



# MaxStrong Zinc 390

## PRODUCT DESCRIPTION

MaxStrong Zinc 390 is a Micaceous iron oxide (MIO)/zinc-pigmented, one component, moisture-cure polyurethane primer. For use over steel or weathered galvanized metal, or as a spot primer for marginally cleaned or blasted surfaces.

## PRODUCT FEATURES

- 65% minimum weight of zinc in dry film
- Can be applied in damp, cold, humid, or foggy conditions
- Can be applied at a minimum of -7°C (20°F) and humidity up to 99%, no dew point temperature differential restrictions
- Mixture of MIO/zinc for high-corrosion performance.
- Quick recoat times
- Cures in less time than two-component conventional primers and epoxies
- Does not become brittle with age
- No pot agitation required
- Can be used as a spot primer over hand or power-tool-cleaned, previously painting surfaces
- pH range 4 to 11

## TYPICAL USES

- Structural Steel
- Chemical Processing Facilities
- Bridges
- Tanks Exteriors
- Pipes
- Water Treatment Facilities

## TECHNICAL DATA

|                                       |                                | Drying times: (depend on humidity) |   |
|---------------------------------------|--------------------------------|------------------------------------|---|
| <b>Color:</b>                         | Green or gray tint             | <b>Dust free:</b>                  | 2 hours   |
| <b>Gloss:</b>                         | Flat                           | <b>To recoat:</b>                  | 4-6 hours   |
| <b>Type of Cure:</b>                  | Atmospheric Moisture Cure      | <b>Hard:</b>                       | 24 hours  |
| <b>Solids by volume:</b>              | 62% +/- 2%                     | <b>Reduction solvent:</b>          | X-34  |
| <b>Solids by weight:</b>              | 88% +/- 2%                     | <b>Dilution:</b>                   | 10% by volume if necessary  |
| <b>Theoretical Coverage at 1 mil:</b> | 994ft <sup>2</sup> / US gallon | <b>Shelf life:</b>                 | 12 months @ 25° C unopened  |
| <b>microns:</b>                       | 92m <sup>2</sup> / 3.78 liters | <b>Pot life:</b>                   | Newly Opened Cans :16 hours<br>Working pot, Spray Application: 6 to 8 hours<br>Working Pot, Brush or Roll application: 4 to 6 hours |
| <b>Recommended D.F.T.: mils:</b>      | 3-4 mils (75-100 microns)      | <b>Packaging:</b>                  | 3.78 lts (1 US gal)<br>11.36 lts (3 US gal.)  |
| <b>Viscosity:</b>                     | 85-100 Ku                      |                                    |   |
| <b>*Specific gravity</b>              | 2.34 – 2.58 kg./lt.            |                                    |   |
| <b>Flash Point:</b>                   | Above 46°C (114 °F)            |                                    |   |
| <b>VOC:</b>                           | 110 grams/liter                |                                    |   |

\*Keep in a cool dry area



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## PRODUCT LIMITATIONS

- Avoid application over visible droplets or puddles of water or ice formations.
- Stated cure times are at 40% minimum relative humidity and temperatures of 10°C (50°F) to 38°C (100°F). Allow more time at humidities below 40% and temperatures below 10°C (50°F).
- Not recommended for strong acid, alkali, or severely corrosive environments without appropriate topcoats.
- For rapid recoat; refer to Pur-Acc accelerator data sheet. Recoat times for intercoat adhesion will be shortened. Consult Lahalt before use.
- Maximum wet film thickness should not exceed 7 mils (175 microns).
- Avoid storing in temperature above 29°C (85°F) or direct sunlight.

## APPLICATION GUIDE

### SURFACE PREPARATION

Prior to hand-tool cleaning (SSPC-SP-2), power-tool cleaning (SSPC-SP-3 or SSPC-SP-11), or abrasive blasting, remove all grease, oil, soils, contaminants in accordance with SSPC-SP-1 "solvent cleaning".

Round off rough welds and sharp edges, and remove weld spatter.

Abrasive blast to a minimum of commercial blast in accordance with SSPC-SP-6 or Swedish Standard Sa2. The blast profile should be between 1½ and 2½ mils (37.5 and 62.5 microns).

After blasting, vacuum or remove all abrasive dust and ensure the surface remains clean before painting.

Further remove any remaining soluble salts on the receiving surface prior to painting. If the primer remains unpainted for a period of time, any salt contamination must be removed using salt solubilizing agents in water wash.

### MIXING AND THINNING

Zinc 390 is supplied in either 1 gallon or 3 gallons containers. The entire contents of the containers must be mixed well before application. Thinning is not required; however, at lower temperatures, up to 10% of X-34 thinner can be added, depending on local VOC and air quality regulations. Mix gently. Do not "box" or create vortex.

\*Reduction Solvent: X-34 thinner                      Clean-UP Solvent: X-50

Air spray: 10% reduction if necessary

Airless spray: If required

Brush (Natural or synthetic short hair, stiff bristle) and roller: No reduction necessary

Paint temperature must always be above the dew point before mixing or application.

\* Contact a Eclat representative when solvent reduction may be needed

### APPLICATION

| Drying Times               | Recoat time                                      |               |               |          |          |
|----------------------------|--|---------------|---------------|----------|----------|
|                            | Dust Free  | Hard          | Minimum       | Maximum  | Normal   |
| < 20°F (-7°C) **           | Not recommended to paint below this temperature. |               |               |          |          |
| 20° to 40°F (-7° - 5°C)    | 6 - 18 hours                                     | 72 - 96 hours | 12 - 18 hours | 2 months | 72 hours |
| 50°F - 100°F (10°C - 38°C) | 4 - 6 hours                                      | 24 hours      | 4 hours       | 2 months | 24 hours |



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## APPLICATION

| CONVENTIONAL SPRAY       |  | AIRLESS SPRAY       |                              |
|--------------------------|--|---------------------|------------------------------|
| <b>Manual Spray gun:</b> | Similar to DeVilbiss JGA-510 or equivalent | <b>Pump Ratio:</b>  | 30:1                         |
| <b>Fluid Nozzle:</b>     | E Fluid Tip                                | <b>Pressure:</b>    | 3000 psi                     |
| <b>Air Cap:</b>          | 704 or 765                                 | <b>Tip Size:</b>    | 0.017 - 0.021 inch           |
| <b>Atomizing Air:</b>    | 45 - 75 lbs.                               | <b>Hose:</b>        | 3/8 in. 50 ft length maximum |
| <b>Fluid Pressure:</b>   | 15 - 20 lbs.                               | <b>Filter Size:</b> | 50 mesh (300 um)             |
| <b>Hose:</b>             | 1/2 in., 50 ft length maximum              |                     |                              |

See the material safety data sheet and product label for complete safety and precaution requirements.

**DISCLAIMER:** "The following is made in lieu of all warranties, expressed or implied: Manufacturer's obligation shall be to replace such quantity of the product proven to be defective. The manufacturer shall not be liable for any injury, loss or damage, direct or incidental or consequential, arising out of the use of or the inability to use the product. Before using, the user shall determine the suitability of the product for the intended use and the user assumes all risk and liability whatsoever in connection therewith. All values shown are approximations. Values indicated are for guide purposes only, as actual values can change due to application conditions, application methods, environmental conditions etc. The information contained herein is subject to change without notice. Consult your representative for a current data sheet. The foregoing may not be altered except by an agreement signed by the officers of the manufacturer."



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