PEACOSIL 100

Product Code: 7911

Date: Feb 2012 (Page 1 fo 2)

PRODUCT INTRODUCTION

- Two component moisture curing Zinc (Alkyl) Silicate coating
- Used as anticorrosive primer for structural steel
- Suitable as a system primer in various paint systems based on unsaponifiable binders
- Galvanic action eliminates sub film corrosion
- Can withstand substrate temperatures from -90°C up to +600°C, under normal atmospheric exposure conditions
- good impact and abrasion resistance
- Must not be exposed to alkaline (more than pH 9) or acidic (less than pH 5) liquid

PHYSICAL PROPERTIES

Colours and gloss	Greenish Gray-flat
Mass density	approx. 2.1kg/m ³
Solids content (by volume)	approx. 66%
VOC	240 g/litre
Recommended dry film thickness	average dft 75μm with a minimum of 60μm on smooth, non-pitted, blast cleaned steel
	average dft 100μm with a minimum of 75μm on rough or pitted, blast cleaned steel
Theoretical	8.8m ² /l for 75μm
spreading rate	6.6m² /l for 100μm 5.2m² /l for 125μm
Touch dry after	25 min at 20°C
Overcoating interval	min. 6 hours
	max. No limitations without Zinc salt
Shelf life(cool and dry place)	at least 9 months
Flash point	binder 15°C , pigment above 65°C

APPLICATION CONDITIONS AND TEMPERATURE

- Steel; blast cleaned to ISO-Sa2.5, blasting profile; (Rz) 49-70μm
- Shop primed steel (Zinc Silicate); sweep blasted to SPSS-Ss to remove Zinc salts and contamination
- Weld seams, burned and rusty area blast cleaned to roughen the surface and to remove any Zinc salts which might be present
- Substrate temperatures form -5°C up to +90°C during application are acceptable
- At high substrate temperatures (above 40°C) PEACOSIL 100 must applied by spray, and to avoid dry spray, thinner 068 has to be added
- Substrate temperature must be at least 3°C above dew point
- Relative humidity should be above 40%

APPLICATION INSTRUCTIONS

Mixing ratio

Part A to Part B 41: 59 by weight

Part A to Part B 81: 19 by volume

- Add the Part B gradually to the container with Part A, using a mechanical mixer
- Stir the Part B thoroughly through the binder
- Do not mix in reverse order, in order to avoid lumps in the paint
- Stain mixture through a 30-60 mesh screen
- Agitate continuously during application
- At an application temperature above 30°C addition of max 10% of thinner 068 may be necessary



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www.cschk.com Tel : (852) 2959 3998 Fax: (852) 3521 0438 Email: cschk@cschk.com

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Date: Feb 2012 (Page 2 fo 2)

	AIRLESS SPRAY	AIR SPRAY
Recommended thinner	Thinner 068 (flash point 30°C)	Thinner 068 (flash point 30°C)
Volume of thinner	<10%	<10%
Nozzle orifice	Approx. 0.48- 0.64mm(0.019- 0.025inch)	2mm
Nozzle pressure	15MPa (approx. 150 AT; 2100 P.S.I.)	0.3MPa (Approx. 3AT; 42 P.S.I.)

BRUSH

- only for touch up and spot repair
- first coat not to be thinned down, max, dft 35μm
- next coat to be thinned down with thinner 068 (10-25% by volume), so that a visible wet coat can be applied, max. dft 25µm

CLEANING SOLVENT	

Thinner 068(flash point 30°C)

OVERCOATING TABLE						
substrate temperature (°C)	-5	0	10	20	30	40
minimum interval (hours)	24	24	16	8	6	4
maximum interval	unlimited, provided that the surface is cleaned from contamination and zinc salts			S		

- In order to avoid possible solvent popping effects (pinholes) PEACOSIL 100 should be sealed with organic coating like Peacopoxy sealer
- Peacosil 100 should have sufficient cure before overcoating, relative humidity and temperature should be measured during the curing time
- A RH below 50% requires a much longer overcoating interval
- Curing can be accelerated by spraying water onto the coated surface 4 hours after application
- The surface should be (kept) wet for the next 2 hours

CURING TABLE

substrate temperature	dry to handle	full cure
-5°C	2 hours	24 hours
0°C	2 hours	24 hours
10°C	1 hours	16 hours
20°C	30 minutes	12 hours
30°C	30 minutes	6 hours
40°C	30 minutes	4 hours

POT LIFE (AT APPLICATION VISCOSITY)

0°C	24 hours
10°C	16 hours
20°C	12 hours
30°C	6 hours

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Email: cschk@cschk.com