



## APCOSIL 605 (85%)

Two component, moisture curing inorganic zinc silicate coating.

- Heavy duty primer, offering excellent corrosion protection in highly aggressive environments
- Excellent water and solvent resistance
- Meets zinc dust level classification as per SSPC Paint 20 Level 1
- Can withstand substrate temperatures ranging from -90° C to +600° C
- Very good resistance to saline and marine atmosphere

### TECHNICAL DATA

Colour	Grey	Drying time at 30° C 50% RH	Surface dry : 30 minutes
Gloss	Matt		Hard dry : 16 hours
Volume Solids	Approx. 60%	Over coating Interval at 30° C	Full cure : 7 days
Recommended DFT/ Coat	50 - 75 microns		Min. : 16 hours
Theoretical covering capacity	13.00 sq.mtr/ l @ 50 microns 8.60 sq.mtr/ l @ 75 microns	Shelf Life (cool and dry place)	Max.: Unlimited, provided surface is free from any contamination, corrosion and zinc salt.
Flash point	Liquid : Not less than 15° C Powder : Above 65° C		At least 9 months

### Overcoating Procedure:

Zinc rich coatings are porous and hence pinholes may occur in the subsequent coat due to release of entrapped solvent. To minimize pinholes, apply a mist coat as the first pass of the subsequent coat, let the entrapped air escape and then apply full coat. Zinc rich primers, when exposed for extended periods of time without proper top coating, will start showing white rust formation. These "white rust" spots are zinc corrosion products. The extent of white rust formation will depend on the period of exposure of the zinc silicate coating and the nature of the surrounding environment. Prior to application of the subsequent coats, it is necessary to ensure removal of the white rust.

### DIRECTIONS FOR USE

#### SURFACE PREPARATION & SUBSTRATE CONDITION:

- Steel; blast clean to Sa 3 / 2.1/ 2 of Swedish Specification. Blasting profile: (Rz) 40 - 70 microns
- Galvanised steel; sweep blast to roughen the surface and to remove any zinc salts that may be present
- Heavily pitted steel is not acceptable
- Substrate temperature should be at least 3° c above dew point but not above 50°

#### MIXING

Do not open packing until just before use. Loosen the settled material in the liquid portion, if any, with the help of hand stirrer followed by power stirrer for quick homogeneous mixing. Add zinc dust gradually to the hydrolysate under stirring. Continue stirring until mixture is homogeneous. (Do not mix in reverse order. It may result in lump formation in the paint.) Strain mixture through a 30 - 60 mesh screen.

Mixing Ratio (by weight)	Hydrolysate (Liquid) : Zinc dust (Powder) 32 : 68	Induction time	None
		Pot life at 30° C	4 hours

#### APPLICATION

Application Method	Air Spray	Airless Spray
Recommended thinner	T 144	T 144
Volume of thinner	10 - 25%	10 - 25%
Nozzle orifice	2.0 - 3.0 mm	0.48 - 0.64 mm
Nozzle pressure	0.3 - 0.4 Mpa (= approx. 3 - 4 atm; 43 - 57 p.s.i)	15 MPa (= approx. 150 atm; 2100 p.s.i)

#### Special Instruction:

- Maintain constant agitation of the mixture until the batch is depleted
  - The spray gun should be at a sufficient distance from the surface to get a wet and smooth coating after application. Besides using a correct spray technique, the amount of thinner added must be carefully adjusted to secure optimum film formation. The coating must be wet and smooth just after application
  - Please refer to field guidelines for the application of Inorganic Zinc rich coatings for further details
- Not suitable for immersion in alkaline (more than pH 9) or acidic (less than pH 5) liquids without suitable topcoats

### STORAGE & PACKING

Storage : Store in a cool, dry place. Store in accordance with local regulations.  
Packing : 20 litres.

### SAFETY INFORMATION

As a general safety measure, inhalation of solvent vapours or paint mist and contact of liquid paint with skin & eyes should be avoided. Forced ventilation should be provided when applying paint in confined spaces or stagnant air. Even when ventilation is provided, respiratory, skin and eye protection is always recommended while spraying paint. Please refer our Material Safety Data Sheet prior to using the product.

**Disclaimer:** To the best of our knowledge the information provided herein is true and accurate at the date of issuance. Since we have no control over the quality or condition of the substrate or the various factors affecting the use and application of the product, we do not accept any responsibility or liability arising out of use of the product. The company reserves the right to modify data contained herein without prior notice. Any change in data would normally be followed by issue of a new data-sheet. The user should check with the nearest sales office of the company and confirm the validity of the information, prior to using the product

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