

## ZINC RICH EPOXY POWDER COATING

STANDARD CURE POWDER COATING FOR INTERIOR APPLICATION BASED ON EPOXY RESINS

| <p><b>Typical applications</b></p> <ul style="list-style-type: none"> <li>Fencing</li> <li>Petrol Dispenser</li> <li>Lamp Post</li> <li>Control Panel</li> <li>Transformer</li> <li>Genset Canopy</li> </ul>  | <p><b>Application guide</b></p> <table border="1"> <thead> <tr> <th colspan="2">Surface Preparation</th> </tr> </thead> <tbody> <tr> <td>Degreasing</td> <td>Alkaline Degreaser</td> </tr> <tr> <td>H R Steel</td> <td>Shotblasting to SA 2½</td> </tr> <tr> <td>Sheet Metal</td> <td>Passivated Zinc Phosphate<br/>(Coating wt 1.5 – 2.5 gms/ Sq.M)</td> </tr> </tbody> </table> <table border="1"> <thead> <tr> <th></th> <th>Single Coat</th> <th>Two Coat</th> </tr> </thead> <tbody> <tr> <td>Voltage</td> <td>40 – 90 KV</td> <td>40 – 90 KV</td> </tr> <tr> <td colspan="3">Curing (Effective Metal Temperature)</td> </tr> <tr> <td>Prime-H</td> <td>180°C/10–15 min</td> <td>180°C/3–5 min</td> </tr> <tr> <td>Hybrid Top Coat</td> <td>--</td> <td>180°C/10–15 min</td> </tr> <tr> <td>Polyester Top Coat</td> <td>--</td> <td>190°C/10–15 min</td> </tr> </tbody> </table>  | Surface Preparation |             | Degreasing | Alkaline Degreaser     | H R Steel  | Shotblasting to SA 2½ | Sheet Metal | Passivated Zinc Phosphate<br>(Coating wt 1.5 – 2.5 gms/ Sq.M) |         | Single Coat | Two Coat | Voltage | 40 – 90 KV | 40 – 90 KV | Curing (Effective Metal Temperature) |                        |            | Prime-H  | 180°C/10–15 min | 180°C/3–5 min | Hybrid Top Coat | --                       | 180°C/10–15 min | Polyester Top Coat | --  | 190°C/10–15 min |          |  |       |       |                |       |  |  |  |  |                |       |  |       |       |       |          |  |  |  |       |       |             |  |  |       |  |  |
|---|--|---------------------|-------------|------------|------------------------|------------|-----------------------|-------------|---|---------|-------------|----------|---------|------------|------------|--------------------------------------|------------------------|------------|----------|-----------------|---------------|-----------------|--------------------------|-----------------|--------------------|---|-----------------|----------|--|-------|-------|----------------|-------|--|--|--|--|----------------|-------|--|-------|-------|-------|----------|--|--|--|-------|-------|-------------|--|--|-------|--|--|
| Surface Preparation   |  |                     |             |            |                        |            |                       |             |   |         |             |          |         |            |            |                                      |                        |            |          |                 |               |                 |                          |                 |                    |   |                 |          |  |       |       |                |       |  |  |  |  |                |       |  |       |       |       |          |  |  |  |       |       |             |  |  |       |  |  |
| Degreasing  | Alkaline Degreaser   |                     |             |            |                        |            |                       |             |   |         |             |          |         |            |            |                                      |                        |            |          |                 |               |                 |                          |                 |                    |   |                 |          |  |       |       |                |       |  |  |  |  |                |       |  |       |       |       |          |  |  |  |       |       |             |  |  |       |  |  |
| H R Steel   | Shotblasting to SA 2½  |                     |             |            |                        |            |                       |             |   |         |             |          |         |            |            |                                      |                        |            |          |                 |               |                 |                          |                 |                    |   |                 |          |  |       |       |                |       |  |  |  |  |                |       |  |       |       |       |          |  |  |  |       |       |             |  |  |       |  |  |
| Sheet Metal   | Passivated Zinc Phosphate<br>(Coating wt 1.5 – 2.5 gms/ Sq.M)  |                     |             |            |                        |            |                       |             |   |         |             |          |         |            |            |                                      |                        |            |          |                 |               |                 |                          |                 |                    |   |                 |          |  |       |       |                |       |  |  |  |  |                |       |  |       |       |       |          |  |  |  |       |       |             |  |  |       |  |  |
|   | Single Coat  | Two Coat            |             |            |                        |            |                       |             |   |         |             |          |         |            |            |                                      |                        |            |          |                 |               |                 |                          |                 |                    |   |                 |          |  |       |       |                |       |  |  |  |  |                |       |  |       |       |       |          |  |  |  |       |       |             |  |  |       |  |  |
| Voltage   | 40 – 90 KV   | 40 – 90 KV          |             |            |                        |            |                       |             |   |         |             |          |         |            |            |                                      |                        |            |          |                 |               |                 |                          |                 |                    |   |                 |          |  |       |       |                |       |  |  |  |  |                |       |  |       |       |       |          |  |  |  |       |       |             |  |  |       |  |  |
