

TECHNICAL DATA SHEET

EP-ZINC 3

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Anti-rust zinc dust paint which guarantees a lasting protection of blasted steel.
Excellent weldable if applied in a dry film thickness of less than 25 micrometer.
After a short time recoatable with epoxy, polyurethane, vinyl and chlorinated rubber paint.
When it must be recoatable with a alkyd paint, then use Epoxy ZNF between 2 layers

Application as anti-rust primer for steel structures under industrial, maritime and nuclear conditions. To prevent zinc-salts it is advisable tot apply a sealer directly after drying

PRODUCT INFORMATION

Type of paint	Two components epoxyprimer/coating with polyamide adduct hardener
Finish	Mat
Colour	Grey
Density (Mixed product)	2.0 kg/L
Zinc Content (in dry film)	65 m%
Solids content (mixed product)	35 vol%
VOC (volatile organic compounds)	560 g/L
Recommended dry film thickness (DFT)	20-30 µm
Theoretical spreading rate	
DFT = 20 µm	17.5 m²/L
DFT = 30 µm	11.6 m²/L
Practical spreading rate (Depending on several factors, like object shape, surface profile, application method and circumstances and experience)	Brush/roller : 85-90% of the theoretical spreading rate Pistol : 50-70 % of the theoretical spreading rate
Flashpoint	23°C
Dry temperature resistance	180°C

DRYING TIMES

For d.f.t. up to 20µm	30°C	20°C	10°C
	30°C	20°C	10°C
Dust free	8 min	10 min	30 min
Manageable	1 hour	2 hours	4 hours
Overpainted			
Minimum interval	3 hours	4 hours	8 hours
Maximum interval	Unlimited provided that the surface is dry and clean		

Because zinc-dust paints can develop zinc-salts on the surface, we recommend to recoat as soon as possible.

Film thickness, ventilation, temperature and relative humidity are of great influence on the drying times.

APPLICATIONS-INSTRUCTIONS

Mixing ratio:	Product 10 + hardener 1,2
Mixing instructions:	Base and hardener should be mixed and applied at temperatures above 10°C At lower temperatures extra thinner is needed.
Induction time:	At 20°C not necessary At 10°C at least 10 minutes.
Pot life after mixing:	At 20°C ca. 24 hours At 35°C ca. 6 hours
Application conditions	During application and hardening the temperature should be above 5°C to attain maximum resistance against chemical and mechanical influences. Application at lower temperatures (down to -5°C) is possible, however hardening will take considerable more time and complete resistance will be achieved much later. The surface should remain free from water and ice and the temperature of the surface should at least be 3°C above dew point. During application and hardening in closed or small spaces, it is necessary to refresh the air continually to remove the solvent vapours, this because of drying, health and safety.

Usage	Airless	Airspray
Type of thinner	Thinner EP	Thinner EP
Percentage of thinner	5-20 vol%	10-25 vol%
Nozzle orifice	0.43-0.48 mm 0.017-0.019	2.0-2.5 mm
Nozzle pressure	150-170 bar	3-5 bar
Cleaning	Cellulose thinner	Cellulose thinner

SURFACE CONDITIONS

Steel:	<p>New steel: Blasting according to Sa2½ Roughness profile Ra 10-12 µm Rz 50-60µm Surface must be clean and dry.</p> <p>Repair and maintenance: Clean the surface carefully with a suitable solvent containing cleaning preparation, or a watersoluble emulsifier to remove oil, grease and dirt. Remove salts and other water-soluble impurity by spraying with clean tap-water under high pressure. Remove rust a.o. by blasting Sa2½ or derust mechanical until St.2-3 Apply the advised paint system (Vibol Epoxy ZNF) on a clean surface. - Mechanical or hand derusting gives less quality than blasting and will result in less protection of the applied paint system.</p>
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DURABILITY

At least 12 months, provided that it has been stored in closed original packing at a dry and cool spot.

PACKAGING

10L + 1,2L

These data have been drawn up to the best of our knowledge and were correct at the data of issue. However we cannot accept full responsibility, because de choice of products and circumstances during elaboration of the systems fall outside our judgement. This documentation sheet will not automatically be replaced in case of modification.