

TYPE: An epoxy glassflake coating, intended for a single coat application.

SUGGESTED USE: Zip E will provide cost effective, durable protection in aggressive atmospheric conditions and aquatic immersion environments. Zip E has excellent application characteristics and edge coverage in single coats. Zip E has good cosmetic appearance and gloss. Zip E may be used for structural steel, bridges, pilings decks, externals of process vessels/pipelines, jetties, ships hulls and other marine environments.

LIMITATIONS: Unsuitable for immersed service in many solvents and chemical service environments. Temperature limit immersed is 50°C with a post cure (45° with an ambient temperature cure), no immersed limit is 90°C).

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

SURFACE PREPARATION: **Metals:** For best results Grit blast to SIS 05 5900 SA 2.5 standard. (For full details refer to Corrocoat Surface Preparation Specification SP1.) Zip E can also be applied to mechanically prepared or water blasted surfaces or where Plasmet ZF has been used as a primer.

Concrete: Priming is required, see Corrocoat Surface Preparation sheet SP5, use Plasmet ECP as the primer.

APPLICATION: Airless Spray pump minimum 45:1 ratio, with an output of at least 4 litres per minute. The pump should be fitted with a leather/Teflon seal combination and all fluid filters removed. Use nylon lined 10mm (3/8") internal bore spray line with a short 6.5mm (1/4") whip and a large bore spray gun fitted with a swivel connector. 17 to 23 thou reversible spray tip is recommended. Spray tip and fan pattern will vary and should be selected to suit the nature of the work. Fluid pressure approximately 4,000PSI depending on temperature, spray line length, etc. Zip E should not be applied or used at temperatures below 5°C.

Zip E may be applied with a brush or short haired roller.

POTLIFE: Generally 70 –90 minutes using the standard hardener at 20°C. Pot life **will vary significantly** with temperature.

Temp °C	10°C	20°C	25°C	30°C	35°C
Gel Time	180 min	84 min	73 min	57 min	42 min

THINNERS: The performance of this product will be adversely affected by the use of solvent based thinners. Under normal application conditions it is not anticipated that any thinners will be required with this product

PACKAGING:	5, 10 and 20 litre composite kits. (Other sizes may be available upon request).
CATALYST/ HARDENER TYPE:	Modified Amine Adduct
STORAGE LIFE:	2 years minimum in unopened tins, stored at 5°C-40°C.
COLOUR AVAILABILITY:	White and light grey as standard. Other colours available on request, price of material 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 matching or colour stability. Where colour stability is of paramount importance, it is recommended that Zip E is over coated with Corrothane AP1.
RECOMMENDED DFT:	Dependent upon intended use, geometry of work and service conditions. Zip E is normally applied to achieve DFT's of 200 to 1,000 microns by applying at 10% greater WFT's. Single coat application is preferred but multiple coats may be used to achieve the required DFT, refer to data on overcoating times.
VOLUME SOLIDS:	Greater than 95 %.
PRACTICAL COVERAGE RATE:	Approximately 0.6 litres/m ² at 500 microns DFT. Note: This information is given in good faith but consumption may increase dependent on the environmental 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:	Mixed: 1.20 g/cm ³
FLASH POINT:	Base: 56°C
MIXING RATIO:	76.7:23.3 Base to Hardener by weight / weight. Plural Spray Grade 74.97:25.03
ELONGATION TO BREAK: (BS 6319, part7)	4%
IMPACT RESISTANCE: (BS 3900 part E3)	14 Joules
VOC LEVEL:	7.5 g / litre
ADHESION: (ASTM D 4541)	Greater than 15 MPa

OVERCOATING:

Where multiple coats are required, overcoating may take place after 3 hours at 20°C. Wet on wet applications are acceptable. The maximum overcoating time is 72 hours at 20°C. Overcoating times will reduce significantly at higher temperatures **and/or** in strong sunlight. The minimum overcoating time at 10°C is 24 hours, refer to Corrocoat Technical Services for overcoating instructions below 10°C.

TACK FREE TIME:

Temp °C	10°C	20°C	25°C	30°C	35°C
Tack-free time	<12 hrs	4hrs 30min	4hrs	3hrs 30min	2hrs 45min

CURE TIME:

Tack-free in less than 3.5 hours, full cure 4 days at 20°C. Tack-free and full cure values will vary subject to ventilation and temperature.

CLEANING SOLVENT:

For best results use Corrocoat Epoxy Equipment Cleaner

Reviewed 07/2006
 Revised 07/2010
 Reviewed 02/2014 (No change)
 Reviewed 05/2016 (No change)
 Revised 03/2017
 Revised 09/2017
 Revised 04/2018
 Revised 05/2018

All values are approximate. Physical data is based on the product being in good condition before polymerisation, correctly catalysed and full cure being attained. Information regarding application of the product is available in the Corrocoat manual. Should further information be required, please consult Corrocoat Technical Services. Unless otherwise stated, all data is quoted at 20°C .