| Curing (Effective Metal Temperature)  |  |                     |             |            |                        |            |                       |             |   |         |             |          |         |            |            |                                      |                        |            |          |                 |               |                 |                          |                 |                    |   |                 |          |  |       |       |                |       |  |  |  |  |                |       |  |       |       |       |          |  |  |  |       |       |             |  |  |       |  |  |
| Prime-H   | 180°C/10–15 min  | 180°C/3–5 min       |             |            |                        |            |                       |             |   |         |             |          |         |            |            |                                      |                        |            |          |                 |               |                 |                          |                 |                    |   |                 |          |  |       |       |                |       |  |  |  |  |                |       |  |       |       |       |          |  |  |  |       |       |             |  |  |       |  |  |
| Hybrid Top Coat   | --   | 180°C/10–15 min     |             |            |                        |            |                       |             |   |         |             |          |         |            |            |                                      |                        |            |          |                 |               |                 |                          |                 |                    |   |                 |          |  |       |       |                |       |  |  |  |  |                |       |  |       |       |       |          |  |  |  |       |       |             |  |  |       |  |  |
| Polyester Top Coat  | --   | 190°C/10–15 min     |             |            |                        |            |                       |             |   |         |             |          |         |            |            |                                      |                        |            |          |                 |               |                 |                          |                 |                    |   |                 |          |  |       |       |                |       |  |  |  |  |                |       |  |       |       |       |          |  |  |  |       |       |             |  |  |       |  |  |
| <p><b>Product Performance</b></p> <p>Standard Packaging 10 kg &amp; 20 Kg cartons</p> <p>Specific Gravity 2.6 -3.0 g/cm3 depending on colors</p> <p>Storage Stability Use before: 6 months (from month of mfg). Store below 30°C, avoid direct and extended heat exposure.</p>  | <p><b>Pretreatment</b></p> <table border="1"> <thead> <tr> <th></th> <th>Steel</th> <th>Alum inum</th> <th>Galva nised</th> <th>Cast Steel</th> <th>HR Steel</th> </tr> </thead> <tbody> <tr> <td>Degreasing</td> <td>Green</td> <td>Green</td> <td>Green</td> <td>Green</td> <td>Green</td> </tr> <tr> <td>Chromating</td> <td></td> <td>Green</td> <td></td> <td></td> <td></td> </tr> <tr> <td>Chrome Free</td> <td></td> <td>Green</td> <td></td> <td></td> <td></td> </tr> <tr> <td>Derusting</td> <td>Yellow</td> <td></td> <td></td> <td>Green</td> <td>Green</td> </tr> <tr> <td>Iron Phosphate</td> <td>Green</td> <td></td> <td></td> <td></td> <td></td> </tr> <tr> <td>Zinc Phosphate</td> <td>Green</td> <td></td> <td>Green</td> <td>Green</td> <td>Green</td> </tr> <tr> <td>Blasting</td> <td></td> <td></td> <td></td> <td>Green</td> <td>Green</td> </tr> <tr> <td>Sweep Blast</td> <td></td> <td></td> <td>Green</td> <td></td> <td></td> </tr> </tbody> </table> |                     | Steel       | Alum inum  | Galva nised            | Cast Steel | HR Steel              | Degreasing  | Green   | Green   | Green       | Green    | Green   | Chromating |            | Green                                |                        |            |          | Chrome Free     |               | Green           |                          |                 |                    | Derusting                                     | Yellow          |          |  | Green | Green | Iron Phosphate | Green |  |  |  |  | Zinc Phosphate | Green |  | Green | Green | Green | Blasting |  |  |  | Green | Green | Sweep Blast |  |  | Green |  |  |
|   | Steel  | Alum inum           | Galva nised | Cast Steel | HR Steel               |            |                       |             |   |         |             |          |         |            |            |                                      |                        |            |          |                 |               |                 |                          |                 |                    |   |                 |          |  |       |       |                |       |  |  |  |  |                |       |  |       |       |       |          |  |  |  |       |       |             |  |  |       |  |  |
| Degreasing  | Green  | Green               | Green       | Green      | Green                  |            |                       |             |   |         |             |          |         |            |            |                                      |                        |            |          |                 |               |                 |                          |                 |                    |   |                 |          |  |       |       |                |       |  |  |  |  |                |       |  |       |       |       |          |  |  |  |       |       |             |  |  |       |  |  |
