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**TECHNICAL DATA SHEET**

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**BA910MK399****KABS ZINTECT 1000HA(S) SHOP PRIMER**

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**DESCRIPTION**

<b>Product Description</b>	Inorganic zinc rich, two component protective shop primer (pre-fabrication) for steel plates and shapes based on alkyl silicate binder and zinc powder.
<b>Intended Use</b>	Rust preventing pre-fabrication primer for protection of steel structures at marine or industrial severe corrosive environment, during production, storage and transportation period.
<b>Characteristic Properties</b>	<ul style="list-style-type: none"><li>• No trouble in gas-cutting and welding</li><li>• Quick drying</li><li>• Excellent shop coat line applicability (automatic)</li><li>• Excellent anti-corrosive performance</li><li>• Excellent resistance to weathering, resistance to oil and resistance to organic solvents and temperature resistance</li></ul>

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**PRODUCT PROPERTIES**

<b>Color</b>	Red Brown
<b>Gloss Level</b>	Matt
<b>Mixing Ratio</b>	Material is supplied in two containers as a unit. Base (Comp A) = BA910MK399 : 3 by volume Hardener (Comp B) = BB910Z001 : 5 by volume Thinner = TN6080 : 0-10 by volume (depends on application conditions)
<b>Solids (by volume)</b>	26-30 % ISO 3233-1
<b>Suggested Thickness</b>	15-20 microns dry film
<b>General Remarks</b>	<p>-Cracking may occur when total thickness is more than 50 microns by short interval (within 7 days) application</p> <p>-Thickness shall be controlled from 15 to 25 microns for ideal cutting and welding work.</p> <p>-BA910MK399 has the welding certificate approved by Bureau Veritas.</p>
<b>Theoretical Coverage</b>	Approximately 16.47 m <sup>2</sup> /L (17 microns dry film)  The practical coverage depends on the factors, such as shape of the construction, roughness of the substrate, method and conditions of application.
<b>Application Method</b>	Airless spray, Brush
<b>Pot Life, 20°C</b>	24 hours after the mixture is prepared. (Higher temperatures reduce the time)

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**STORAGE AND SAFETY INFORMATION**

<b>Storage</b>	Store in a well ventilated and dry conditions at temperatures between 5 – 40°C. The packaging should not be exposed to direct sunlight. The shelf lives of the products (base and hardener are at least 6 months in unbroken original package, under mentioned storage conditions.
<b>Warnings</b>	See label for precautions. The user of this product is required to comply with the national statutory regulations for health, safety during transportation and at work and waste disposal. See the MSDS for detailed information.

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### APPLICATION INFORMATION

#### Surface Preparation

Performance of this product depends upon the degree of surface preparation.

All surfaces to be coated should be completely clean, dry and free from contamination.

- Remove salts and other water soluble contaminants by fresh water.
- Remove oil and grease with suitable detergents or solvents (SSPC SP-1).
- Remove rust, mill scale and other loose material completely by abrasive blasting (ISO 8501-1: 2007 Sa2<sup>1/2</sup> or SSPC SP-10)

#### Application Conditions

Ambient temperature shall be above 0°C and relative humidity shall be above 50%. Surface temperature shall be a minimum of 3°C above the dew point. Adequate ventilation shall be provided in confined spaces to ensure proper drying.

#### Product Preparation

Material is supplied in two containers as a unit.

Base (Comp. A) = BA910MK399

Hardener (Comp. B) = BB910Z001

-Stir each component with power agitator well before mixing. Then mix in a right proportion Base (Comp. A) with Hardener (Comp B), stir thoroughly with power agitator.

3 parts of Comp. A (BA910MK399) to 5 part Comp. B (BB910Z001) (by volume)

-Zinc powder in mixed paint tends to sink due to heavy specific gravity. Stir slowly during application to prevent zinc powder settling.

#### Application Method, 20°C

Equipment	Airless Spray	Brush
Thinner	TN6080	TN6080
Dilution	0-10 % by volume	0-5 % by volume
Nozzle Pressure	Not less than 10 MPa	-
Nozzle Size	515-621	-

-Too much thinning results sagging and slower cure.

-Contamination of other thinner may spoil paint film formation. Wash spray equipment sufficiently with TN6080 (Cellulosic Thinner) before using.

#### Drying Time, %65 RH (for 17 microns DFT)

Surface Temperature	5°C	20°C	30°C
Touch Dry	8 minutes	5 minutes	3 minutes
Hard Dry	20 minutes	15 minutes	5 minutes
Overcoating* Interval, Minimum	24 hours	24 hours	24 hours

\*Oil and alkyd paint is not suitable for overcoating.

#### Packaging

	Volume (litres)	Size of containers (litres)
Base (Comp A) =	5.95	10
Hardener (Comp B) =	9.90	10

The effectiveness of our systems is based on many years' practical experience and laboratory research. We guarantee that the quality of the work performed in accordance with our systems meets the Kansai Altan standards, provided that our instructions are followed carefully and the work is performed in accordance with the requirements as to good craftsmanship. We decline any responsibility, if the final result is affected by factors beyond our control. The customer has to determine the suitability of the delivered products for the intended application by using the means which normally are at his/her disposal.