

## 11390 KANEPOX ZINC RICH HCX

### PRODUCT DESCRIPTION

**11390 KANEPOX ZINC RICH HCX** is an epoxy based, two component micronized zinc dust containing primer with outstanding resistance to severe weathering. It provides cathodic protection if film is damaged. Zinc content in the dry film conforms to SSPC-Paint 20, Level 1 and ISO 12944 standards.

### RECOMMENDED USE

In combination with suitable topcoat systems, it is used as an anti-corrosive primer on steel surfaces of;

- Tank exteriors in industrial plants.
- Bridges and dams.
- Other exposures subjected to high humidity, salty or fresh water.

### PRODUCT CHARACTERISTICS

Finish: Matt	Density (g/ml) 2,88±0,10
Colour: Grey	Spreading Rate (m <sup>2</sup> /l) 11,00 (50 microns DFT)
Thinner: Kanat Thinner 0620 (Low Temp.) Kanat Thinner 0625 (High Temp.)	Flash Point >21°C
Mixing Ratio (by volume) 8,33 Parts A Comp.+ 1,67 Parts B Comp.	VOC ( Volatile Organic Content) 389 g/l
Mixed Product; Volume Solids (%) 55±2	Application Methods Airless spray
	Pot Life (20°C) 6 hours

### DRYING SCHEDULE(\*)

50 microns/2 mils film thickness)

	Dry to Touch	Hard Dry
5°C	4,5 hours	9 hours
15°C	3 hours	6 hours
25°C	2 hours	4 hours
35°C	1 hour	2 hours

Drying values are valid for defined dry film thickness and below 85% relative humidity.

Fully Cured: 7 days (20°C)

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

### PACKAGING

One kit of **11390 KANEPOX ZINC RICH HCX** is 10 l.

One pail of **11390 KANEPOX ZINC RICH HCX** component A is 8,33 l.

One can of **KANEPOX HARDENER 0361** component B is 1,67 l.

### SHELF LIFE

Part A–1 year, Part B–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 40–70 microns in depth. Depending on ambient conditions, blasted surfaces must be primed in maximum 5 hours with **11390 KANEPOX ZINC RICH HCX**. Remove all the old paint to bare steel by abrasive blasting.

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

**Touch-up:** Remove all dust, dirt and other foreign material and keep dry. Surfaces should be blasted to near-white metal surface cleanliness according to SSPC-SP10 or ISO 8501-1 Sa2 ½. **11390 KANEPOX ZINC RICH HCX** can be safely used for touch-up. If it is practically impossible to blast the surface, clean the surface to St 2-St 3 level mechanically according to ISO 8501-1 and complete the touch-up application with a surface tolerant primer.

### 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 1,67 parts by volume of Part B Hardener with 8,33 parts by volume of Part A Base. Homogenize the mixture with a power mixer, add thinner if necessary before use. Mixed product must be used within 6 hours (20°C). Continuous stirring against zinc dust settling is required during application.

### MIXING RATIO

Base 11390 : Curing Agent 0361  
5 : 1 by volume

### APPLICATION CONDITIONS

For the best results;

Temperature must be more than 5°C during the application and/or the curing process.

**Surface temperature:** At least 3°C above dew point.

**Relative humidity:** 85% maximum.

Good ventilation is required during application.

### APPLICATION

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. 1-2 hours drying is recommended before the second coat for best results. There is no limitation for maximum recoating interval provided that surface is free of oil, grease and other foreign matter.

Do not apply more than 175 microns (7 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.

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### CLEAN UP

**KANAT THINNER 0644, KANAT THINNER 0620,  
KANAT THINNER 0625**

### APPLICATION EQUIPMENT

(The table is a guide for 20°C)

Application Equipment	Airless Spray
Thinner maximum	4-5%
Pressure minimum (bar)	180-220
Nozzle(inch)	0,019-0,023

### PRECAUTIONS

- Contact KANAT Project Group in case surface preparation is not applicable either by blasting or mechanical.
- Maximum 75 microns DFT should be applied to ensure good adhesion.
- Long overcoating intervals may lead to zinc corrosion products (white rust). Remove white rust with brush and clean the surface with appropriate detergent and/or pressurized fresh water. Avoid mechanical cleaning that would decrease DFT of the film.
- Condensation forming on the coating during early times of curing may result in longer cure times, solvent entrapment, premature failure, discoloration or a surface haze or blush that must be removed before recoating.

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