



# THOMAS HOWSE LIMITED

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## PRODUCT SPECIFICATION SHEET

### C3120 POWDAGALV - EPOXY ZINC RICH PRIMER

Contains two anti – corrosion additives, which act synergistically.

One in the form of finely divided zinc particles used in ‘zinc rich’ paint. These concentrate near the metal interface providing the so – called ‘sacrificial’ corrosion resistance and emulate galvanising.

Pre-treatment before coating is essential for long-term protection, which consists of descaling and phosphating.

1. **Lower cost**
2. **Quick turn around**
3. **Alternative to galvanising components, which deform during conventional galvanising.**
4. **Smoother aesthetic finish eliminating nodules blowholes associated with galvanising.**

|   |  |
|---|--|
| <b>MAXIMUM CORROSION RESISTANCE*</b>        | <b>60 U EPOXY POWDAGALV<br/>80 U POLYESTER TOPCOAT</b> |
| <b>MAXIMUM MECHANICALS<br/>'X' ADHESION</b> | <b>50 U EPOXY POWDAGALV<br/>50 U POLYESTER TOPCOAT</b> |

- **BS 6497 500 HRS SALT SPRAY**

### WHEN OVERCOATING POWDAGALV

Apply 60-80 microns of Powdagalv for optimum intercoat adhesion, the component should then be sufficiently, but not completely cured (we suggest a metal temperature of 160'c for 10 minutes) so that:-

1. **No disruption of final coating occurs due to small amounts of gaseous products forcing through the topcoat.**
2. **The Powdagalv forms a smooth continuous coating, free from any surface roughness**

Allowances should be made for variances in metal thickness and, therefore, metal temperature, especially on the same component.

Initial preheating of the component before applying the powder, and then application of the finishing coat whilst still warm, maybe beneficial in some cases. It is essential to cover the metal surfaces completely, especially welds, crevices on where it is difficult to penetrate (faraday cage effect). This can be minimised by preheating the component 160°C but it is not always successful, and a immersion coating or hot dip galvanising is preferable.

The above advice is given with the reference to over coating with our standard exterior polyester, curing 10 minutes at 200°C, therefore some adjustments may be required for products with lower curing schedules.

## **PRETREATMENT**

It is essential to thoroughly clean the substrate from moisture, rust, scale, grease, oil or any other contaminants.

Then a suitable pre-treatment, suitable for the substrate. A general guide is: -

|                          |   |  |
|--------------------------|---|--|
| <b>FERROUS SUBSTRATE</b> | - | <b>IRON OR ZINC PHOSPHATE</b>              |
| <b>ZINC COATED STEEL</b> | - | <b>ZINC PHOSPHATE OR CHROME CONVERSION</b> |
| <b>ALUMINIUM</b>         | - | <b>CHROMATE CONVERSION</b>                 |

The pre-treatment type and coat weighting should follow the manufacturer's recommendation.

|                           |   |   |
|---------------------------|---|---|
| <b>SPECIFIC GRAVITY</b>   | - | <b>2.8 – 2.9 G/CM</b>                           |
| <b>SALT SPRAY TEST</b>    | - | <b>Minimum 1000 hours BS 3900F4</b>             |
| <b>IMPACT RESISTANCE</b>  | - | <b>Excellent pass 100 inch pounds BS 3900E3</b> |
| <b>SCRATCH RESISTANCE</b> | - | <b>BS3900E3 Normally 4kg load pass</b>          |
| <b>HUMIDITY</b>           | - | <b>Minimum 1000 hours BS3900F2</b>              |