



DESCRIPTION

- a two pack moisture curing, zinc rich, ethyl silicate primer/finish
- approved to APAS-2908
- zinc in dry film 71% by weight

PRINCIPAL CHARACTERISTICS

- liquid A and B packs
- provides cathodic protection to steel
- anticorrosive primer for structural steel
- suitable as a system primer in various paint systems based on non-saponifiable binders
- good impact and abrasion resistance
- must not be used for immersion or splash in alkaline (more than pH 9) or acidic (less than pH 5) liquids

COLOURS AND GLOSS

- Grey - flat

BASIC DATA AT 25° C / 80% RH

- mix ratio 3A:2B by volume
- typical film thickness (per coat) 75 microns(dry), 115 microns(wet)
- theoretical spreading rate 8.7 m²/l for 75 microns(dry)
- touch dry after 15 minutes
- overcoating interval refer overcoating table
- full cure after 24 hours
- shelf life (cool and dry place) 6 months

Zinc rich primers form zinc salts on the surface. At all times, any visible surface contamination and zinc salts must be removed before overcoating by high pressure potable water cleaning (min. 30 MPa/4000 psi), wet abrasive blasting, sweep blasting or mechanical cleaning.

RECOMMENDED SUBSTRATE CONDITIONS AND TEMPERATURE

- all surfaces to be coated must be clean, dry and free from chalking and contamination
- oil and grease should be removed from all surfaces in accordance with AS 1627.1 solvent cleaning
- mild steel; blast clean in accordance with AS 1627.4 to Sa 2½ minimum (AS 1627.9), surface profile 40-70 microns
- if oxidation occurs between blasting and application, the surface should be reblasted to the specified visual standard
- surface defects revealed by the blast cleaning process should be ground, filled or treated in the appropriate manner
- substrate temperature must be at least 5°C during surface preparation, application and curing and at least 3°C above dew point
- a heavily pitted steel substrate is not acceptable
- substrate temperatures ranging from 5°C up to 40°C are acceptable
- relative humidity should be above 60%

INSTRUCTIONS FOR USE

- mixing ratio by volume: zinc paste to liquid binder - 3A:2B
- induction time - none
- pot life at 25°C 8 hours. Do not use after this time even if the mix is still liquid
- stir the paste thoroughly before adding the binder
- add gradually one third of the binder to the zinc paste
- stir thoroughly until homogeneous
- add remaining binder and continue stirring until the mixture is homogeneous

- the temperature of the mixed product should be above 15°C
- thinner should only be added after mixing the components
- freshly catalysed material should not be added to product that has been mixed for some time
- agitate continuously during application
- for recommendations outside those contained in this data sheet, refer to WattyI

APPLICATION

- **AIRLESS SPRAY**
Avoid excessive film build as mud cracking may occur
 - recommended thinner Thinner L702
 - volume of thinner up to 10%
 - nozzle orifice..... approx. 0.48 mm - 0.64 mm (0.019 - 0.025 inch)
 - nozzle pressure 15 MPa (2100 psi)
- **AIR SPRAY**
 - recommended thinner Thinner L702
 - volume of thinner up to 10%
 - nozzle orifice..... 2 mm
 - nozzle pressure 0.3 MPa (50 psi)
- **BRUSH/ROLLER** (for spot repair and stripe coating only)
 - recommended thinner thinner not necessaryThe maximum dry film thickness that can be achieved when brushing/rolling is 50 microns
Multiple coats may be required to achieve the recommended dry film thickness
- **CLEANING SOLVENT** Thinner L702

SAFETY PRECAUTIONS

- flammable. Avoid contact with heat and naked flame
- avoid contact with skin and eyes
- use gloves, mask and goggles during application
- provide adequate ventilation when using in confined spaces
- this product is intended for use in industrial situations by professional applicators in accordance with the advice given on this sheet. All work involving the use and application of this product should be carried out in compliance with all relevant Health, Safety & Environmental standards and regulations and must not be used without reference to the Material Safety Data Sheet (MSDS)

ADDITIONAL DATA

Surface Preparation of Galvit ES510 before overcoating

- zinc rich primers can form zinc salts on the surface and these must be removed before overcoating
- zinc rich primers should NOT be weathered for long periods before overcoating
- in Industrial and Marine Conditions, the overcoating interval should be reduced to the practical minimum
- before overcoating, zinc salts, chalking and all other forms of visible surface contamination must be removed by high pressure (30 MPa/4,000 psi) potable water cleaning, wet abrasive blasting, sweep blasting or mechanical cleaning
- to prevent zinc salt formation and surface contamination where very long overcoating intervals are required, it is recommended to overcoat Galvit ES510 within two days with EpinameI PR250

**Overcoating table**

	Humidity	Substrate temperature			
		5°C	15°C	25°C	40°C
Minimum Interval	less than 60%	>7 days	>4 days	>48 hrs	>32 hrs
	60%	7 days	4 days	48 hrs	32 hrs
	80%	4 days	2 days	24 hrs	16 hrs
	greater than 80%	<4 days	<2 days	<24 hrs	<16 hrs
Maximum interval	Unlimited when free from zinc salts and contamination (See surface preparation notes above)				

- Galvit ES510 requires moisture for curing
- Galvit ES510 should have full cure before overcoating; relative humidity and temperature should be measured during curing to determine the overcoating time
- to reduce the curing time of Galvit ES510, allow a 4 hour flash-off time, wet the surface by spraying with fresh water and keep wet for the next 4 hours. Test for full cure after this time to determine if a further wet exposure period is required.
- curing will be retarded at low humidities. For relative humidities less than 60%, test for full cure before overcoating
- Galvit ES510 can be tested for full cure using a solvent rub test. The coated surface should be rubbed with a cloth soaked in MEK for determination of cure (refer AS 3894.4/ASTM D4752)
- to avoid possible solvent popping effects (pinholes) when recoating, Galvit ES510 must be sealed with Epinamel PR250 or a thinned first coat of high solids epoxy

Curing table

Humidity	Substrate temperature			
	5°C	15°C	25°C	40°C
less than 60%	>7 days	>4 days	>48 hrs	>32 hrs
60%	7 days	4 days	48 hrs	32 hrs
80%	4 days	2 days	24 hrs	16 hrs
greater than 80%	<4 days	<2 days	<24 hrs	<16 hrs

- adequate ventilation must be continuously maintained during application and curing.

Potlife (at application viscosity)

Paint temperature	Pot life
15°C	12 hrs
25°C	8 hrs
35°C	4 hrs

CUSTOMER SERVICE HOTLINE 132101 (Aust)

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