

50050 KANTHERM ZINC PRIMER

PRODUCT DESCRIPTION

50050 KANTHERM ZINC PRIMER is a silicone resin based, one component, air drying micronized zinc dust containing primer curing with heat. It has outstanding resistance to severe weathering. It provides cathodic protection if film is damaged. Service temperature range is 0-400°C dry temperature.

RECOMMENDED USE

In combination with suitable topcoat systems, it is used as a primer on heated steel surfaces for;

- Exteriors of furnaces.
- Exteriors of steel chimneys.
- Exteriors of exhaust systems and gas channels.
- Other exposures in industrial areas subjected to high temperatures. It can be used as onecoat coating on insulated surfaces.

PRODUCT CHARACTERISTICS

Finish: Matt	Spreading Rate (m ² /lt) 9,2 (50 microns DFT)
Colour: Grey	Flash Point 30°C
Thinner: Kanat Thinner 0672	VOC (Volatile Organic Content) 450 g/l
Volume Solids (%) 46±2	Application Methods Airless Spray, Roller
Density (g/ml) 1,97±0,10	

DRYING SCHEDULE(*)

(50 microns/2 mils film thickness)

	Dry to Touch	Hard Dry	Dry to Over Coat Minimum
5°C	7 hours	–	9 hours
15°C	5 hours	–	7 hours
25°C	3 hours	–	5 hours
35°C	2 hours	–	4 hours
170-200°C	–	1 hour	–

Drying values are valid for defined dry film thickness and below 80% relative humidity.

(*) Drying time depends on temperature, humidity and film thickness.

PACKAGING

One pail of **50050 KANTHERM ZINC PRIMER** is 14 L.

SHELF LIFE

1 year when the material is stored in a cool and dry place in unopened original containers.

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: Surfaces should be blasted to near-white metal surface cleanliness according to SSPC-SP10 or ISO 8501-1 Sa 2½. Blast profile on steel should be 20-30 microns when used alone as onecoat at 30-40 microns DFT and 40-50 microns when used as the primer of 75-90 microns DFT heat resistant paint system. Depending on ambient conditions, blasted surfaces must be primed in maximum 5 hours with **50050 KANTHERM ZINC PRIMER**.

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

The Surfaces Other Than Steel: Contact KANAT Project Group for the galvanized, aluminium, plastic surfaces.

Rusty Surfaces: Contact KANAT Project Group.

Touch-up: Remove all dust, dirt and other foreign material and keep dry. Abrade the surface to Sa 2½ according to ISO 8501-1 level and complete the touch-up application as soon as possible.

This is a one-component paint. Add thinner if necessary and homogenize the mixture with a powermixer and wait 10-15 minutes before use. Continuous stirring against zinc dust settling is required during application.

APPLICATION PROCEDURES (Mixing Procedure)

For the best results;

Air Temperature : 5°C minimum, 35°C maximum.

Surface Temperature : At least 3°C above dew point, 5°C minimum and 45°C maximum.

Relative Humidity: 80% maximum.

Good ventilation is required during application.

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APPLICATION CONDITIONS

Stripe coat all crevices, welds and sharp angles. Apply paint at the recommended film thickness and spreading rate. Application of coating above maximum or below minimum recommended spreading rate may adversely affect coating performance. 24 hours drying is recommended before the second coat for best results. Do not apply more than 100 microns (4 mils) WFT to prevent sagging. 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.

APPLICATION

Paint system shall not be exposed to high temperatures before full drying (at least 24 hours at 200°C). Paint film should be cured at 170-200°C for 1 hour to acquire high temperature resistance. Painted small parts shall be cured in an appropriate furnace. Painted parts in the plants shall be cured by adjusting service temperature to 170-200°C for 1 hour after full drying.

CLEAN UP

KANAT THINNER 0644, KANAT THINNER 0672

APPLICATION EQUIPMENT

(The table is a guide for 20°C)

Application Equipment	Airless Spray	Roller/Brush
Thinner maximum (% by weight)	%5	%7
Pressure minimum (bar)	150	—
Nozzle (inch)	0,017-0,025	—

PRECAUTIONS

- Contact KANAT Project Group in case surface preparation is not applicable either by blasting or mechanical.
- DFT of the paint system should not exceed 75 microns for maximum high temperature resistance.