| Chromating  |  | Green               |             |            |                        |            |                       |             |   |         |             |          |         |            |            |                                      |                        |            |          |                 |               |                 |                          |                 |                    |   |                 |          |  |       |       |                |       |  |  |  |  |                |       |  |       |       |       |          |  |  |  |       |       |             |  |  |       |  |  |
| Chrome Free   |  | Green               |             |            |                        |            |                       |             |   |         |             |          |         |            |            |                                      |                        |            |          |                 |               |                 |                          |                 |                    |   |                 |          |  |       |       |                |       |  |  |  |  |                |       |  |       |       |       |          |  |  |  |       |       |             |  |  |       |  |  |
| Derusting   | Yellow   |                     |             | Green      | Green                  |            |                       |             |   |         |             |          |         |            |            |                                      |                        |            |          |                 |               |                 |                          |                 |                    |   |                 |          |  |       |       |                |       |  |  |  |  |                |       |  |       |       |       |          |  |  |  |       |       |             |  |  |       |  |  |
| Iron Phosphate  | Green  |                     |             |            |                        |            |                       |             |   |         |             |          |         |            |            |                                      |                        |            |          |                 |               |                 |                          |                 |                    |   |                 |          |  |       |       |                |       |  |  |  |  |                |       |  |       |       |       |          |  |  |  |       |       |             |  |  |       |  |  |
| Zinc Phosphate  | Green  |                     | Green       | Green      | Green                  |            |                       |             |   |         |             |          |         |            |            |                                      |                        |            |          |                 |               |                 |                          |                 |                    |   |                 |          |  |       |       |                |       |  |  |  |  |                |       |  |       |       |       |          |  |  |  |       |       |             |  |  |       |  |  |
| Blasting  |  |                     |             | Green      | Green                  |            |                       |             |   |         |             |          |         |            |            |                                      |                        |            |          |                 |               |                 |                          |                 |                    |   |                 |          |  |       |       |                |       |  |  |  |  |                |       |  |       |       |       |          |  |  |  |       |       |             |  |  |       |  |  |
| Sweep Blast   |  |                     | Green       |            |                        |            |                       |             |   |         |             |          |         |            |            |                                      |                        |            |          |                 |               |                 |                          |                 |                    |   |                 |          |  |       |       |                |       |  |  |  |  |                |       |  |       |       |       |          |  |  |  |       |       |             |  |  |       |  |  |
| <p><b>Features</b></p> <ul style="list-style-type: none"> <li>Good Leveling</li> <li>Good chemical resistance</li> <li>Good corrosion resistance</li> </ul>   | <p><b>Processing Instructions</b></p> <p>The guidelines for application must be strictly observed.</p>   |                     |             |            |                        |            |                       |             |   |         |             |          |         |            |            |                                      |                        |            |          |                 |               |                 |                          |                 |                    |   |                 |          |  |       |       |                |       |  |  |  |  |                |       |  |       |       |       |          |  |  |  |       |       |             |  |  |       |  |  |
| <p><b>Performance (When cured at 180°C/ 10 Min EMT)</b></p> <table border="1"> <thead> <tr> <th>Test</th> <th>Test Method</th> <th>Series EPZ</th> </tr> </thead> <tbody> <tr> <td>Film Thickness microns</td> <td>ISO 2360</td> <td>50 - 60</td> </tr> <tr> <td>Gloss @ 60°</td> <td>ISO 2813</td> <td>90 - 95</td> </tr> <tr> <td>Adhesion</td> <td>ISO 2409</td> <td>Gt-0</td> </tr> <tr> <td>Bending</td> <td>ISO 1519</td> <td>6 mm</td> </tr> <tr> <td>Impact Resistance KgCm</td> <td>ASTM D2794</td> <td>40 – 100</td> </tr> <tr> <td>Pencil Hardness</td> <td>ASTM D3363</td> <td>H – 2H</td> </tr> <tr> <td>Salt Spray Test - Primer</td> <td>ASTM B117</td> <td>1000 hrs</td> </tr> <tr> <td>Salt Spray Test – Primer + Polyester Top Coat</td> <td>ASTM B117</td> <td>3000 hrs</td> </tr> </tbody> </table> |  | Test                | Test Method | Series EPZ | Film Thickness microns | ISO 2360   | 50 - 60               | Gloss @ 60° | ISO 2813  | 90 - 95 | Adhesion    | ISO 2409 | Gt-0    | Bending    | ISO 1519   | 6 mm                                 | Impact Resistance KgCm | ASTM D2794 | 40 – 100 | Pencil Hardness | ASTM D3363    | H – 2H          | Salt Spray Test - Primer | ASTM B117       | 1000 hrs           | Salt Spray Test – Primer + Polyester Top Coat | ASTM B117       | 3000 hrs |  |       |       |                |       |  |  |  |  |                |       |  |       |       |       |          |  |  |  |       |       |             |  |  |       |  |  |
