

## Product and Technology Description

MCU-Zinc<sup>®</sup>HS (high volume solids) is a single component moisture cure urethane primer. A pure zinc rich primer with very small zinc particles for atmospheric exposures on maintenance and new construction works, where the longest durability is required. A substitute for galvanising, MCU-Zinc<sup>®</sup> does not suffer from amine blooming, or create zinc salts, or crack when applied at higher DFT's.

## Technology Features

1 component – minimal preparation and no pot-life limitations  
 Can be applied in 6 % to 99 % relative humidity  
 Dew point restrictions do not apply, or affect durability  
 Cures quickly, even at -20 °C  
 Can be applied at ambient temp. to 50°C & steel to 75°C  
 High surface tolerance  
 Exceptional corrosion resistance  
 Excellent abrasion resistance  
 Good chemical resistance  
 Superior flexibility - no cracking, flaking or peeling  
 Moisture resistant after 30 minutes  
 High resistance to blistering  
 Typical service temperatures -45°C to 145°C \*

Excellent adhesion to most substrates and sound aged coatings  
 UHP WJ, dry/wet blasting & power tool cleaning

## Product Specific Features

Up to 40% more zinc in the MCU-Coatings<sup>®</sup> 2-coat system (DFT)  
 Approved for Class B Slip Coefficient  
 No maximum recoat window  
 Does not create zinc salts on the surface  
 No amine blooming  
 Can be applied to damp substrates, surface must be visibly dry  
 Wide DFT tolerance  
 Excellent wetting properties  
 Suitable for atmospheric exposure (excl. UV)  
 Substitute for galvanising

## Areas of Use

### Substrates

Ferrous – mild steel / cast iron  
 Overlapping / touch-up:  
 ♦ Non-ferrous metals  
 ♦ Metallized coatings  
 ♦ Galvanised metal  
 ♦ Aluminium  
 (and most sound old coatings)

### Possible uses

Structural steel / atmospheric zones  
 Bridges, transmission towers  
 Oil & gas storage / offshore platforms / refineries  
 Port facilities / ships / wharves / jetties  
 Material handling equipment  
 Wind energy / hydropower / transmission towers  
 Pipes / pumps / valves  
 Chemical processing plants / paper mills  
 Steel tanks  
 Water and wastewater treatment sites

## Specifications

Resin type:	Aromatic urethane
Pigment type:	Zinc
Sheen:	Flat
Colour:	Grey
Volume solids:	70%±2.0%
VOC:	260 g/l
<b>Theoretical coverage:</b>	9.3. m <sup>2</sup> /l@75µm DFT
<b>Recommended film thickness:</b>	
Wet:	107 - 243 µm - no thinners
Dry:	75 - 170 µm

## Performance test data:

Adhesion (ASTM D4541): >15 MPa (2175 PSI)  
 Abrasion Resistance (ASTM D4060):  
 CS17 wheel 1,000 cycles/ kg: 31 mg loss  
 Impact (ASTM 2794): direct 160; reverse 20  
 Prohesion (ASTM G85 5,000 hours): scribe rate 9.5;  
 blistering: none  
 Dry Heat Resistance: continuous 145 °C  
 Salt Spray (ASTM B117): +10,000 hours (several systems)  
 Norsok M-501: Passes – several 2 & 3 coat systems  
 ISO 12944-6 C5 I & M High: Passes – several 2 & 3 coat systems

## Storage and Shipping Information

Shelf life:	15 months from date of manufacture if stored unopened between -5 °C & 30 °C in a cool, dry place
Density:	2.87 ± 0.12 kg/l
Flash point:	36.5 °C
UN proper shipping name:	UN 1263, PAINT, Class 3, Packaging Group III

**Drying Times and Temperatures – 75µm DFT (allow additional time for higher film builds)**

Temperatures RH at 60% *	Tack free		Recoat minimum & maximum *		Full cure	
	<i>without MCU-Quickcure</i>	<i>with MCU-Quickcure</i>	<i>without MCU-Quickcure</i>	<i>with MCU-Quickcure</i>	<i>without MCU-Quickcure</i>	<i>with MCU-Quickcure</i>
-20 °C	20 hours	15 hours	48 hours / Indef	10 hours / Indef	**	**
-10 °C	15 hours	10 hours	20 hours / Indef	4 hours / Indef	**	**
0 °C	7 hours	5 hours	12 hours / Indef	1.5 hours / Indef	**	**
10 °C	30 minutes	20 minutes	5 hours / Indef	1 hour / Indef	10 days	10 days
25 °C	10 minutes	10 minutes	4 hours / Indef	45 minutes / Indef	7 days	7 days
40 °C	10 minutes	10 minutes	3 hours / Indef	30 minutes / Indef	5 days	5 days

