

Product Description

A two pack, solvent based, inorganic zinc rich ethyl silicate primer, containing 85% zinc by weight in the dry film. Provides excellent corrosion protection to correctly prepared steel substrates.

Recommended Uses

As a base coat for a wide range of above water organic coating schemes to greatly enhance corrosion resistance. For use at Newbuilding or Maintenance & Repair.

Product Information

color	SZ3852 Grey SZ3855 Green grey
Part B (Curing Agent)	SZC385 (zinc dust)
Volume Solids	64% ± 2%
Typical Film Thickness	50–75 microns dry (78–117 microns wet)
Mix Ratio	Part A (Base) : Part B (Curing Agent) =3.1: 1 (by volume)
Flash Point	19°C
VOC	490g/lit (EPA method 24)

Surface Preparations

All surfaces to be coated must be clean, dry and free from contamination. High pressure fresh water wash or fresh water wash, as appropriate, and remove all oil or grease, soluble contaminants and other foreign matter in accordance with SSPC–SP1 solvent cleaning.

Bared steel	Abrasive blast clean to Sa2½ (ISO 8501–1:2007).
Shop primer	Approved shop primers must be clean, dry and free from soluble salts and any other surface contaminants. Unapproved shop primers will require complete removal by blast cleaning to Sa2.5 (ISO 8501–1:2007). Consult Hilon representative for specific recommendations.
Others	Please consult Hilon representative.

Application

Application Condition	The temperature of the substrate should be minimum 5°C and at least 3°C above the dew point of the air. Good ventilation is required in confined areas to ensure proper drying. During application and curing process at relative humidity less than 55%, the curing period maybe extended. Please consult Hilon representative for details.
Mixing	The Part B(Powder) should be slowly added to the Part A(Base) whilst stirring with a mechanical agitator. Material should be filtered prior to application and the should be constantly agitated during the spraying process.
Induction period	None
Pot Life (23°C)	4 hours (Reduced at higher temperature)
Thinner	THR400

Airless Spray	Recommended Tip Range 0.38–0.53mm (15–21 thou) Total output fluid pressure at spray tip not less than 110 kg/cm ² (1560 p.s.i)
Air Spray	Recommended
Brush	Application by brush is recommended for small areas only. Multiple coats may be required to achieve specified film thickness.
Roller	Not applicable

Drying information

Temperature	5°C	15°C	25°C	35°C
Touch Dry	30 mins	10 mins	5 mins	5 mins
Hard Dry	2 hrs	1 hr	30 mins	30 mins

Drying time data are based on above temperatures and 55% relative humidity.
Consult Hilon company for details.

Overcoating Data

Temperature	5°C		15°C		25°C		35°C	
	Min.	Max.	Min.	Max.	Min.	Max.	Min.	Max.
HilonGuard 2510	18 hrs	Ext#	10 hrs	Ext#	4 hrs	Ext#	2 hrs	Ext#

#See the Definition and Abbreviation

Unit Size

13.8 litres unit: 10.44 litres part A (Base) in a 12 litres container, 3.36 litres part B (Curing Agent) in a 20 litres container.

Storage

Must be stored in accordance with national regulations. Store in dry, shaded conditions away from sources of heat and ignition.

Health And Safety

Prior to use, obtain, consult and follow the Material Safety Data Sheet for this product concerning health and safety information, and apply and use the coating according to the national state of health and safety as well as environmental protection standards and regulations.

Important note

The information in this data sheet is not intended to be exhaustive, for your reference only. The information contained in this data sheet is liable to modification from time to time in the light of experience and our policy of continuous development. Please contact us and request the latest version prior to using the product.