| Test  | Test Method  | Series EPZ          |             |            |                        |            |                       |             |   |         |             |          |         |            |            |                                      |                        |            |          |                 |               |                 |                          |                 |                    |   |                 |          |  |       |       |                |       |  |  |  |  |                |       |  |       |       |       |          |  |  |  |       |       |             |  |  |       |  |  |
| Film Thickness microns  | ISO 2360   | 50 - 60             |             |            |                        |            |                       |             |   |         |             |          |         |            |            |                                      |                        |            |          |                 |               |                 |                          |                 |                    |   |                 |          |  |       |       |                |       |  |  |  |  |                |       |  |       |       |       |          |  |  |  |       |       |             |  |  |       |  |  |
| Gloss @ 60°   | ISO 2813   | 90 - 95             |             |            |                        |            |                       |             |   |         |             |          |         |            |            |                                      |                        |            |          |                 |               |                 |                          |                 |                    |   |                 |          |  |       |       |                |       |  |  |  |  |                |       |  |       |       |       |          |  |  |  |       |       |             |  |  |       |  |  |
| Adhesion  | ISO 2409   | Gt-0                |             |            |                        |            |                       |             |   |         |             |          |         |            |            |                                      |                        |            |          |                 |               |                 |                          |                 |                    |   |                 |          |  |       |       |                |       |  |  |  |  |                |       |  |       |       |       |          |  |  |  |       |       |             |  |  |       |  |  |
| Bending   | ISO 1519   | 6 mm                |             |            |                        |            |                       |             |   |         |             |          |         |            |            |                                      |                        |            |          |                 |               |                 |                          |                 |                    |   |                 |          |  |       |       |                |       |  |  |  |  |                |       |  |       |       |       |          |  |  |  |       |       |             |  |  |       |  |  |
| Impact Resistance KgCm  | ASTM D2794   | 40 – 100            |             |            |                        |            |                       |             |   |         |             |          |         |            |            |                                      |                        |            |          |                 |               |                 |                          |                 |                    |   |                 |          |  |       |       |                |       |  |  |  |  |                |       |  |       |       |       |          |  |  |  |       |       |             |  |  |       |  |  |
| Pencil Hardness   | ASTM D3363   | H – 2H              |             |            |                        |            |                       |             |   |         |             |          |         |            |            |                                      |                        |            |          |                 |               |                 |                          |                 |                    |   |                 |          |  |       |       |                |       |  |  |  |  |                |       |  |       |       |       |          |  |  |  |       |       |             |  |  |       |  |  |
| Salt Spray Test - Primer  | ASTM B117  | 1000 hrs            |             |            |                        |            |                       |             |   |         |             |          |         |            |            |                                      |                        |            |          |                 |               |                 |                          |                 |                    |   |                 |          |  |       |       |                |       |  |  |  |  |                |       |  |       |       |       |          |  |  |  |       |       |             |  |  |       |  |  |
| Salt Spray Test – Primer + Polyester Top Coat   | ASTM B117  | 3000 hrs            |             |            |                        |            |                       |             |   |         |             |          |         |            |            |                                      |                        |            |          |                 |               |                 |                          |                 |                    |   |                 |          |  |       |       |                |       |  |  |  |  |                |       |  |       |       |       |          |  |  |  |       |       |             |  |  |       |  |  |

Note: Above tests done on Shot Blasted steel

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