Refer to MCU-Quickcure<sup>®</sup> Technical Data Sheet for additional information

\* 95% of cure is reached within the recoat time

\* Humidity, temperature, and coating thickness will affect drying and curing times

\*\* Product is serviceable, will cure slowly, taking longer to reach full cure

## Surface Preparation

### Ferrous Metal

Use SSPC-SP1 solvent cleaning and/or MCU-Ecodegreaser<sup>®</sup> to remove oil and grease or other contaminants prior to employing surface preparation methods.

Near White Metal finish OR by SSPC 12/Nace 5.0 High or Ultra High Pressure water jetting methods to WJ 2 M (visual standard SSPC vis 4/Nace vis 7) very thorough cleaning finish (not applicable for new steel) OR by SSPC-TR2/Nace 6G198 Wet abrasive blast cleaning methods to WAB 10 M (visual standard SSPC vis 5/Nace vis 9) Wet near white metal blast clean finish. Consult your MCU-Coatings<sup>®</sup> representative for minimal surface preparation.

Prepare surfaces for non-immersion or atmospheric service projects by ISO 8504-2 methods to ISO 8501-1 SA 2 or SSPC-SP6/NACE No. 3 (visual standard SSPC vis 1) Commercial Blast Clean finish OR by SSPC 12/Nace 5.0 High or Ultra High pressure water jetting methods to WJ 4 M (visual standard SSPC vis 4/Nace vis 7) OR by SSPC-TR2/Nace 6G198 Wet abrasive blast cleaning methods to WAB 6 M (visual standard SSPC vis 5/Nace vis 9) Wet commercial blast clean finish.

For minimum surface preparation, use conscientious hand and power tool cleaning methods in accordance with ISO 8504-3 or SSPC-SP 2 and 3 to remove corrosion and loose or failing paint to ISO 8501-1 St 2 or SSPC-SP 2 and 3 (visual standard SSPC vis 3). Feather the edges of sound, existing paint back to a firm edge.

Blast cleaning methods should produce a minimum surface profile of 25-50 µm.

### Corten Steel

Prepare surfaces using SSPC-SP12/NACE No. 5 Low Pressure Water Cleaning methods. Supplement SSPC-SP 12 LPWC with ISO 8501-1 St 2 (SSPC-SP 2 or 3) hand or power tool cleaning where areas show excessive corrosion. Use SSPC-SP1 solvent cleaning and/or MCU-Ecodegreaser<sup>®</sup> to remove oil and grease prior to surface preparation methods.

### Galvanised Metal

Prepare surfaces using SSPC-SP1 Solvent Cleaning and SSPC-SP12/NACE No. 5 Low Pressure Water Cleaning methods to remove surface contamination. Supplement weathered galvanised surface preparation with ISO 8501-1 St 2 (SSPC-SP 2 and 3) hand and power tool cleaning and/or MCU-Ecocleaner<sup>®</sup> to remove excessive corrosion and impart surface profile on bare metal. Supplement new galvanised surface cleaning as necessary with mechanical abrasion to impart a surface profile to support mechanical adhesion.

### Best Practice

The surface to be coated must be dry, clean, dull, and free from dirt, grease, oil, rust, mill scale, salts or any other surface contaminants that interfere with adhesion.

Ensure welds, repair areas, joints, and surface defects exposed by surface preparation are properly cleaned and treated prior to coating application.

Consult the referenced standards, SSPC-PA1 and your MCU-Coatings<sup>®</sup> representative for additional information or recommendations.

## Application Information

MCU-Zinc<sup>®</sup>HS can be applied by brush, roller, airless spray, pressure pot, and conventional spray methods. Follow proper mixing instructions before applying.

### Thinner / Reducer

Typically not required. If necessary, thin up to 10% with a recommended MCU-Thinner<sup>®</sup>. See Technical Data Sheet for additional information.

