

TYPE: **A RAPID CURING TWO-PACK, MULTI-MONOMER ISOPHTHALIC POLYESTER GLASSFLAKE COATING**

SUGGESTED USE: Zipcoat provides durable corrosion protection in aggressive atmospheric conditions and some immersion environments. It has excellent application characteristics and can be applied in single coats, giving good edge coverage, when spray applied. Zipcoat has good gloss and cosmetic appearance. It has rapid cure times and will cure at temperatures below freezing. Zipcoat may be used for structural steel, bridges, piling, jetties, ships hulls, decks, ballast tanks, pipelines and other immersed marine environments.

LIMITATIONS: Unsuitable for immersion service in many chemical and aggressive service environments. Temperature limit in Immersion service is 50°C, and in non-immersed environments 90°C.

HEALTH & SAFETY Before handling or using this product the material **safety data sheet should be read** and all precautions observed.

SURFACE PREPARATION: **Metals:** Grit blast to SIS 05 5900 SA 2.5 standard. (For full details refer to Corrocoat Surface Preparation Specification SP1.)
Concrete: Priming is required. See Corrocoat Surface Preparation Specification SP5.

APPLICATION: Airless Spray Pump with minimum 30:1 ratio and output of at least 3 litres per minute. The pump should be fitted with leather seals and all fluid filters removed. Use 10mm diameter (3/8") Nylon lined spray hose with a short 6mm (1/4") whip end and large bore contractor type Spray Gun fitted with swivel connector. An 18-25 thou reversible tip is recommended. Spray tip size and fan pattern can vary and should be selected to suit the nature of the work. Fluid pressure should be circa 2500 psi depending on temperature, spray line length etc. (Refer to Application Data Sheet).

Intended primarily for spray application, Zipcoat may be applied by brush or short haired roller.

POT LIFE: Pot life **will vary significantly** with temperature but generally 50-60 minutes **using P2 catalyst.**

Temperature	4°C	20°C	30°C	30°C*	40°C*
Pot life	4.5 Hrs	55 mins	32 mins	52 mins	40mins

THINNERS: The performance of this product **will be adversely affected** by the use of solvent thinners.

Thinning may be achieved by the addition of **not more than 5%** by volume of styrene to the base. For normal applications it is not anticipated that any addition of styrene will be necessary. Addition of styrene may increase tack free times and hold-up will be affected. This should be checked before application.

PACKAGING: 10 and 20 litre composite kits. (Other kit sizes available on request).

CATALYST/
HARDENER TYPE: **Organic peroxide at 2% by weight.**

STORAGE LIFE:	Base: 12 months stored at temperatures below 24°C away from heat sources and direct sunlight. During extended storage i.e. greater than 3 months, it is recommended that the drums be periodically inverted. Frequent temperature cycling will shorten storage life and may cause condensation polymerisation. Hardener: 6 months at 24°C. (Note Hardener may become hazardous if stored at high ambient temperatures. See separate HS Data Sheet).
COLOUR AVAILABILITY:	Off White or Light Grey are standard. Other colours including green, red oxide, yellow and black are available on request. Price subject to colour and quantity. Note: This product is formulated to give optimum corrosion resistance. Due to the nature of the polymerisation process of this product, it is not possible to guarantee colour stability or matching.
VOLUME SOLIDS:	Nominally greater than 99%. This material contains volatile liquid monomers, convertible to solids. In consequence volume solids and WFT/DFT ratios will vary, dependent on polymerisation conditions. As guidance, a wet film of 500microns will normally achieve 400microns DFT.
RECOMMENDED DFT:	500microns non immersed, 800 microns minimum in immersion
PRACTICAL COVERAGE RATE:	Approximately 0.7 litre/m ² at 500 microns DFT. Note: This information is given in good faith but consumption may increase dependent upon environment conditions, geometry, nature of work undertaken and the skill and care of application. Corrocoat accept no responsibility for any deviation from these values.
SPECIFIC GRAVITY:	Base: 1.24 gcm ⁻³ Hardener: 1.1 gcm ⁻³
FLASH POINT:	29°C
MIXING RATIO:	98:2 base to hardener (P2) by weight/weight. Observe safety requirements. At high ambient temperatures inhibitor may be used to extend pot life but should be added to the base and thoroughly mixed before addition of the hardener.
HARDNESS:	Approximately 50 Barcol, higher values are possible in optimum conditions
ELONGATION TO BREAK:	Approximately 1.5%
ABRASION RESISTANCE:	201 mg loss/1000 cycles/1000gm load. H18 wheels.
TENSILE STRENGTH:	272 kg/cm ²
OVERCOATING:	Where multiple coats are required, overcoating may take place as soon as the previous coat has gelled and still tacky. Maximum overcoating time is 72 hours at 20°C. Overcoating times can be extended at low temperatures but will reduce significantly at higher ambient temperatures and/or in strong sunlight.
COATING ADHESION:	295 kg/cm ²
CURE TIME:	Tack free in less than 3 hours, full cure 4 days at 20°C. Tack free and full cure values will vary subject to ventilation and temperature. The product may be put into non aggressive service once tack free.
CLEANING SOLVENT:	Normal solvents are ineffective in removing Zipcoat resin from spray pumps and lines. Zipcoat cleaner should be used within the pot life of the product to avoid equipment damage. Observe safety regulations.

All values are approximate. The physical data contained on this sheet will vary dependent upon the effectiveness of cure which is variable with application and environment conditions. The figures given are average values for well cured material.

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