



PRODUCT DATA

P-159

Low V.O.C. Inorganic Zinc Primer

Description: P-159 is a two component, zinc-rich ethyl silicate primer formulated for use as a primer for galvanic (cathodic) protection of ferrous surfaces. The zinc pigment sacrificially oxidizes to protect iron in ferrous substrates.

Typical Uses: zinc-rich primer to protect ferrous surfaces, such as bridges, tanks, and structural steel. Zinc pigment provides cathodic protection and film undercutting resistance to corrosion. Performance similar to hot-dipped galvanizing.

Special Qualifications: AASHTO M-300, Types I & IA, and for high-strength bolts (ASTM B-490, Class B) slip coefficient of 0.66

Dry Temperature Limits: 750 deg.F

Surface Cleanliness: for atmospheric exposure abrasive blast clean to NACE No.3/SSPC-SP 6 Commercial Metal Blast Cleaning, for immersion service abrasive blast clean to a NACE No. 2/SSPC-SP 10 Near-White Metal Blast Cleaning. For salt contaminated surfaces best results are obtained by first pressure washing the surface using a commercially available chloride remover.

Profile Depth: average 1.5 to 2.0 mils (visual comparator), maximum 2.3 mils (Testex replica tape)

Profile Texture: sharp and angular (viewed under magnification)

Mixing Instructions: Stir liquid portion first using mechanical agitation (jiffy power mixer). Discard the desiccant bag from the zinc powder, gradually stir the zinc dust into the liquid component under constant agitation. Filter through a 50 mesh screen after mixing. Never add the liquid portion to the zinc dust component. Continuous agitation is required.

Application Equipment: 45:1 ratio pump with 0.017 (617) to 0.019 (619) inch diameter orifice for airless spray gun tip at a 2,400 psi recommended minimum fluid pressure at tip to obtain proper atomization. For whip lines longer than 50 feet, use 1/2 inch I.D. Flush all equipment with thinner to remove any moisture that may be present. Striping must be done following spray application. Thin 50% for touchup and striping.

Application Conditions:

- Noncontaminated profile (pretreat and blast contaminated surfaces)
- Dry, dust-free metal surface
- Hot metal temperature will retard cure.
- Metal temperature at least 5 deg. above the dew point
- Ambient temperature above 50 deg.F
- Humidity greater than 40% and less than 90%
- Material temperature between 50 and 90 deg.F

Safe Application Conditions: Consult MSDS for proper handling, cleanup, disposal, and use of personal protective equipment. Circulate sufficient air to maintain working environment below the PEL and LEL. Apply according to local, state, and federal (OSHA) regulations.

Finish: Flat

Color: gray/green

Volume Solids: 80% (void content method)

VOC: 2.8 lbs./gal. (336 g/l), (mixed)

Flash Point: 56 deg.F

Dry Film Thickness: 3 mils

Wet Film Thickness: 3-1/2 mils

Theoretical Coverage: 1412 sq.ft./gal.@ 1 mil

Induction Time: none required

Pot Life Time: 8 hours @ 75 deg.F

Shelf Life Time: 9 months. Do not use past nine months.

Dry Time: @ 75 deg.F

Set to Touch 15 min.s

Recoat generally 24 hours, depending on temperature and relative humidity, although may be topcoated, when dry film will pass a 50 MEK rub test without removing any zinc.

Thinner: T-155 or T-163

Clean Up Solvent: T-40 or T-36

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