### Mixing

Power mix thoroughly prior to application. Do not keep under constant agitation.

If required, apply a solvent float over the material (approx. 2mm) to prevent moisture intrusion, then cover the can.

### Brush/Roller

Brush:	Natural fibre
Roller:	Natural or synthetic fibre cover
Nap:	5 to 10 mm (higher nap, thicker coat)
Core:	Phenolic

### Airless Spray

Pump Ratio:	28-40:1
Pressure:	165-193 bar (2400 – 2800 psi)
Hose:	5 to 10 mm (1/4" to 3/8")
Tip Size:	(0.38 - 0.58mm (0.015-0.023 in)
Filter Size:	60 mesh (250 µm)

### Conventional Spray

Fluid Nozzle:	E Fluid Tip
Air Cap:	704 or 765
Atomizing Air:	3.1 - 5.2 bar
Fluid Pressure:	1 - 1.4 bar
Hose:	12mm ID; Max 16 metres

### Clean-up

MCU-Thinner<sup>®</sup>, MCU-Thinner<sup>®</sup> 25, and MCU-Thinner<sup>®</sup> 50. If MCU-Thinners<sup>®</sup> are not available for cleaning up, use MEK, MIBK, Xylene, a 50:50 blend of Xylene and MEK or MIBK

Do not add other solvents to MCU-Coatings<sup>®</sup>.

### Application

**Temperature:** - ambient temp. -20°C to 50°C & steel to 75°C

The substrate must be visibly dry.

\* In extreme environments the resistance will diminish over time

**Relative Humidity:** 6% to 99%

MCU-Quickcure<sup>®</sup> is advised when relative humidity is below 40%.

### Coating Accelerator:

See MCU-Quickcure<sup>®</sup> Technical Data Sheet for information.

### Storage

Store off the ground in a dry, protected area in temperature between -5 °C to 30 °C. Containers must be kept sealed when not in use. Use a solvent float to reseal partially used containers.

### Safety Precautions

This product is for industrial and professional use only. Consult the Safety Data Sheet.

## Warranty

MCU-Coatings<sup>®</sup> warrants its products to be free from defects in materials. MCU-Coatings<sup>®</sup> sole obligation, and Buyer's exclusive remedy, in connection with the products shall be limited, at MCU-Coatings<sup>®</sup> option to either replace the products not conforming with this warranty, or to credit the Buyer's account with the invoiced amount of the non-conforming products. Any claim under this warranty must be made by Buyer to MCU-Coatings<sup>®</sup> in writing within five (5) days of Buyer's discovery of the claimed defect, but in no event later than the expiration of the applicable shelf- life, or six months from the delivery date, whichever is earlier. Buyer's failure to notify MCU-Coatings<sup>®</sup> of such non-conformance as required herein shall bar Buyer from recovery under this warranty.

MCU-Coatings<sup>®</sup> makes no other warranties concerning the products. No other warranties, whether expressed,

implied, or statutory, such as warranties of merchantability or fitness for a particular purpose, shall apply. In no event shall MCU-Coatings<sup>®</sup> be liable for consequential or incidental damages.

Any recommendations or suggestions relating to the use of the products made by MCU-Coatings<sup>®</sup>, whether in its technical literature, or in response to specific inquiry, or otherwise, is based on data believed to be reliable; however, the products and information are intended for use by Buyers having the requisite skill and know-how in the industry, and therefore the Buyer must satisfy itself as to the suitability of the products for their own particular use, and it shall be deemed that Buyer has done so at its sole discretion and risk. Variations in environment, changes in procedures of use or extrapolation of data may cause unsatisfactory results.

## Limit of Liability

MCU-Coatings<sup>®</sup> liability on any claim of any kind, including claims based upon MCU-Coatings<sup>®</sup> negligence or strict liability for any loss or damage arising out of, connected with, or resulting from the use of the products, shall in no case exceed the purchase price allowable for the products or part thereof that gave rise to the claim. In no event shall MCU-Coatings<sup>®</sup> be liable for consequential or incidental damages. Published Technical Data Sheets are subject to change without notice. Contact your MCU-Coatings<sup>®</sup> representative for the most up to date Technical Data Sheets.