



PRODUCT DATA SHEET: CERAM-KOTE ORGANIC ZINC PRIMER

Description: CeRam-Kote Organic Zinc Primer is a high solids zinc rich epoxy primer for protection of structural steel in salt or weathering environments that will be topcoated with CeRam-Kote products. Not recommended for immersion service. Available in green only.

CeRam-Kote Organic Zinc Primer is 78% total zinc in the dry film. The primer offers excellent adhesion and undercutting resistance. The material is prethinned and ready to spray upon mixing. CeRam-Kote Organic Zinc Primer meets most VOC (Volatile Organic Compound) regulations.

Suggested Uses: Structural Steel and Equipment

TECHNICAL DATA

Volume Solids:	82% +/- 2%
VOC:	3.75 lb/gal (449 g/l)
Number of Coats:	One Coat (2-4 mils WFT, 50-100 microns)
Dry Film Thickness:	CeRam-Kote Organic Zinc Primer should be applied at a preferred thickness of 1-3 mils (25-75 microns) DFT. Dry film thickness in excess of 8 mils (200 microns) per coat is not recommended. Excessive film thickness may increase damage during shipping or erection.
Coverage:	Theoretical coverage is 1027 ft ² per 1 mil (25.5 m ² /l at 25 microns); 342 ft ² at 3 mils (8.4 m ² /l at 75 microns). Mixing and application losses will vary and must be taken into consideration when estimating job requirements.
Cure Time:	A one coat film of 1-3 mils (25-75 microns) DFT air dries to a film set in 4.5 hours at 77°F (25°C). Film set time is 20 hours at 40°F (4.4°C). Coating should be fully cured in 2-7 days. Cure times lengthen at lower temperatures and shorten at higher temperatures. If the coating is to be exposed to a critical service environment, coating should be fully cured before placing into service.
Surface Preparation:	Bonding strength depends on proper preparation of the surface to be protected for long-term performance of the product. The specification is a white metal (NACE 1, SSPC-SP5, Swedish Standards SA-3) finish with a 1-2.5 mil (25-62.5 microns) anchor profile. Surface preparation should be no less than a near white (NACE 2, SSPC-SP10, Swedish Standards SA 2½) finish. Cleanliness is the most important step to produce a coated surface that will perform and last. Call Freecom for surface preparation recommendations of materials such as aluminum, brass, plastic, fiberglass and/or concrete.
Mixing Ratio:	One (1) part of Part A to one (1) part of Part B. Part C is pre-measured.
Mixing:	CeRam-Kote Organic Zinc Primer is packaged in three parts: Part A (Base), Part B (Curing Agent) and Part C (Zinc Dust). Add Part B into Part A (Part A is very thick and Part B is very thin). Mix for approximately one (1) to two (2) minutes. Slowly add Zinc Dust to mix until all zinc is mixed thoroughly. Spray CeRam-Kote Organic Zinc Primer immediately after mixing to assure solids are in suspension (settling of zinc occurs immediately).
Packaging:	CeRam-Kote Organic Zinc Primer is available in one (1) gallon and two-and-one-half (2-½) gallon kits.
Pot Life & Shelf Life:	Pot life for CeRam-Kote Organic Zinc Primer is one (1) hour at 75°F (24°C) and less at higher temperatures. It is recommended that CeRam-Kote Organic Zinc Primer be used within one (1) year of delivery.
Thinning:	Not required.

- Application:** Spray apply using conventional, airless, HVLP or cup gun. **The air source must be dry.** The compressed air source should be outfitted with air dryers as needed to supply moisture-free air. Use pressure feed equipment such as high volume, low pressure equipment or Binks 2001 spray equipment with a 563CVT needle, 63CVT fluid nozzle and 63PB air nozzle. Airless: use reversible carbide tip with orifice size of 0.019-0.021 inches. Do not apply CeRam-Kote Organic Zinc Primer by roller.
- After thoroughly shaking CeRam-Kote Organic Zinc Primer, strain it with a standard paint strainer and pour CeRam-Kote Organic Zinc Primer into the spray equipment.
- Apply a coat of two (2) to four (4) mils (50-100 microns) WFT and allow sufficient time for solvent to flash off. At 72°F (22.2°C), 30-40 minutes is sufficient. Cure time is temperature dependent.
- Apply additional mils without incurring runs or sags if the finished product requires thicker coverage. Whenever possible, apply second coat in a cross-coat method.
- Climate:** Use CeRam-Kote Organic Zinc Primer only if the substrate temperature and ambient air temperature are above 40°F (4.4°C). No coating should be permitted when substrate is wet from rain or dew, when surfaces are less than 5°F (3°C) above the dew point and holding or when relative humidity is greater than 85%. Moisture will inhibit the catalyst reaction and CeRam-Kote Organic Zinc Primer will not cure or perform properly.
- Repairs:** If application of the coating is less than seventy-two (72) hours old and has not been exposed to contamination, repair by wiping with Acetone, MEK or Isopropanol (99% pure) and then re-apply CeRam-Kote Organic Zinc Primer. If contaminated or more than 72 hours old, first sand with appropriate grit sandpaper, then repeat repair process. Touch-up by roller is not recommended. Use brush for touch-up of small areas only. Use medium bristle brush for applying full strokes. Avoid rebrushing.
- Cleanup:** Purge and clean spray equipment within thirty (30) minutes of the final spray. Flush equipment with Acetone, MEK or Isopropanol (99% pure) until solvent sprays clear. Disassemble and clean equipment to manufacturer's recommendations. Material left in spray equipment will solidify and damage equipment. Use precautionary measure applicable to any catalyzed material.
- Safety:** See individual product label for safety and health data. A Material Safety Data Sheet is available upon request.

3-23-07