



DESCRIPTION

Two component solventless, zinc rich coating for galvanizing

INTENDED USE

Zincfix® Original is an organic bound zinc rich coating containing >80% metal. It is applied to clean steel and hot dip galvanized surfaces to form an adherent anti-corrosive coating in excess of 100µm thick. **Zincfix® Original** combines the convenience of squish pack technology with the chemistry of modern solvent free epoxies.

PRODUCT BACKGROUND

When suitably cleaned steel is dipped in molten zinc at 450°C a coating comprising a series of iron/zinc alloy layers, over-coated with relatively pure zinc, is formed.

The hot dip galvanized coating provides a barrier against corrosion but additionally, provides sacrificial protection when the coating is site cut, welded or mechanically damaged. In order to prevent this sacrificial protection property prematurely consuming the surrounding coating, repair of the damaged coating using **Zincfix® Paste** is recommended

PRODUCT FEATURES

- The easy and accurate mixing of small packs reduces waste
- Although the medium grey metallic colour of **Zincfix® Original** will stand out on the bright shiny surface of newly exposed zinc, it will blend into a very similar finish once the stable matt grey zinc carbonate film has formed
- **Zincfix® Original** is resistant to white rust as the metal is bound by the epoxy binder. The product is resistant to 1000 hours humidity and 1000 hours salt spray resistance at a thickness of 400µm, with very little whitening
- **Zincfix® Original** is an excellent anti-corrosive primer for steel and is ideal for rust prevention and repair of corroded steel. It can be applied as a single coat & can be applied as a single coat and can be over-coated with any kind of conventional painting system

STANDARD COLOUR AVAILABILITY

Grey



PRODUCT INFORMATION

| Product Data | |
|-----------------------------|---|
| Components | 2 – Squish Pack |
| Percentage Zinc in Dry Film | >80% |
| Volume Solids | 100% |
| Pot Life | 30 minutes @ 25°C |
| Density | 3.6 +/- 0.1 kg/litre |
| Film Thickness | Wet – 100 µm Dry – 100µm |
| Spreading Rate | <ul style="list-style-type: none"> • 10m²/lt at 100µm DFT • 0.3 m²/ 100gm pack at 100µm DFT |
| Temperature Resistance | 120°C Dry |

PACKAGING

- The product is supplied in a sealed, 2 compartment, reinforced aluminium foil pouch. It is easy and clean to mix and use, it ensures exact mixing and 100% reproducibility. The mixing process takes place within the sealed container, thus the user is not exposed to the contents until the pack is cut open ready for use
- 100 gm Squish Packs



SURFACE PREPARATION

- Degrease surfaces with **Speccoats Hydrosolve** followed by a high pressure water rinse
- **Hot dip galvanized** surfaces (repair of defects) – surface must be abraded for a minimum distance (radius) of 25mm from defect using 220# waterproof emery paper (or finer) and water as a lubricant, the defect should be exposed to bare metal but the size should be kept as small as possible. Immediately after abrasion wipe the surface clean and apply the premixed repair material within the abraded area. Do not overlap the “patch” onto un-abraded galvanizing
- **Steel surfaces** - Grind and fettle weld spatter, protrusions & sharp edges to a minimum radius of 2mm
- Abrasive blast clean to grade SA 2 ½ of ISO 8501-1 with a blast profile 40- 50µm
- Alternatively mechanically abrade the surface using grinding discs/Bristle Blaster to achieve a similar profile
- Surface must be free from any surface contaminants such as oils, grease, dust etc.




APPLICATION

Mixing – Two Components

- The product is mixed by the removal of the seal and rubbing and squashing the components together inside the pouch. The contents will start to heat up after 10 minutes (exothermic reaction) and must be used within 30 minutes of mixing

Application – Equipment & Methods

| | |
|---|--|
| First | <ul style="list-style-type: none"> Remove seal between Zinc base and clear curing agent (pull rubber cord from plastic channel) Squeeze the contents of the clear bag to the other to mix the two components |
| Secondly | <ul style="list-style-type: none"> Crumple the bag & squash the components to mix thoroughly for 5 minutes. It is recommended that the squish pack be placed on a flat surface and "ironed" backwards and forwards using the flat surface of the channel from the temporary seal insure that all the material is squeezed out of the corners into the centre of the packet and thoroughly mixed in with the contents |
| Application | <ul style="list-style-type: none"> Cut the corner off the mixed packet and squeeze sufficient material out to coat the prepared area |
|  Brushes | <ul style="list-style-type: none"> Spread the material with a stiff bristled brush or a plastic (polypropylene) applicator |

DO NOT

- Attempt to use the product after the pot life has been exceeded. The pot life will be shorter at high temperatures and longer at lower temperatures. Wetting on the substrate is important for adhesion. When the product is too thick (at the end of its pot-life) it is recommended to discard the material and mix a new packet

Cleaner

- Cleaning is done with **Speccoats SA65 Thinners**

LIMITATIONS

- This product will chalk on prolonged exterior exposure
- This product will not cure below 8°C

APPLICATION ENVIROMENT

| Level | Surface Temperature | Ambient Temperature | Relative Humidity |
|----------------------------|---------------------|---------------------|-------------------|
| Minimum | 10°C* | 8°C | N/A |
| Maximum | 45°C | 45°C | 90% |
| *or 3° above the dew point | | | |

DRYING TIME

| Touch dry | Over-coating interval | | Dry to handle | Full Cure |
|-------------------------------------|---------------------------|----------|---------------------------|-----------|
| 2 hours at 25°C for 100µm at 65% RH | Minimum | Maximum | 6 hours at 25°C at 65% RH | 7 days |
| | 6 hours at 25°C at 65% RH | 48 Hours | | |

STORAGE AND HANDLING

Storage - Store at temperatures between 5°C and 40°C, away from direct sunlight, open flames or sparks

Shelf Life - use before 6 months from production date

HEALTH AND SAFETY

- Adequate ventilation should be provided during use
- Avoid contact with the skin by using gloves, barrier creams and face mask
- If the product comes into contact with the skin, wash immediately with lukewarm water and soap, if the eyes are affected flush with water orf dilute boric acid solution and seek medical attention immediately
- Refer to Material Safety Data Sheet (MSDS)

DISCLAIMER

Whilst we endeavour to ensure that all advice we give about the product is correct, the information given in this data sheet is not intended to be exhaustive and any person using the product for any purpose other than that specifically recommended in this sheet without first obtaining written confirmation from us as to the suitability of the product for the intended purpose does so entirely at his own risk. As conditions of use, method of application and suitability of the substrate prior to painting are beyond our control, no guarantee is implied by the recommendations contained herein. We therefore do not accept any liability whatsoever or howsoever arising from the performance of this product or for any loss or damage arising out of the use of this product. The information contained in this sheet is liable to modification from time to time in the light of experience and ongoing product development programmes. It is the user's responsibility to ensure that this sheet is current prior to using the product. **No.H5064 ISSUE DATE 02/02/2012**