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PRODUCT DATA SHEET

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HANSAZINC ST dark grey

by volume mixture 93:7 with hardener ACA-6 115 (03091-70700)

Article no.: **73009-73920-0070**

Surface tolerant, zinc dust-containing 2-component epoxy primer with high penetration capability on not metallically clean steel surfaces. Offers pigment binding reserve on manual derusted or ultra high pressure water blasted steel surfaces, can be used in areas above and below water.

application areas:

hull under water	+	holds	+
hull above water	+	interior	+
areas with condensation	+	deck buildings	+

Substrates / surface preparation:

substrates must be absolutely clean, dry and free of grease and dust

structural steel, sheet steel: cast iron:	Blasting to **Sa 2½**, pressure water jets **DW 3**, manual derusting **ST 2** *(on flash rust, moisture or well-bonded residues of old paints by brush or roller without problems processable up to max. 70 microns / 2.8 mils dry film thickness)*
galvanized steel: stainless steel: light / non ferrous metal: wood / wooden composite: mineral substrate: plastics: old coatings, third party primers:	not suitable

HANDLING AND APPLICATION

Storage stability: At least 6 months when both components are separately stored in original, un-opened packages at temperatures between 15 and 25°C (60 - 85°F).
Opened containers must be sealed well and use up as soon as possible.

hardener: **HANSAPOX hardener ACA-6 115** Article no.: **03091-70700**

mixture:

by volume	93	parts of main component:	7	parts of hardener
resp	13.29	parts of main component:	1	part of hardener
(by weight	33.64	parts of main component:	1	part of hardener)

potlife: 3 - 4 hours at 20 - 23°C (68 - 73°F)
It is not possible to store pre-mixed mixtures longer than the specified pot life.

thinner: **HANSASOL Thinner EP** Article no.: **03089-00090**

application: Before application, the color shade and the compatibility with the substrate should be tested. Object-, material and ambient temperature should not be below 15° C (49° F) and not above 25° C (77° F) and must be at least 5° above the dew point.
Freshly blasted surfaces can be coated by spraying methods. On manual derusted surfaces or surfaces with residual moisture, flash rust or residues of old coatings the mixture must be well incorporated by brush or roller into the substrate. Before processing the mixture must be adjusted to the viscosity for the respective application method.

All values given are just examples, the actual settings are process-and system-dependent

	Viscosity:	Nozzle diameter (mm)	Nozzle diameter (mil)	Spray pressure (bar)	Spray pressure (psi)
Airless spraying	not diluted	0.3 - 0.8	12 - 30	120 - 200	1740 - 2900
Cup gun	30 - 40 s	2.0	75	2.5	36
Brush/roller	To avoid surface finish faults (differences in dry film thickness depending on working direction), apply undiluted material and smoothe it in accordance with good professional practice.				

theoretical spreading rate:

at 50 microns (2 mils) dry film thickness	11.2 m²/l	= 4.5 m²/kg mix
= 90 microns (3.5 mils) wet film = 220 g/m² (0.41 lbs/yd²)	60.7 yd²/gal	= 2.4 yd²/lb mix
at 70 microns (2.8mils) dry film thickness	8 m²/l	= 3.2 m²/kg mix
= 130 microns (4.9 mils) wet film = 310 g/m² (0.57 lbs/yd²)	43.3 m²/gal	= 1.7 yd²/lb mix

drying time:	*(at standard climate 23°C (73°F) / 50 % rel. humidity and adequate air circulation)*	*dust-dry* 2 hours *touch dry* 4 hours *overcoatable* 4 hours up to 14 days (max. 6 months after intermediate grinding) *splash-/rain-water proof* after overcoating *cured* 14 days

Drying temperatures below 10°C / 50°F, relative humidity above 85% or too less air circulation increases the drying time significantly.
Drying temperatures below 5°C / 41°F can cause film defects (blistering, loss of adhesion)

TECHNICAL DATA

	Main component	*Hardener*	*Mixture*		
density:	2580	1020	2470	kg/m³ =	
density (solids):	4130	1020	3740	kg/m³ =	
Solids:	84	100	84	Wt %	
	52	100	56	Vol-%	
VOC content:	16	36	16.6	Wt %	*VOC value:* = 411 g / l mixture

base of binder:	*Main component:*	epoxy resin combination
	Hardener:	formulated cycloaliphatic polyamine
colour shades:	*Main component:*	greenish grey
	Hardener:	colorless
Viscosity:	*Ready mixture*	1100 – 1200 cp with spindle 5

FILM CHARACTERISTICS

gloss matt

stability: depends on the following coatings

stability: *(without top coat):*

weather	**C4 low**	solvents	**o**
dripping water	**+**	fuels	**o**
aqueous cleaning agents	**o**	lubricants	**+**
(partial) immersion in water	**-**	dry heat	**180°C / 356°F**

overcoatable with	*itself*	4 hours - 14 days
	2-comp. coatings	*(after this time intermediate grinding is necessary)*
	Antifoulings	only following suitable inermediate coatings

recommended 2nd primer **OSNAPOX PA primer "ZH"**, containing zinc phosphate 12944 Article no.: **7135-xxxx-0050**

DELIVERY AND SHIPPING AMOUNTS

(subject to minimum order quantity):

1 pail with	9.3	l = 24.0 ± 0.5 kg	2.05	gal = 53.0 ± 1.0 lbs main component
+	0.7	l = 0.7 kg	0.15	gal = 1.6 ± 0.1 lbs hardener
amounts to	10	l = 24.7 ± 0.5 kg	2.20	gal = 54.5 ± 1.1 lbs mixture

other amounts on request.

HEALTH AND SAFETY / STORAGE / ENVIRONMENTAL DATA

Observe the universally applicable guidelines when handling and storing coating materials. Observe all hazard warnings and safety advice printed on the containers.
For more details, please refer to the Material Safety Data Sheets.

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