

**DESCRIPTION**

A premium quality zinc-based anti-corrosive epoxy primer, ideal for applications requiring extra corrosion and chemical resistance, and mechanical durability. ZnKoat delivers equal or better cathodic protection than zinc dust and provides an additional barrier of protection. For best results use the complete NexShield coating system.

**FEATURES**

With a platelet-like structure, the zinc flake provides a larger surface area the typical zinc dust allowing for more favorable performance characteristics:

- Over 4000 hours salt spray on steel
- Greater flexibility compared to conventional zinc dust
- Improved cohesion
- Smoother surface & improved overcoat properties
- No intermediate coat necessary

The full flake 2D contact between the zinc flakes gives a higher current density that improves the cathodic nature of the coating. Less zinc in the dry film results in a greater amount of resin, which protects the zinc particles from corrosive forces, thus reducing the problem at the source. As the zinc flakes overlap each other when they are laid down, this barrier is enhanced.

**QUICK REFERENCE**

Mix Ratio	<b>4:1</b> (Resin to Catalyst)
Catalyst	<b>8015C</b> ZnKoat Catalyst
Recommended Thickness	<b>4.0 - 6.0 mils</b> (100 - 150 microns)
Theoretical Coverage	<b>864 ft<sup>2</sup>/usg @ 1.0 mil DFT</b> (21 m <sup>2</sup> /L @ 25 microns DFT)
Thinner / Clean-up	<b>Q650</b> Universal Reducer

**PRODUCT DATA**

Type	Zinc Flake Epoxy Primer
Gloss	Matte
Colour	Zinc Grey
VOC (mixed)	420g/L
Zinc content	45% mixed (dry film)
Weight Solids (mixed)	71.0 ± 2.0%
Volume Solids (mixed)	53.0 ± 2.0%
Viscosity (mixed)	86 KU
Flash Point	23°C (73°F)
Shelf Life	1 year from shipment

These technical specifications are based on results from product 155ZK.

Last updated September 2013

**APPLICATION GUIDE**

Surface	Steel, galvanized, aluminum
Pot Life	6 hours @ 25°C (75°F)

*Dry time at 75°F (24°C) 50% relative humidity*

**Cure times**

To Touch	10 - 20 minutes
Tack Free	< 1 hour
To Recoat	>1 hour < 72 hours
Hard	24 hours

**PERFORMANCE**

Corrosion Resistance	<b>4000+ hours salt spray</b> @ SSPC SP6 with 4-6mils DFT
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**APPLICATION EQUIPMENT**

Conventional Air Spray	Reduce with Q650 as required
Air Assisted Airless	Reduce with Q650 as required
Airless	Reduce with Q650 as required
Electrostatic Spray	Some adjustments for polarity may be necessary to maximum of 2 mohms
Brush & Roll	Use as described within specified pot life

**SURFACE PREPARATION**

All surfaces must be clean and free from dirt, oils, rust, flaking paint, and other contaminants. Ensure a sandblast quality of SSPC-SP6 (NACE 2) Commercial blast or for best results SPC-SP10 (NACE 2) Near White blast or better. Proper surface preparation will enhance the performance of the coating system.

**Important:** ZnKoat should be topcoated in the 72 hour window to ensure good intercoat adhesion, or sanding will be necessary. Temperatures in excess of 80°F can shorten this time due to an accelerated cure response. Outside this limit the surface should be sanded and cleaned prior to top coating.

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**APPLICATION INSTRUCTIONS**

**THINNING:** Thinning may facilitate flow depending on application equipment, use up to 10% total by volume. Only use the specified thinners approved by the manufacturer. Be aware that additional reduction (solvent) will increase the VOC levels of the mixed coating. Always know VOC laws for coating application in your area and follow regulated restrictions.

**APPLICATION:** Mix thoroughly before use, A to B ratio is 4:1. Combine 1 gallon "A" ZnKoat Zinc Flake Primer with 1 quart "B" 80155C and mix well. Apply when surface and air temperature are between 35°F-100°F (7°C-38°C) Ensure surface temperature is at least 5°F (3°C) above the dewpoint.

**DRYING TIME:** See application data for typical dry times. Low temperature, high humidity, poor ventilation and thick films will slow drying.

**CLEAN UP:** Flush mixed material from pot and lines immediately after use. Clean up paint tools or spills immediately with recommended thinner, carefully observing cautions on paint and thinner labels. Dried paint may be removed by scraping.

**SAFETY & STORAGE**

For industrial use only by professional applicators. Always wear appropriate safety equipment and observe proper handling techniques.

Refer to *Material Safety Data Sheet* for proper health and safety information. Store in cool, dry, and secure location. Consult your Niskoat representative for more information.

**GENERAL PURPOSE SYSTEM SPECIFICATIONS**

<b>Sandblast</b>	SSPC-SP6 (NACE 3) Commercial Blast or SSPC-SP5 (NACE 1) Near-white Blast
	<b>155ZK</b>
<b>Prime</b>	ZnKoat Epoxy Primer
	<b>4.0 - 6.0 mils DFT (100-150 microns)</b>
	<b>5xxNX - Colour</b>
<b>Topcoat</b>	NexShield HS Urethane Topcoat
	<b>2.0 - 3.0 mils DFT (50-75 microns)</b>
	<b>500NX - Clear</b>
<b>Clear Coat (optional)</b>	NexShield HS Urethane Topcoat
	<b>1.0 - 2.0 mils DFT (25-50 microns)</b>
<b>TOTAL SYSTEM</b>	<b>7.0 - 11.0 mils DFT (175-275 microns)</b>
	<b>Q650</b>
<b>Thinner</b>	Universal Reducer



**NISKU**  
**INDUSTRIAL COATINGS**  
2109 - 5th Street, Nisku AB T9E7X4

toll free: 1 866 361 9696  
ph: 780 955 9696  
fx: 780 955 7676  
www.niskoat.com

*IMPORTANT – The information contained in this data sheet pertains to material currently offered and represents the results of Laboratory evaluation and is intended as a guide. Since the customer's application requirements are not under our control, Nisku Industrial Coatings Ltd. and Niskoat Ltd. cannot make any warranties or guarantees for the results obtained.*