

MC-Zn Zinc Rich

Endura MC-Zn Zinc Rich Primer provides excellent galvanic protection with a very high load of zinc in the dry film and a superior impact resistance. It gives the best protection for corrosive environments. This product can be applied at sub zero temperatures.

Product Features

- ◆ High solids
- ◆ Low VOC
- ◆ Ideally suited for industrial & marine uses
- ◆ Provides galvanic protection

Theoretical Solids Content:

Volume: 62%

Shelf Life*

Component A: (3) years
Component B: 6-12 months

*For unopened product.

Pot Life of Mixed Product:

8 Hours @ 77°F (25°C) and 50% RH



Suitability

Endura MC-Zn Zinc Rich Primer is a two-component, low VOC, moisture-cure primer ideally suited for industrial and marine uses: bridges, tanks, piping, offshore drilling equipment, structural steel, etc. With 90% zinc content in the dry film, MC-Zn is an effective galvanic primer providing optimum cathodic protection to steel substrates.



Surface Preparation

Sandblasting (sandblast media, mesh size 16/30 or 30/50 or LG 50 steel shot) or machine sanding with 40 grit sandpaper is acceptable for most applications. Hand or power-tool cleaning may be adequate for removal of loose rust.



Mixing Ratio

2 parts by volume of component A [FEA0311]
1 part by volume of component B [FEB0315]

The recommended temperature when mixed is 20-25°C (68-77°F).

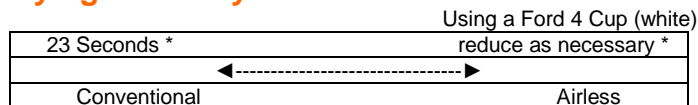
Environmental Conditions

For optimum coating performance product, substrate and ambient temperature should be between 20°C-25°C* (68°F-77°F). To prevent condensation during application the surface temperature must be 3°C (5°F) or more above the dew point at all times.

*for use outside this range please contact your Endura representative.



Spraying Viscosity*

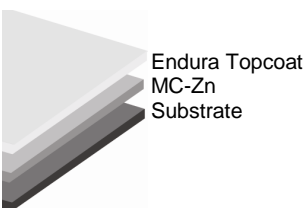


* Spraying viscosity and thinning will depend on ambient conditions, spray equipment used, and on the desired surface finish.



Spray Gun Setup

| Feed Type | Fluid Tip | Application Pressures (heel of gun) | Fluid Delivery |
|--------------------|------------|---------------------------------------|----------------|
| Siphon Feed | 1.6-1.8 mm | 40-50 psi | |
| Gravity Feed | 1.6-1.8 mm | 30-40 psi | |
| Pressure Feed | 1.4-1.8 mm | 50-60 psi | 12-16 oz/min |
| Air Assist Airless | 9-17 Thou | 1,000-1,800 psi | |
| Airless | 13-15 Thou | 1,700-3,000 psi | |



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Application Method

Endura MC-Zn Zinc Rich Primer can be applied using most spray painting systems although electrostatic sprayers are not recommended. Spraying should be done using an agitated pot. A brush or roller may be used for minor touch ups or small areas.



Recommended Film Build Thickness and Cover Rate

Endura MC-Zn Zinc Rich Primer has a recommended film build thickness of:

Wet (unreduced): 3.0 – 5.0 mils wet (75 – 125 microns)
Dry: 2.0 - 3.0 mils (50 - 75 microns)

Theoretical coverage at 1.0 mil (25 microns) DFT: 992 ft² per gallon @ 100% transfer efficiency.

Drying Time*

Under normal conditions MC-Zn Zinc Rich Primer has a topcoat window of 4 - 72 hours. **After 72 hours this primer must be scuff sanded** with no greater than 100 grit sandpaper.

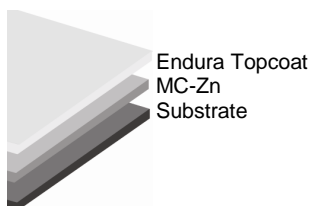
| | 20°C (68°F) | 30°C (86°F) | 40°C (104°F) |
|-----------|-------------|-------------|--------------|
| Topcoat | 4-6 Hours | 4-5 Hours | 3-4 Hours |
| Full Cure | 7-9 Days | 5-6 Days | 3-4 Days |

Note: If Relative Humidity is below 20% use up to 30ml Super Catalyst II per mixed quart, to aid curing.

* Subject to ambient conditions (temperature and humidity) film build and good airflow. For improved scheduling please contact your Endura representative.

Specifications

| | | |
|--------------------|--|-------------------------------|
| Solvent resistance | ASTM D4752 | 100 MEK rubs; NO failure |
| Flexibility | ASTM D522 | 1/8" mandrel bend: NO failure |
| VOC | For VOC amounts please refer to the product MSDS | |



Clean Up

Endura high strength gun wash, Endura epoxy reducer or Endura EX-2C thinner.