10600 KANAT Zn-SILICATE SHOP PRIMER

PRODUCT DESCRIPTION

10600 KANAT Zn-SILICATE SHOP PRIMER is a two pack, solvent borne zinc containing ethyl silicate shop primer with a very fast drying speed. It is designed for automatic paint application systems. It offers good corrosion resistance and does not affect weld and cutting quality. It is resistant to dry temperatures up to 540 °C.

RECOMMENDED USE

It is used as a protective shop primer in the following areas for corrosion protection of abrasive blast cleaned steel during production, transportation and stacking;

- Ship structures
- Structural steels
- Offshore structures-oil platforms
- Chemical plant tanks, pipe and heat exchangers.

It can be applied as a shop primer in paint systems demanded from C2 to C5, also CX corrosion category and Im4 immersion category according to ISO 12944-5 &

CERTIFICATES

Certificates which shows that the products do not affect the welding quality and that the welding fumes are not toxic;

- Weldability Certificate (Türk Loydu)

PRODUCT CHARACTERISTICS

Finish:
Matt

Colour:
Grey, Oxide Red

Thinner:
Kanat Thinner 0660 (Low Temp.)
Kanat Thinner 0665 (High Temp.)

Mixing Ratio (by volume)
6,09 Parts A Comp.+ 8,92 Parts B Comp.

Mixed Product;
Volume Solids (%)
28±2

Density (g/ml)
1,37±0,10

Spreading Rate (m²/l)
18,67 (15 microns DFT)

Flash Point
9°C

VOC (Volatile Organic Content)
600 g/l

Application Methods
Airless spray Conventional spray

Pot Life (20°C)
16 hours

DRYING SCHEDULE(*)

(15 microns dry film thickness)

	Dry to Touch	Hard Dry	Dry to Over Coat Minimum
5°C	8-10 minutes	12-15 minutes	-
15°C	4-6 minutes	7-10 minutes	-
25°C	1-3 minutes	3-5 minutes	-
35°C	1-2 minutes	2-3 minutes	-

Drying values are valid for defined dry film thickness and minimum 50% preferably above 65% relative humidity. Complete curing: 24 hours (25°C and 80% RH). Below 80% relative humidity, curing time delays. As film thickness increases, curing time may be longer. Ventilation decreases curing time.

Curing time to be verified by MEK-test (ASTM D 4752:2010). Ready for recoating if complete curing is achieved.

PACKAGING

One kit of **10600 KANAT Zn-SILICATE SHOP PRIMER** is 15,1 l.

One pail of **10600 KANAT Zn-SILICATE SHOP PRIMER** component A is 6,09 l.

One can of **KANTEX HARDENER 0507** component B is 8,92 l.

SHELF LIFE

Part A–1 year, Part B–4 months maximum shelf life when the material is stored indoors at 25°C in unopened original containers. Store the product in a dry, well ventilated surround. Shelf life is reduced at temperatures above 25°C. If part B is gelled or if the mixed product causes gels, the shelf life is exceeded, do not use the material.

HEALTH/SAFETY PRECAUTIONS

Refer to the MSDS sheet prepared according to EU directives before use.

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SURFACE PREPARATION

Surfaces must be dry, clean, free of oil, grease and other foreign material.

New Steel Surfaces: To ensure good adhesion and zinc-steel contact;

• Remove surface defects of welding and dirt from the surface by proper means.

• Use mechanical cleaning for welding defects.

• Clean oil and grease with solvent conforming to SSPC-SP1.

• Surfaces should be grit or grit/shot blasted to near-white metal surface cleanliness according to SSPC-SP10 or ISO 8501-1 minimum Sa 2½, preferably Sa 3. Blast profile on steel should be 50–75 microns in depth.

• Remove blast residue by proper means.

• Depending on ambient conditions, blasted surfaces must be primed in the same day after blasting.

Previously Painted Surfaces: Remove all the old paint to bare steel by abrasive blasting.

APPLICATION PROCEDURES (Mixing Procedure)

This is a two-component paint. Do not mix more material than you plan to use within the listed pot life. Complete containers must be mixed at one time. DO NOT MIX PARTIAL QUANTITIES FROM CONTAINERS OR PROPER COMPONENT RATIOS MAY NOT BE OBTAINED. Prior to mixing, components A Base and B Hardener should be at room temperature. Combine 8,91 parts by volume of part B (silicate solution) with 6,09 parts by volume of part A (zinc paste). Before mixing the two components stir part A (zinc paste). Add part B (silicate solution) to part A (zinc paste) under continuous stirring with a power mixer until a homogenous mixture is obtained. Add thinner if necessary and wait 10-15 minutes for induction before use. Mixed product must be used within 16 hours (20ºC).

MIXING RATIO

Base 10600 : Curing Agent 0507
0,7 : 1 by volume

APPLICATION CONDITIONS

For the best results;

Temperature must be more than 0°C during the application and/or the curing process.

Relative Humidity: Minimum 50% preferably above 65% relative humidity during application is required.

Surface Temperature: At least 3°C above dew point,

Good ventilation is required during application.

APPLICATION

Apply paint at the recommended film thickness and spreading rate. Avoid spray dust and high film thicknesses. Recommended film thickness is 15-20 microns measured on unblasted steel panel. There is no limitation for maximum recoating interval.

When using spray application, use a 50% overlap with each pass of the gun to avoid holidays, bare areas and pinholes. If necessary,cross spray at a right angle.

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CLEAN UP

KANAT THINNER 0644, KANAT THINNER 0660, KANAT THINNER 0665

APPLICATION EQUIPMENT

(The table is a guide for 20°C)

Application Equipment	Airless Spray	Conventional Spray
Thinner maximum	30%	30%
Pressure minimum (bar)	80	2,5
Nozzle(inch)	0,015-0,023	1,6-2,0

PRECAUTIONS

• Thinner amount shall be adjusted according to paint equipment adjustment. Surface appearance can be controlled on a glass panel. Recommended thinner ratio is 10-30% .

• For recoating complete curing must be achieved. It can be checked by rubbing the coating with a **KANAT THINNER 0693** soaked rag according to ASTM D 4752:2010.

• At low humidity, to accelerate curing of the coating, the surface can be sprayed with water 24 hours after application until complete curing of the coating is achieved.

• Long overcoating intervals may lead to zinc corrosion products (white rust). Remove white rust with a stiff brush and clean the surface with appropriate detergent and/or pressurized fresh water. Avoid mechanical cleaning that would decrease DFT of the film.

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