

REC ZINC GUARD 1800

EPOXY ZINC-RICH

DESCRIPTION

REC ZINC GAURD 1800 is a rapid recoat primer that provides excellent corrosion protection and under cutting protection.

PRIMARY APPLICATIONS

Excellent for use in industrial, coastal, marine and freshwater environments. May be used on structural steel, steel tanks, offshore platforms, barges refineries, petrochemical plants, power plants, rail cars, pulp & paper mills and other areas as recommended. May also be used to field touch-up inorganic zinc and/or provide galvanic protection for properly prepared steel substrates.

FEATURES/BENEFITS

- High load epoxy zinc primer
- Provides excellent galvanic protection
- Meets Class “B” slip co-efficient and creep resistance criteria for use on bolted connection faying surfaces
- Excellent under cutting resistance
- VOC compliant
- Easy to topcoat
- Rapid and extended recoat windows
- Excellent adhesion to hand tool cleaned surfaces (SSPC-SP 11)

TECHNICAL INFORMATION

Drying Time		Depends on the temperature and specific site condition	
Density		1.48 Kg/L	
Shore A Hardness		94	
Impact Resistance (ASTM D 2794) (Direct Impact)		80 in-lbs. (Passed)	
Temperature resistance (dry)		Continuous	Non-continuous
		121°C	148°C
Adhesion (ASTM D 4541)		3912 psi	
Theoretical volume solids of mixed material (ASTM D 2697)		66% $\pm$ 1%	
Theoretical coverage of mixed gal. (25 microns)		98.48 m ²	
Volatile Organic Content	Unthinned	0.288 kg/L (2.4 lbs./gal)	
	Thinner @ 12% by volume	0.395 kg/L (3.3 lbs./gal)	
Zinc in dry film		80%	
Mixing Ratio (A: B)		4:1	
Pot Life		Six hours (35°C) *Decreases with rise in temperature.	

PERFORMANCE DATA

Salt Spray (ASTM B117) 7200 Hours	No blistering or rusting is observed on the plane surface.
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QUALIFICATIONS

REC ZINC GAURD 1800 meets Class “B” requirements for slip co-efficient and creep resistance as set forth in the Specification for Structural Joints using A325 or A490 Bolts, in accordance with Research Council on Structural Connections.

RESISTANCE

REC ZINC GAURD 1800 prevents rusting of steel in a corrosive environment with a pH range of 5 to 9. Top coats should be used for pH beyond these limits. When top coated, **REC ZINC GAURD 1800** effectively reduces undercutting from a damaged area. The following is a guide to the proper selection:

Exposure	Immersion	Spillage	Splash / Fumes
Acidic	Not Recommended	Good*	Excellent*
Alkaline	Not Recommended	Good*	Excellent*
Solvents	Not Recommended	Good*	Excellent*
Salt water	Excellent*	Excellent*	Excellent*
Water	Excellent*	Excellent*	Excellent*

*With suitable top coat

DIRECTIONS FOR USE

SURFACE PREPARATION:

Remove oil and grease from the steel surface with solvent or a commercial cleaner, which does not leave a residue, according to SSPC-SP1. Abrasive blast to a Commercial finish per SSPC-SP 6 to obtain a 1-3 mil blast profile. For immersion, abrasive blast to a Near-white finish per SSPC-SP 10 to obtain a 1-3 mil blast profile. For field touch-up, prepare the substrate according to SSPC-SP 11. Use primer on the surface before applying the **REC ZINC GUARD 1800**.

MIXING:

Power mix Part A and Part B components, then slowly blend REC ZINC GUARD Filler into the Part A and mix until uniform. Avoid forming a dust cloud while adding powder.

Note: The Part B forms a soft crust on the surface, which is readily dispersed with power mixing. After mixing, strain through a wire screen or cheese cloth. Mix Part A and Part B components, then slowly blend REC ZINC GUARD filler into the Part A and mix until uniform. Avoid forming a dust cloud while adding powder. Do not mix partial kits.

THINNING

Thinning is not required for most applications. However, in hot or windy conditions, **REC ZINC GUARD 1800** may be thinned at a maximum rate of 12-20% of coating depending on the specific condition.

Table: Temperature Limits for REC GUARD ZINC 1800

	Material	Surface	Ambient
Minimum	22°C	22°C	22°C
Maximum	40°C	49°C	49°C

Special thinning and application procedures are required outside these temperature ranges. **REC ZINC GAURD 1800** should be applied to a dry surface.

DRYING TIME

The following minimum times are based on a 76 microns DFT and adequate air ventilation. Higher thickness and reduced air ventilation increase drying times.

Surface Temperature (°C)	To Touch	To Topcoat
10	12 hrs.	32 hrs.
15	6 hrs.	16 hrs.
21	3 hr.	8 hrs.
26	2 hrs.	5 hrs.
32	1 hr.	3 hrs.

FILM THICKNESS (PER COAT)

Dry film thickness: 50-102 μm
 Wet film thickness: 102-152 μm
 Theoretical Coverage: 32 m^2 @ 76 μm
 Theoretical Coverage: 13 m^2 /L @ 76 μm

SUBSTRATES

REC ZINC GUARD 1800 can be applied directly to properly prepared steel as a primer. Direct contact with the steel substrate is required to provide optimal galvanic protection to the underlying steel surface.

TOP COATS

REC ZINC GUARD 1800 is an easy to coat primer using either an epoxy or polyurethane coating.

CLEAN UP

Clean up the surface as per instructions.

PACKAGING

REC ZINC GUARD 1800 can be supplied in various packaging units on demand.

SHELF LIFE

Up to 2 years when stored in accordance with manufacturer's instructions.

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