



PROTECTIVE COATINGS

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## TECHNICAL DATA

### INDURAZINC DF67

## COATING DATA

### DESCRIPTION:

Indurazinc DF67 is a two-component, moisture-cured organic zinc rich primer with dry fall capability. The dried film consists of 83% zinc by weight and provides the galvanic protection of zinc. The metallic zinc combined with the aromatic urethane resin forms a highly durable, densely cross-linked film with outstanding adhesion to provide excellent long-term corrosion protection. Quick cure, same day recoat, and unlimited recoat time allow for efficient shop and field priming and recoating. This product conforms to ANSI/AWWA D102-11 Outside Coating System No. 6. Zinc Dust certified under ASTM D 520 Type III, 99.99% pure zinc metal.

### USE:

As the prime coat in a multi-coat system designed for the protection of carbon steel in many moderate to severe atmospheric exposures. Indurazinc DF67 may be applied as a "dry fall" under most conditions (see Application).

### SURFACE PREPARATION:

**Steel:** SSPC-SP 6/NACE 3 Commercial Blast Cleaning. Surface profile shall be angular and 1.5 to 2.5 mils in depth. **Topcoating**—This primer must be topcoated in corrosive atmospheres for best performance. Indurazinc DF67 does not require profiling the surface prior to being topcoated with any product listed under recommended topcoats. Prior to topcoating, remove all chalk, zinc salts and other surface contaminants in accordance with the procedures detailed in SSPC-SP 1, SSPC-SP 2 and SSPC-SP 12.

### RECOMMENDED TOP COAT:

**Non-immersion topcoats:** AquaClean, PE-70, RC-70, Induraguard SG, Induramastic 85, Perma-Clean II, Indurethane 6600, Permastic Polyurethane, Perma-Gloss Fluorourethane and Aquanaut II Enamel.

### COVERAGE:

Theoretical 1,075 ft.<sup>2</sup> per gallon at 1.0 mil dry film thickness.

**DRY FILM THICKNESS:** 2.5 to 3.5 mils.

**WET FILM THICKNESS:** 3.7 to 5.3 mils.

## APPLICATION DATA

### PACKAGING:

**FOUR GALLON KITS:** Each kit consist of two parts; one premeasured five gallon container of liquid Indurazinc DF67 Primer PART A and one premeasured container of Indurazinc MC67 Primer Zinc Dust PART B. Part A and Part B mixed together yields four gallons of Indurazinc DF67 Primer.

### MIXING:

While under controlled power agitation, slowly sift the entire contents of Zinc Dust H-7901 PART B into the liquid PART A. Continue power agitation until both components are thoroughly mixed. Strain through a 30-50 mesh screen after mixing. Maintain minimum agitation during application to prevent settling and to avoid mixing air into the product.

**POT LIFE:**

6 hours @90F, 12 hours @70F, 18 hours @50F ( 50% Relative Humidity). Do not use this material past the pot life limits.

CAUTION: Conditions of high humidity or high levels of moisture during the use of this product will shorten the pot life. Avoid high speed agitation and keep containers covered to minimize exposure to moisture.

**APPLICATION:**

**Airless Spray**—Use .017-.019 tip orifice; 60 mesh filter; 3/8" material hose; 3000-3600 psi atomizing pressure. Weather conditions, applicator technique, pump size, spray tip and atomizing pressure may vary recommendations. Attention: Dry overspray can be wiped or washed from most surfaces. Satisfactory dry-fall performance depends upon height of work, weather conditions and equipment adjustment. Low temperature and high humidity are of particular concern. Test for each application as follows: Spray from 15 to 25 feet towards paint container. The material should readily wipe off. **Note:** Heat can fuse-dry overspray to surfaces. Always clean dry overspray from hot surfaces before fusing occurs. Be aware that exterior surface temperatures can be higher than air temperatures **Roll**—Use professional quality 1/4" or 3/8" synthetic cover. **Brush**—Use professional quality natural or synthetic bristle brush. **Ventilation:** When used in an enclosed area, provide adequate ventilation during application and cure.

**THINNING:**

For best results, thin up to 10% with Induron K-1017 Industrial Thinner. Clean up equipment with Induron K-1012 Industrial Thinner.

**CLIMATE:**

Use this product only if the substrate and the ambient air temperatures are between 35°F (2°C) and 120°F (49°C). The substrate should be dry and 5°F above the dew point.

**STORAGE:**

Shelf life is 10 months at a 20°F-120°F (7°C-49°C) storage temperature range.

**DRY TIME:**

Temperature	To Handle	To Recoat
95°F	1.0 hours	3 hours
85°F	1.25 hours	4 hours
75°F	1.5 hours	4 hours
65°F	2.0 hours	5 hours
55°F	3.0 hours	6 hours
45°F	4.0 hours	7 hours
35°F	5.0 hours	8 hours

Cure time will vary with humidity, surface and air temperature, and film thickness. For cure times for immersion service, reference the specified Induron topcoat technical data sheet.

**PHYSICAL DATA:**

VOLUME SOLIDS: 67% ± 2%  
SOLIDS BY WEIGHT: 90% ± 2%  
WEIGHT PER GALLON: 24.4 ± .2 lbs per gallon mixed  
VOLATILE ORGANIC CONTENTS:  
Mixed unthinned - < 2.6 lbs/gallon; < 312 grams/liter  
Mixed thinned 10% - < 2.6 lbs/gallon; < 312 grams/liter

**PERFORMANCE DATA:**

**GRAFFITI CLEAN-UP:** Spray Paint

100% removed with ketone solvent.

**SAFETY DATA:**

See individual product label for safety and health data information. Individual Material Safety Data Sheets are available upon request.