

# MEGENAX® 2-COMPONENT ZINC DUST PRIMER



## PRODUCT INFORMATION

<b>Designation of type</b>	⇒ EP 730	State of 4/18
<b>Product description</b>	⇒ 2-component epoxy zinc dust primer according to DB, TL 918 300 part 2, folio 87 ⇒ Cold galvanizing of steel by cathodic protection against corrosion ⇒ Low in solvents with approx. 88 % by weight solid matter content ⇒ Temperature stability approx. 150 °C ⇒ Recoatable with many 1- and 2-component top coats except alkyd resin coats	
<b>Application area</b>	⇒ General industry, steel industry, heavy protection against corrosion	
<b>Binder</b>	⇒ Polyaminoamide-curing epoxy resin	
<b>Substrate/Preparation</b>	⇒ Absolutely grease-, scale and stainless steel surface (degree of rusting A-C ISO 8501-1) ⇒ Sand blasted to Sa 2 ½ DIN EN ISO 12944, part 4 ⇒ Use granular blasting agents; roughness depth Ø 60 µm ⇒ Coat blasted surfaces not later than after a few hours ⇒ At a plasma cut no adequate blasting possible	
<b>Processing</b>	⇒ Compressed-air spraying: max. 10 % VS 50, 1.8-2.5 mm nozzle, 3-4 bar ⇒ Airless undiluted, nozzle from 0.38 mm up, pressure at least 180 bar ⇒ Dependent on film thickness 1-2 spraying cycles, 3-6 minutes intermediate flash off time ⇒ Ambient temperature: at least + 10° C, relative air humidity max. 75 % ⇒ Object temperature: at least + 10° C and at least 3° C above the dew point	
<b>Viscosity</b>	⇒ Airless: 20-30 s / 6 mm DIN (hardened) ⇒ Compressed-air spraying: 30-50 s / 4 mm DIN (hardened)	
<b>Mixing ratio</b>	⇒ 10 : 1 by weight	
<b>Hardener</b>	⇒ Special hardener for 2-component zinc dust primer SO 011 B, thoroughly mix primer and hardener, then thin if necessary	
<b>Pot life</b>	⇒ 8-12 hours, use not under + 10° C	
<b>Thinner</b>	⇒ VS 50	
<b>Drying time at 20° C</b>	⇒ Dust-dry after 10-15 minutes ⇒ Tack-free after 30-60 minutes ⇒ Ready for installation after 4-6 hours ⇒ Complete drying after 1-2 days	
<b>Recoatability</b>	⇒ After 1-2 days with good ventilation ⇒ With many 1- and 2-component top coats except alkyd resin coats (for example MMT, MG, DG, DM, DS) and DAC ⇒ In case of doubt, check the recoatability before coating	
<b>Colour</b>	⇒ Grey	

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<b>Degree of gloss</b>	⇒ Flat
<b>Specific weight</b>	⇒ Approx. 3.0 g/cm <sup>3</sup>
<b>Solid matter content</b>	⇒ Approx. 88 % (percent of weight)
<b>Solvent content</b>	⇒ Approx. 12 % (percent of weight)
<b>Film thickness</b>	⇒ 75-80 µm, max.120 µm dry film thickness, 160-175 µm wet film thickness ⇒ At sand blasted to Sa 2½ (roughness depth Ø 60 µm) at least 80 µm dry film thickness
<b>Theoretical coverage</b>	⇒ Approx. 2.3 m <sup>2</sup> /kg at 80 µm dry film thickness
<b>Practical consumption</b>	⇒ Compressed-air spraying: approx. 0.63 kg/m <sup>2</sup> or 1.6 m <sup>2</sup> /kg at 80 µm dry film thickness ⇒ Airless: approx. 0.56 kg/m <sup>2</sup> or 1.8 m <sup>2</sup> /kg at 80 µm dry film thickness
<b>VOC-value ready for use</b>	⇒ 490 g/l ⇒ Limiting value paint material for buildings: 500 g/l ⇒ Limiting value industrial coating: no specification Coating of other metal and plastic surfaces
<b>Standard packaging</b>	⇒ Primer 20 kg ⇒ Hardener 2 kg
<b>Shelf life</b>	⇒ Primer and hardener at + 10 to + 30° C and unopened packaging ½ year
<b>Material safety data sheet</b>	⇒ Primer No. 028, hardener No. 053
<b>Flash point</b>	⇒ > + 23° C