No. 4

Guiding data airless spray
Pressure at nozzle : 5 - 7 MPa (50 - 70 kp/cm², 700 - 900 psi.).
Nozzle tip : 0.38 - 0.58 mm (0.015 - 0.023").
Spray angle : 40 - 80°

NOTE :
* 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 ZINC LINE 80 it is recommended to circulate Jotun Thinner No. 4 through the entire spraying equipment for some minutes. During application it is necessary to use a mechanical stirrer.
* Comp. B (Zinc paste) must be stirred continuously while the Comp. A (Silicate solution) is added.

SURFACE PREPARATION : Blast cleaning to Sa 2½ (ISO 8501-1:1988 / SS 05 59 00), surface profile: 40 - 75µm.

CONDITION DURING APPLICATION : The temperature of the substrate should be min. 3° C above the dew point of the air in the vicinity of the substrate.

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

- * Good ventilation
- * Recommended film thickness

Substrate temperature	Surface Dry	Through Dry	Cured ¹	Dry to recoat ^{1,2}	
				Minimum	Maximum ³
23° C	1 - 3 min	3 - 5 min	5 hrs	5 hrs	-
35° C	1 - 3 min	3 - 5 min	3 hrs	3 hrs	-

¹ Curing time to be verified by MEK-test (ASTM D 4752-87) and is dependent on both humidity and temperature.

² Recommended data given for recoating with coatings normally specified on top of shop-primers.

³ The substrate should be free from zinc salts and other contamination prior to application of the subsequent coat.

The given data must be considered as guidelines only. The actual drying time/times before recoating may be shorter or longer, depending on existing coating, generic type, film thickness, system chosen, no. of coats, ventilation, temperature, requirement for early handling and mechanical strength etc. A mechanical system can be described on a system sheet, where all parameters and special conditions could be included.

TYPICAL RECOMMENDED PAINT SYSTEM : ZINC LINE 80 1 x 15 - 20 µm (Dry Film Thickness measured on a smooth test panel)

Undamaged shopprimer can be overcoated with a choice of systems based on epoxy, vinyl or chlorinated rubber resins.

STORAGE AND PACKING :

STORAGE : The product must be stored in accordance with national regulations. Preferred storage conditions are to keep the containers in a dry space provided with adequate ventilation. The containers should be sealed tightly.

SHELF LIFE : 6 months at room temperature for Comp. A.

PACKING CONTENT : 10 Ltr Comp. A + 10 Ltr Comp. B.

HEALTH AND SAFETY :

Please observe the precautionary notices displayed on the container. Spray under well ventilated conditions. Do not breathe or inhale mist. Avoid skin contact. Spillage on the skin should immediately be removed with suitable cleanser, soap and water. Eyes should be well flushed with water and medical attention sought immediately.

For detailed information on the health and safety hazards and precautions for use of this product, we refer to the Material Safety Data Sheet.

DISCLAIMER: *The information in this data sheet is given to the best of our knowledge based on laboratory testing and practical experience. However, as the product is often used under conditions beyond our control, we can not guarantee anything but the quality of the product itself. We reserve the right to change the given data without notice.*