

TRANSCOAT 685 A

Zinc Epoxy

Product Description	Polyamide cured zinc epoxy primer.	
Recommended Use	A zinc primer for applications in aggressive environments in a wide range of industries and to repair organic / inorganic zinc primer.	
Characteristics	<ul style="list-style-type: none"> • Excellent adhesion to inorganic zinc primer. • Good corrosion prevention properties • Quick drying and can be over coated after a short interval. • Excellent abrasion resistance which minimize transit and handling damages. • Not recommended for immersion service in acid and alcohols. 	
Physical Data	Colour	Grey
	Gloss Level	Flat
	Volume Solid	Approx. 50%
	Dry Film Thickness	75 microns per coat
	Number of Coat	1
	Theoretical Coverage	6.60 sq.m/ltr for 75 microns
	Temperature Resistance	Maximum : 93°C (dry)
	VOC	449 g/ltr
	Flash Point	Base : 37°C Hardener : 37°C
	Shelf Life	At least 12 months
	Pack Size	
	5 litres unit	Base : 4 litres , Hardener : 1 litre
	10 litres unit	Base : 8 litres , Hardener : 2 litres
Surface Preparation	<p>Dry abrasive blast in accordance with ISO - Sa 2.5 or SSPC - SP 10 "Near White". Blast to achieve a 25 - 50 microns anchor profile as indicate with a Keane Tator Surface Profile Comparator.</p> <p>Remove abrasive residue or dust from surface.</p>	

APPLICATION DATA	Application Methods	
	Airless Spray	
	Nozzle Tip	Approx. 0.46 mm (0.018 inch)
	Nozzle Pressure	10 MPa (approx. 1400 psi)
	Conventional Spray	
	Nozzle Tip	Approx. 1.8 mm (0.071 inch)
	Nozzle Pressure	0.3 MPa (approx. 43 psi)
	Brush or Roller Only for touch up	
	Mixing Ratio By Volume	Base : Hardener = 4 : 1
	Thinner	Thinner Trans 650
	Cleaner	Thinner Trans 120
	Surface Temperature	Should be 10°C - 50°C, at least 3°C above the dew point to prevent condensation

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Drying Time	
Touch Dry	25 minutes at 25 ⁰ C, 15 minutes at 32 ⁰ C
Through Dry	40 minutes at 25 ⁰ C, 25 minutes at 32 ⁰ C
To Topcoat	8 hours at 25 ⁰ C, 4 hours at 32 ⁰ C
Pot Life	24 hours at 25 ⁰ C, 12 hours at 32 ⁰ C
Limitation	Zinc rich primers can form zinc salts on the surfaces, before over coating visible surface contamination must be removed by high pressure water cleaning, sweep blasting or mechanical cleaning.

SYSTEM COMPATIBILITY

Before over coating with recommended topcoats ensure the Transcoat 685 A is fully cured and if weathering has occurred all zinc salt should be removed from the surface by fresh water washing, and if necessary scrubbing with bristle brushes.

Typical topcoat and intermediates are:

- Transcoat 5100 / Transcoat 5151
- Transcoat 3850
- Transcoat 3831 HS
- Transcoat 4000
- Transcoat 662 GL

In some cases it may be necessary to apply a mist coat of suitable viscosity to minimise bubbling. This will depend upon the age of the Transcoat 685 A, surface roughness and ambient conditions during curing and application.

For other suitable intermediates or topcoats, please consult Transcoat Protective Coating.

SAFETY PRECAUTION

Keep away from heat, spark and open flames. Avoid breathing of vapour on skin and eye contact. Keep container closed and store in cool, ventilated area when not in use.

Proper ventilation and protective measures must be provided during mixing, application and drying, to keep vapour concentration within safe limits and to protect against toxic hazard.

Necessary safety equipment must be used and ventilation requirements carefully observed, especially in confined or enclosed spaces, such as tank interior and building.

DISCLAIMER

The information in this product data sheet is given to the best of our knowledge based on laboratory testing and practical experience. If the product is used under condition beyond our control, we cannot guarantee anything but the quality of the products it self. The information in this product data sheet is liable for modification from time to time in the light of experience and our policy of continuous product development, and without further notice.
