TYPE: **An epoxy glassflake coating, intended for a single coat application.**

SUGGESTED USE: Zip E will provide cost effective, durable protection in aggressive atmospheric conditions and aquatic immersion environments. Zip E has excellent application characteristics and edge coverage in single coats. Zip E has good cosmetic appearance and gloss. Zip E may be used for structural steel, bridges, pilings decks, externals of process vessels/pipelines, jetties, ships hulls and other marine environments.

LIMITATIONS: Unsuitable for immersed service in many solvents and chemical service environments. Temperature limit immersed is 122˚F (50ºC), non immersed limit 194˚F (90ºC).

HEALTH AND SAFETY: Before handling or using this product the material **safety data sheet should be read** and all precautions observed.

SURFACE PREPARATION: **Metals:** For best results Grit blast to SSPC-SP10 standard. (For full details refer to Corrocoat Surface Preparation Specification SP1.) Zip E can also be applied to mechanically prepared or water blasted surfaces or where Plasmet ZF has been used as a primer. **Concrete: Priming is required,** see Corrocoat Surface Preparation sheet SP5, use Plasmet ECP as the primer.

APPLICATION: Airless Spray pump minimum 45:1 ratio, with an output of at least 1.06 Gal (4 liter per minute). The pump should be fitted with a leather/Teflon seal combination and all fluid filters removed. Use nylon lined ⅜" (10mm) internal bore spray line with a short ¼" (6.5mm) whip and a large bore spray gun fitted with a swivel connector. 17 to 23 thou reversible spray tip is recommended. Spray tip and fan pattern will vary and should be selected to suit the nature of the work. Fluid pressure approximately 4,000PSI depending on temperature, spray line length, etc. Zip E should not be applied or used at temperatures below 41˚F (5ºC).

Zip E may be applied with a brush or short haired roller.

POTLIFE: Generally 50 –60 minutes using the standard hardener at 68˚F (20ºC). Pot life **will vary significantly** with temperature.

Temp	39˚F (4 ºC)	50˚F(10 ºC)	68˚F(20 ºC)	86˚F(30 ºC)	86˚F(30ºC) *	104˚F(40ºC)
Pot life	6 hours	150 min-	60 min-	30 min-	50 min	35 min

* using "tropical" grade hardener, mix ratio for temperate and tropical hardener is the same.

THINNERS: The performance of this product will be adversely affected by the use of solvent based thinners. Under normal application conditions it is not anticipated that any thinners will be required with this product

PACKAGING: **5 Gallon (**18.9 Liter) composite kit. (Other sizes may be available upon request).

CATALYST/ HARDENER TYPE: Modified Amine Adduct

STORAGE LIFE: Base and Hardener: 12 months in unopened tins, store away from heat sources and direct sunlight.

COLOR AVAILABILITY: White and light grey as standard. Other colors available upon request, price of material subject to color and quantity.

Note: This product is formulated to give optimum corrosion resistance. Due to the nature of the polymerization process of this product, it is not possible to guarantee color matching or color stability. Where color stability is of paramount importance, it is recommended that Zip E is over coated with Corrothane AP1.

RECOMMENDED DFT: Dependent upon intended use, geometry of work and service conditions. Zip E is normally applied to achieve DFT's of 8 to 40 mils (200 to 1,000 microns) by applying at 10% greater WFT's. Single coat application is preferred but multiple coats may be used to achieve the required DFT, refer to data on overcoating times.

VOLUME SOLIDS: Greater than 93 %.

PRACTICAL COVERAGE RATE: Approximately 24 SF/Gal at 20 mils (0.6 liters/m^2 at 500 microns) DFT.

Note: This information is given in good faith but consumption may increase dependent on the environmental conditions, geometry, nature of work undertaken and the skill and care of application. **Corrocoat accepts no responsibility for any deviation from these values.**

SPECIFIC GRAVITY: Base: 1.20 g/cm^3 Hardener: 1.06 g/cm^3

FLASH POINT: 133˚F (56 ºC)

MIXING RATIO: 71.5:28.5 Base to Hardener by weight / weight.
(note: mix ratio of temperate and tropical grade of hardener is the same)

ELONGATION TO BREAK: 4%
(BS 6319, part7)

IMPACT RESISTANCE: 14 Joules
(BS 3900 part E3)

VOC LEVEL: 31.7 g / liter

ADHESION: 2660 lbs/sq/in **(**187 Kg/$cm^{2)}$
(ASTM D 1002)

(BS 3900 part F11) applied onto an SSPC SP10

CATHODIC DISBONDMENT: 0 mm disbondment and 0 mm ion spread on a 12 mils (300 microns) film

OVERCOATING: Where multiple coats are required, overcoating may take place after 3 hours at 68˚F (20ºC). The maximum overcoating time is 72 hours at 68˚F (20ºC). Overcoating times will reduce significantly at higher temperatures **and/or** in strong sunlight. The minimum overcoating time at 50˚F (10ºC) is 24 hours, refer to Corrocoat Technical Services for overcoating instructions below 50˚F (10ºC).

TACK FREE TIME:

Temp	41˚F (5ºC)	50˚F (10ºC)	68˚F (20ºC)	86˚F (30ºC)	104˚F (40ºC)
Tack-free	9 hours	6.5 hours	3.5 hours	3 hours	2 hours

CURE TIME: Tack-free in less than 3.5 hours, full cure 4 days at 68˚F (20ºC). Tack-free and full cure values will vary subject to ventilation and temperature.

CLEANING SOLVENT: For best results use Corrocoat Epoxy Equipment Cleaner

All values are approximate. Physical data is based on the product being in good condition before polymerization, correctly catalyzed and full cure being attained. Information regarding application of the product is available in the Corrocoat manual. Should further information be required, please consult Corrocoat Technical Services.

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