



INDU-610 INORGANIC ZINC

HOJA TÉCNICA DEL PRODUCTO

DESCRIPTION

Moisture-curing, ethyl-based, two-component zinc silicate coating

MAIN FEATURES

- Anticorrosive primer for structural steel
- Suitable as a primer system in various paint systems based on unsaponifiable vehicles.
- Galvanic action eliminates underfilm corrosion
- It can withstand substrate temperatures from -90°C to 400° C under normal atmospheric exposure conditions.
- Good curing at low temperature.
- Good resistance to impact and abrasion.

COLORS AND BRIGHTNESS

Greenish Gray - Matt

BASIC DATA AT 20°C

(1g/cm³= 8.25 lb/US gal; 1m²/l = 40.7ft²/US gal)

Density

2.3g/cm³

Solids Volume

65 ± 2%

VOC (supply)

Max 219 g/kg (Directive 1999/13/EC, SED)

Max. 507 g/l (approx. 4.2 lb/gal)

film thickness recommended

- Film thickness measurement 75 µm with a minimum of 60 µm on a smooth surface without pitting, steel with abrasive blasting.
- Film thickness measurement 100 µm with a minimum of 75 µm on rough surface with pitting, steel with abrasive blasting.

Theoretical performance

touch dry

Overcoat Interval

8.7m²/l for 75 microns. 30 minutes at 20°C

Minimum 12 hours.

Max. No limit, although cleaning is essential before refinishing.

Curing time

12 hours.

induction time

None.

CONDITIONS

RECOMMENDED FROM

SUBSTRATE AND TEMPERATURE

- For immersion exposure:

- Steel: blasted, roughness profile (R) 40 – 70 microns.
- Steel with shop approved zinc silicate primer; areas with rust and damaged blasted White Metal

- For atmospheric exposure conditions:

- Steel: blasted, roughness profile (R) 40 – 70 microns.
- Steel with shop approved zinc silicate primer; surface preparation.
- Weathered galvanized steel; blasted to remove rust, scratch the surface and remove any zinc salt that might ask to be present.
- Stainless steel; degreased and blasted with roughness profile 40 - 70 microns thick.
- Relative humidity must be above 50%.

INSTRUCTIONS FOR USE

Mixing ratio by volume: zinc resin 81 : 19

To ensure proper mixing of both components, the following instructions must be carried out

To avoid haze on the paint, do not add the vehicle to the

zinc powder.

- 1) Take the bag with zinc powder out of the drum.
- 2) Shake the vehicle in the container until reaching a certain degree of homogenization.
- 3) Pour about 2/3 parts of the binder into the empty drum.
- 4) With the container reduced in weight and with more headroom, shake vigorously to obtain a homogeneous mixture without deposits at the bottom, and add this to the drum.
- 5) Add the zinc powder gradually into the container of the pigmented vehicle, and at the same time renew the mixture continuously using a mechanical stirrer (keep a slow speed).
- 6) Completely remove the zinc dust using the vehicle (at high speed) and continue stirring until a homogeneous mixture is obtained.
- 7) Filter the mixture with a 30-60 sieve screen

AIRLESS GUN

Recommended solvent:

Solvent INDU-540.

Solvent Volume

0 - 10% depending on specified thickness and application conditions.

nozzle hole

approx. 0.48 - 0.64mm (= 0.019 - 0.025in)

nozzle pressure

9 - 12 MPa (= approx. 90 - 120 bar; 1280 - 1700 psi)

A suitable pump must be used for the constant agitation of the zinc silicate coating.

AIR GUN

Recommended solvent:

Solvent INDU-540.

Solvent Volume

0 - 10% depending on specified thickness and application conditions.

nozzle hole

2mm

nozzle pressure

0.3 MPa (= approx. 3 bar; 43 psi)

A suitable pump must be used for the constant agitation of the zinc silicate coating.

BRUSH / ROLLER

recommended solvent

Solvent volume

Only for patches and small repairs

Solvent INDU-540.

5 - 15%

Apply a wet layer with a maximum thickness of 25 microns, follow the same procedure for the following layers, until the desired thickness is obtained.

CLEANING SOLVENT

Solvent INDU-540.

SAFETY PRECAUTIONS

For recommended paints and solvents, see product safety data sheet.

It is a solvent-based paint and inhalation of spray mist or vapor should be avoided, as should contact of wet paint with skin and eyes.



HECHO EN VENEZUELA POR PINTURAS FLAMUKO C.A.

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LOS DATOS QUE AQUÍ SE SUMINISTRAN, SON CIERTOS. SE BASAN EN NUESTROS ÓPTIMOS CONOCIMIENTOS TÉCNICOS Y DE CONTROL DE CALIDAD Y SE PUEDEN CAMBIAR SIN PREVIO AVISO. ESTOS DATOS NO IMPLICAN O EXPRESAN NINGÚN TIPO DE GARANTÍA POR INDEBIDOS MANEJOS OPERATIVOS Y/O DE INTERPRETACIÓN, ASÍ COMO DE RENDIMIENTOS, DESEMPEÑOS O DAÑOS RESULTANTES DE SU APLICACIÓN Y USO. LA RESPONSABILIDAD DE PINTURAS FLAMUKO C.A. ESTA LIMITADA SOLO A LA REPOSICIÓN DE SUS PRODUCTOS. LA GARANTÍA DE LOS PRODUCTOS DE PINTURAS FLAMUKO C.A. ALCANZA SOLO, SU CALIDAD EN EL ENVASE ORIGINAL DE ACUERDO AL ASEGURAMIENTO Y CONTROL DE CALIDAD DE LA EMPRESA. LOS USUARIOS DEBEN CONTACTAR A PINTURAS FLAMUKO C.A. PARA VERIFICAR EL USO CORRECTO DE NUESTROS PRODUCTOS ANTES DE ESPECIFICARLOS Y/O USARLOS.