Construction

Technical Data-Sheet
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Friazinc® R

Epoxy zinc-rich primer for steel

Product description	2-component, highly pigmented zinc-rich primer of low solvent content, based on epoxy resin.
Fields of application:	Friazinc R offers a wide range of applications and is especially suitable for objects subjected to heavy mechanical wear, e.g. weirs, interior of pressure pipe lines, gates, penstocks, etc. With up to 20 microns film thickness Friazinc R may also be employed as weldable shop coating. An approval is available upon request.
Properties:	Friazinc R cures very quickly, is resistant to water and weathering, abrasion and barnacles, mechanical wear.

Product data

Colour shades:	Zinc grey
Packaging:	15 kg and 7 kg net.
Shelf life:	In originally sealed containers in a cool and dry environment: min. 1 years.

Systems

Coating systems:	Without top coat: 2 x Friazinc R For priming under top coat: 1 x Friazinc R Weldable shop coating: 1 x Friazinc R, dry film thickness 20 microns Suitable top coatings: Universally recoatable with 1- and 2-component products of Sika Korrosionsschutz GmbH
Surface Preparation:	Steel: blast cleaning to Sa 2½ according to EN ISO 12944, part 4, free from dirt, oil and grease.

Technical data

Material consumption:

Specific gravity liquid	Solids content approx. %		Theoretical thickness with 100 g/m² consumption		Material-consumption for medium dry film thickness of	
approx. kg/L	by vol.	by weight	wet microns	dry microns	microns	approx. kg/m²
2,8	67	89	36	24	20 60 80*)	0,083 0,250 0,335

*) for spray application
Apart from small areas the dry film thickness should not exceed 150 microns per layer

Mixing ratio in parts by weight:
(Components A : B)
94 : 6

Resistance:
The fully cured material is resistant to weathering, water and mechanical wear.

Temperature:
Dry heat up to approx. +150°C, short term up to maximum +180°C.
Damp heat up to approx. +50°C.

Hints on application

Preparation of material:
Stir Component A very thoroughly using an electric stirrer. Add component B and mix both components very thoroughly (including sides and bottom of the container).

In case of weldable shop coating add approx. 12% Thinner K.

Application method:
The method of application has a major effect on achieving uniform thickness and appearance. Spray application will give the best results. The indicated dry film thickness is easily achieved by airless spray and by brush. Adding solvents reduces the sag resistance and the dry film thickness. In case of application by roller or brush, additional applications may become necessary to achieve the required coating thickness, depending on type of construction, site conditions, colour shade etc. Prior to major coating operations a test application on site may be useful to ensure the selected application method will provide the requested results.

By brush:

Conventional high pressure spraying:
nozzle size 1,7 – 2,5 mm; pressure 3 – 4 bar.

Airless-spraying:
With a spray pressure in gun of min. 180 bar;
nozzle size 0,38 – 0,53 mm (0,015 – 0,021 inch); spraying angle 40° - 80°

Application temperature:
surface: min. +5°C
material: min. +5°C

Potlife:
at 20°C approx. 8 hours

Drying degree 6 (DIN 53150):

Material Thickness	+5°C after	+23°C after	+40°C after	+80°C after
20 microns	1 hour	45 min	30 min	20 min
60 microns	3 hours	2½ hours	1½ hours	45 min

Waiting time between coats:	Between Friazinc R, Icosit EG 1 and Icosit Poxicolor Plus: min.: 4 hours max.: unlimited Between Friazinc R and other top coats: 1-2 days max.: unlimited In case of intermediate storage possible contamination must be removed before further coats may be applied.
Final drying time:	Depending on film thickness and temperature full hardness is achieved after 1-2 days.
Cleaning of implements:	Thinner K

Important notice

Directive 2004/42/CE (Decopaint):	For product category IIA / j, Type SB, the maximum permissible content of VOC as per directive 2004/42/CE is 500 g/litre (limit 2010). The maximum content of Friazinc R remains below 500 g/litre VOC".
Value Base	All technical data stated in this Product Data Sheet are based on laboratory tests. Actual measured data may vary due to circumstances beyond our control.
Local Restrictions	Please note that as a result of specific local regulations the performance of this product may vary from country to country. Please consult the local Product Data Sheet for the exact description of the application fields.
Health and Safety Information	For information and advice on the safe handling, storage and disposal of chemical products, users should refer to the most recent Material Safety Data Sheet containing physical, ecological, toxicological and other safety-related data.
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