Tinol Paints International Co. s.a.l.
Est. 1956 - C.R. 7155 Beirut - Capital L.L. 1 250 000 000 Fully Paid - paints@tinol.com - www.tinol.com - Fax 01/867071
Head Office: Verdun, 01/812345 • Factory: Choueifat, 05/435500 • P.O.Box: 11 - 4895 Beirut, Lebanon
Tinol World of Colors: Verdun, 01/812812 • Bouchrieh, 01/245222 • Choueifat, 05/430043

STAND THE TEST OF TIME

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Product Specification Sheet:

Tinopoxy Primer – Intermediate Metal Coating

Curing agent: Hardener 864

Epoxy corrosion & chemical resistant metal primers & intermediate coatings

Zinc Phosphate, series 8600

CHARACTERISTICS

Tinopoxy Primer-Intermediate Metal Coating, Series 8600 is two-pack cold cured epoxy solvent-based primer-intermediate coating in high-build form, incorporating rust inhibiting pigments to protect ferrous surfaces against atmospheric and industrial corrosion and simultaneously serve as an intermediary coating on metal surfaces. It combines the characteristics of rust resistant primers and intermediate coatings in one product for practical applications, especially for maintenance painting.

Tinopoxy Primer-Intermediate Metal Coating, Series 8600 is intended to be applied directly to well-prepared steel & zinc coated (galvanized) metal surfaces in coastal, urban and industrial environments and on surfaces to be immersed in water or buried in soil. It is heat resistant (up to 120°C) & is resistant to chemicals, acids, solvents, oils, saline and sewage water etc…

TECHNICAL DATA

Solvent-bearing epoxy-based coatings, complying with the technical requirements of International Specifications ISO 12944-5 & British Standards BS 5493 "protective paint systems for steel structure".

COMPOSITION

Characteristics	Zinc phosphate Series 8600
Total solids, by volume	58%
Total solids, by weight	78%
Non-volatile resin, by weight	29%
Pigments, by weight	50%
Density kg/L	1.52
Mixing ratio: Hardener 864 to Base Component, by volume	1:5.8
VOC content	241 g/L

RECOMMENDED USES

Direct to metal coatings for protection of exterior exposed and interior steel surfaces in industrial, coastal & urban environments. Ideal for application over TINOPOXY ANTI-RUST & ZINC RICH PRIMERS to reinforce the effectiveness of corrosion prevention and serve as an intermediary layer for finishing coats, especially in marine & industrial environments with very high atmospheric corrosion and/or on surfaces to be immersed or buried.

Zinc Phosphate, Series 8600 is more suitable for application in buildings, hydraulic engineering works, plants etc…

SURFACE PREPARATION

Surfaces must be well prepared, solid, clean and dry, free from oils, salt, dirt, and other contaminants.

Rust, mill scale and all deteriorated previous coatings should be removed. Best results are obtained by abrasive blasting to international standards. Swedish Standard Sa 2½ (sand blast cleaning) is acceptable in environments with medium-high atmospheric corrosivity. St2 or St3 standards (hand or power tool cleaning) is acceptable in environments with low-medium atmospheric corrosivity.

Hot-dip-galvanized surfaces should be free from contaminants, oils, dirt, zinc corrosion or oxidation products (white rust), zinc ash or salts. Wash priming with TINOPRIME ACTIVATOR 7 followed by washing with water (preferably pressurized water) is recommended.

Spot prime welded areas & cuts with TINOPOXY ZINC RICH PRIMER, Nr. 15400 at 40µm d.f.t.

MIXING

Pour contents of Base Component into a larger container, add its HARDENER 864 supplied with each pack and stir well, then leave mixture for about 20 minutes to react before thinning & application.

Pot life:
Mixture with HARDENER 864 remains usable for about 5½ hours at room temperature (about 23°C & 65% r.h.). Higher temperatures reduce the pot life and vice-versa.

