PRODUCT DATA SHEET

CAP ZINC 14

Two-component epoxy galvanizer

CHARACTERISTIC

Two-component high in zinc and epoxy hardeners resins. It is used for long-term protection of steel structures in marine and industrial atmosphere.

USE

It can be used as galvanizing primer on surfaces blasted to SA 2½. Cap zinc 14 can be used with qualified anti-corrosive systems.

TECHNICAL DATA

DESCRIPTION	VALUE
Specific weight (A+B)	1800/1900 g/l
Application temperature	<+250 °C
Flash point	27°C
Solid by volume % (A+B)	62±2%
VOC	330 g/l

THICKNESS AND YIELD

	Min.	Max	Recommended
Thickness of dry film (µm)	42	98	59
Thickness of wet film (µm)	65	150	90
Theoretical yield (m^2/l)	15.4	6.7	11.1
Theoretical yield (m^2/kg)	8,3	3,6	6,0

STORAGE

Product is stable till one year as long as it is kept in original and unopened buckets at temperature between +5°C e +30°C.

COLOUR

Grey.

PREPARATION OF SURFACE

New steel

The surface must be clean and dry, free of oils and other contaminants. Sandblasting Sa2,5.

Surfaces treated with shop primer

If undamaged, clean and free from any dirt, oil, grease, salts and dry, it can be painted otherwise perform the preparation as for coated surfaces.

Coated surfaces

Rusty coating: perform sandblasting Sa2,5;

Localized maintenance: perform mechanical preparation St3 followed by abrasion to white metal and high-pressure washing to remove oil, grease, dust and salt or sand blasting Round off the edges of the painting well anchored and restore the system in the original layers and thicknesses.

TOOLS

Roller and brush (for limited areas, edges, profiles), conventional and airless spray.

APPLICATION

Mix ratio in weight	100:14.5 Induritore Cap Zinc 14
Mix ratio in volume	100:33 Induritore Cap Zinc 14
Thinning	By Diluente S800 Airless: 0-5%; Conventional: 5-10%
Induction time	10' with temperature <10°C
Time of use 23°C	5h
Application condition	+5°C +40°C >3°C at dew point Relative humidity: <85%
Conventional spray	Nozzle: 0,05 mm Air pressure: 3,5-4 kg/cm^2

CAP ARREGHINI SpA 30026 PORTOGRUARO/VE Viale Pordenone, 80 Tel.0421 278111 Fax 0421 75498/ 0421 278115
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Application by airless	Nozzle pressure: 15 MPa (150 kp/cm², 2100 psi). Nozzle: 0,43 - 0,58 mm (0,017 - 0,023") Angle range: 40 - 80° Air pressure: Compression ratio: 45:1 (pressure 150-180 kg/cm²)
Thinner for washing	Acetone per lavaggio

DRYING TIME

Dry time are purely indicative as it might be longer or shorter by keeping in consideration ventilation, humidity, thickness of the applied film. Full curing takes place at temperatures >5 °C; it is however possible to apply the product even at lower temperatures. At low temperatures it is essential to ensure the induction time indicated. In case of high temperatures, apply the product immediately.
There is no limit to the maximum time of over painting, however the best adhesion occurs when the application of the next layer is performed before the complete curing.

Surface temperature	5°C	10°C	23°C	30°C
Out touch	50′	30′	15′	4′
Dry touch	3h	2,5h	1,5h	50′
Full catalysis	10gg	7gg	5g	3gg
Minimum time of over application	3h	2,5h	1,5h	50′
Maximum time of over application	n.d.	Nn	Nn	Nn

RECOMMENDED SYSTEM

Suitable for marine and industrial atmosphere C5-I C5-M high.

Product	Coat	Wet Thickness	Dry thickness
CAP ZINC 14	1	90	59
MIDDLE COAT MIOX	1	250	200
PUR CAP 51	1	85	50
Total	3	425	309

Suitable for marine atmosphere C5 M high

Product	Coat	Wet Thickness	Dry Thickness
CAP ZINC 14	1	90	59
MIDDLE COAT MIOX	1	250	200
PUR TOP 52	1	100	60
Total	3	440	319

Suitable for marine atmosphere C5 M high

Product	Coat	Wet Thickness	Dry Thickness
CAP ZINC 14	1	90	59
CAP MASTIC 14	1	250	200
PUR CAR 51	1	100	60
Total	3	440	309

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INSTRUCTIONS

To carry out the work in a proper way, it is needed to strictly follow the instructions for the preparation of the surfaces contained in the CAP Arreghini Books. The specification data and technical information have been calculated at +23°C with relative ambient humidity of 65%. In different conditions the data and the time intervals between the two phases of the above reported coating system may vary.

This technical information is intended as a rough guide. However, because of the enormous variety of media and application conditions, it is essential to check the suitability of the product and test the effectiveness on a sample.

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