

**SELAC B920HT3
ZINTECH PRIMER T-RUST PLUS DG**

Pure epoxy anticorrosive primer for multilayer cycle T-RUST PLUS

DESCRIPTION

B920HT3 is an epoxy primer especially designed to have a multilayer coating cycle entirely based on powder coatings .
The high level of zinc makes **B920HT3** very performing and gives it outstanding anticorrosive properties allowing to consider it as an interesting alternative to hot dipping galvanization .
The following coupling with a suitable topcoat (PE-A , PE-I , PE-SD polyester for outdoor exposure or epoxy-polyester in case of indoor use) allows to obtain a very performing system having outstanding functional behaviour as well as excellent aesthetic and decorative properties .

GENERAL PROPERTIES

Good mechanical properties
Reduced resistivity , meaning easier overcoatability
Excellent overcoatability with topcoats , even 30 days after primer application
Excellent adhesion to substrate and excellent intercoating adhesion
Outstanding corrosion resistance (see drafts)
Good " anti-bubble " properties
Good adhesion on galvanized supports

TECHNICAL FEATURES

Surface texture : smooth
Colour : grey
Specific gravity : 2,7 - 2,8 g/cc
Theoretical yield at 60 micron : approx 6,2 sqm/kg
Brilliance at 60° : 45 - 60

SUPPORT PREPARATION

Painting must be done on clean support , free from oil , grease , oxidation , residuals (working , welding and rinsing processes , and any contaminating agent must be avoid
Iron and steel : iron or zinc salts phosphatization
Aluminium : cromatation or chrome-free pretreatment are recommended
Hot dipping galvanized steel : according with the item adopt mechanical treatment , phosphatization or chromatation process .

THICKNESS

Minimal recommended thickness is 60 microns , but in any case the coating layer must completely cover any surface roughness , especially in case of sandblasted supports .

**APPLICATION METHODS
AND RECYCLE**

The application is possible with manual or automatic electrostatic devices , both corona and tribo .
Overspray can be recycled in the fresh powder and re-used , but the use of integral recycle is not recommended at all ; do not exceed 25% and maintain a constant feeding of fresh powder .
According to the high density it is suggested to define dedicated application set-up .
An increasing of spraying and fluidizing air pressure could be necessary .

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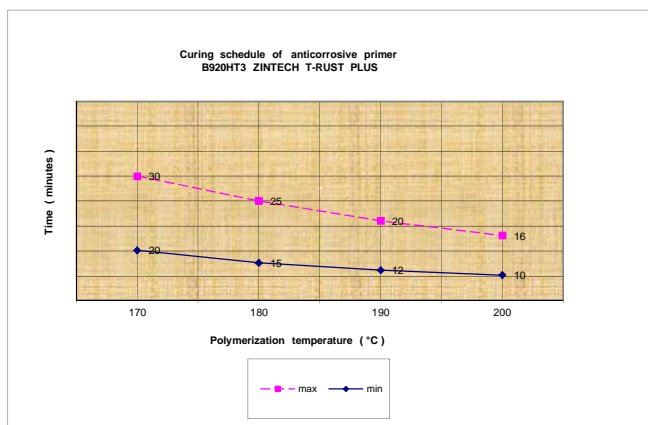
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CURING CONDITIONS

Drafts interpretation

To obtain functional, optical and aesthetic properties mentioned in TDS the curing schedule adopted for the products must be in any point of the draft area comprised between the curves of minimum and maximum.

Times always refer to object temperature (PMT), being the heating time variable from item to item and from plant to plant.



B920HT3 may be cured in conventional, IR irradiance or combined ovens.

MULTILAYER SYSTEMS

The polymerization of the primer may be completed also after the application of the topcoat layer (with PE-A, PE-I, PE-SD polyesters or with hybrid products in case of goods not for exterior).

In these cases the coating cycle may include a 2-3 minute semi-polymerization in the oven, the overcoating with the topcoat and the contextual complete curing of both two layers in the conditions defined for the topcoat, if they are suitable for the primer too.

This cycle ensures a very good adhesion to the support as well as an excellent intercoating adhesion.

Further informations about the corrosivity classes according with norm ISO 12944 are mentioned on a dedicate informative leaflet, available on demand.

MECHANICAL PROPERTIES

Test conditions : trials are made on normalized UNI 5961 panels 0,6 mm thick, degreased with solvent, coated with 70 - 80 micron of powder completely cured.

Mentioned results are obtained under controlled lab conditions; therefore these values are merely indicative and must be confirmed in the actual use conditions under the responsibility of each single user.

Minimal polymerization conditions (PMT)

20' @ 170°C - 15' @ 180°C - 12' @ 190°C - 10' @ 200°C

Primer thickness : 70 - 80 micron.

Direct impact : min. 20 Nm (ISO 6272)

Erichsen embossing (ISO 1520) : min. 4 mm

Cylindrical mandrel (ISO 1519/73) : pass 3/16" = 5 mm

Adhesion (ISO 2409) : GT 0/1

Buchholz hardness (ISO 2815) : min. 85

Pencil hardness (ASTM D3363) : H - 2H

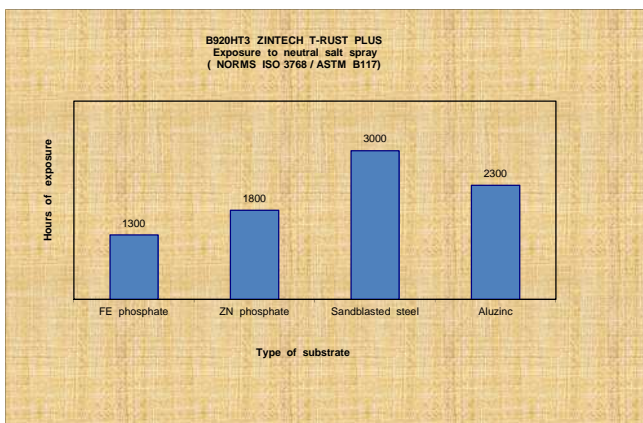
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**CORROSION
AND DURABILITY**

Test conditions : trials are made on normalized UNI 5961 panels 0,6 mm thick , treated by microcristalline zinc salts phosphatization , or on AA 5005-H24 chromated aluminium panels , coated with 70 - 80 micron of powder completely cured .

Mentioned results are obtained under controlled lab conditions ; therefore these values are merely indicative and must be confirmed in the actual use conditions under the responsibility of each single user .



Salt spray test (ISO 3768 / ASTM B117)

Support UNI 5961 steel treated by zinc phosphate

After 1800 hours rust penetration at the cross-hatch : max. 4 mm

Saline-acetic spray test (ISO 9227)

Support UNI 5961 steel treated by zinc phosphate

After 1500 hours rust penetration at the cross-hatch : max. 16 mm

STORAGE AND STABILITY

Product must be stored in the original sealed packagings , in a cool and dry place and at a temperature not exceeding 30°C .

In these conditions **B920HT3** is stable for a period of 36 months .

RECOMMENDATIONS

These informations are given on the base of our best experience as well as the one of specialized laboratories and they are continuously updated , nevertheless the user has the complete responsibility to apply and to experiment the products according its own specific necessities .

This document has the intention to describe and summarize the main properties of arsonsisi products , but in no case it can be considered as a warranty for them . Further informations about application of metallic effects , maintenance of goods coated with homologated polyesters or availability of special versions are mentioned in specific technical integrative notes .