THINNING

Use TINOSOLVE 1007 to thin as needed, about 10% for airless spray application, and about 10-15% for brush/ roller application. In hot weather, use TINOSOLVE 1014 for brush/roll application.

APPLICATION

As per Code of Practice and technical requirements of ISO 12944-5 & BS 5493.
Spray (airless spray) in thicknesses of up to 200µm wet film thickness per coat. Brush/roll application is also possible. Immediately after use, clean tools and equipment.
80-100µm d.f.t. is recommended to give adequate rust protection in coastal environments, followed by finishing coats.
Stripe coats on edges and peaks are recommended to insure proper film thickness.
Recoating should be carried out before the complete curing of the preceding coat, otherwise the surface should be roughened with sandpaper.

This coating could be applied as self-priming finishing coating or could be top coated with all TINOPOXY epoxy coatings, TINORETHANE polyurethane paints, TINOMARINE chlorinated rubber paints, TINOCHLORYLIC acrylic / chlorinated rubber paints & SUPER TINOLUX Pu modified paints.

For maintenance painting, remove rust spots, clean surface and spot apply **Tinopoxy Primer-Intermediate Metal Coating** in the required thickness, after compatibility field check.

CONDITION OF APPLICATION

Can be applied at surface temperatures from 5°C. Apply only to surfaces with temperatures at least 5°C above the dew point. This product may be applied optimally at relative humidity ranging from 30% to 65%. Good ventilation is necessary. The product should not be exposed to mechanical stress until fully cured.

APPLICATION EQUIPMENT

Brush	Recommended for coating small areas	
Roller	Typical phenolic core rollers should be used	
Conventional spray	Pressure pot equipped with dual regulators, 3/8" I.D. Minimum material hose, .070" I.D.50" fluid tip and appropriate air cap.	
Airless Spray	Pressure at nozzle	1400 - 3000 psi
	Nozzle tip	0.019"- 0.023"

DRYING & RECOATING TIME

At a temperature of 23°C and 65% relative humidity, a coated film of 100µm w.f.t. dries to touch in 2 hours and dries to recoat in 10-24 hrs.
Higher temperatures accelerate drying time and vice-versa.

GLOSS

Low sheen (eggshell finish).

COVERAGE

Depends on condition of surface and film thickness required. Contents of one gallon of Base Component + its Hardener 864 = 4.440 cover 32sq.m. at 80µm d.f.t.

COLORS

Available in medium grey as a standard color. Slightly variant colors could be supplied on demand.

PACKING

Into standard tin containers of:
• 1 US gallon = 3.78 L **e** • 1 US quart = 0.94 L **e** • 5 US gallons pail = 18.9 L **e** (on request).

CAUTION

Flammable liquid. Keep away from flame or high heat. Flash point 21ºC.
Avoid inhalation of spray mist and arrange for adequate spraying precautions.
Arrange for adequate ventilation upon application especially when spraying. Do not breathe vapour or spray mist.
As in all industrial paints & coatings in their liquid form, safe handling requires precautions.

Handle with care. Keep container tightly closed. Avoid contact with eyes. Do not smoke, eat or drink while applying these products. It is recommended to wear suitable gloves. Do not contaminate with surface water and do not pour into drainage system.

WARRANTY

TINOL products are warranted to be free of material and manufacturing defects, and to give the performance required of good quality coatings of International Standards, when properly applied in accordance with the written directions and the Code of Practice.
If any product proves to contain material or manufacturing defects that substantially affect its performance, it will be either replaced free of charge or purchase price will be reimbursed. Other liabilities or claims for any consequential loss or damage are disclaimed.

DISCLAIMER

The information in this document is given to the best of Tinol's knowledge, based on laboratory testing and practical experience. Tinol's products are considered as finished goods and as such, products are often used under conditions beyond Tinol's control. Tinol cannot guarantee anything but the quality of the product itself. Minor product variations may be implemented in order to comply with local requirements. Tinol reserves the right to change the given data without further notice.
Users should always consult Tinol for specific guidance on the general suitability of this product for their needs and specific application practices.