



Rustbuster Zinc Rich Epoxy Anode

Product characteristics

Description

Rustbuster Epoxy Zinc Rich Anode is an activated, zinc-rich epoxy primer in compliance with the requirements of Level 2, type II in SSPC Paint20, 2019 and ISO 12944 Part 5, 2018. The product is in full compliance with ASTM D520 type II and EU Directive 2004/42/EC, the Paints Directive on the limitation of volatile organic compounds: subcategory j.

Recommended use

Rustbuster Epoxy Zinc Rich Anode is recommended as a versatile primer for long-term protection of steel in severely corrosive environments including offshore.

Service temperature:

- Maximum, dry exposure only: 160°C [320°F].

Certificates / Approvals

- Meets requirements to NORSOK M-501 when used as part of a predefined paint system. Edition 6, system no. 1.
- Complies with the European Fire Standard EN 13501-1, reaction to fire classification, when used as part of a predefined paint system. B-s1, d0.

Features

- Reduces the effect of corrosion and provides excellent galvanic protection.
- Fast drying primer with short minimum overcoating intervals.
- Excellent mechanical strength, also in cyclic temperatures, with improved tolerance to high film thickness through high flexibility and self-healing effect.
- Superior tolerance to high relative humidity during application.
- Cures down to -10°C [14°F].

Product safety

Flash point 25°C [77°F]

VOC content mixed product

Legislation	Value	5% thinning, by volume	Limit value, phase II (2010) ^a
EU	330 g/L [2.75 lb/US gal]	356	500
US (coatings)	330 g/L [2.75 lb/US gal]		
US (regulatory)	330 g/L [2.75 lb/US gal]		
China	330 g/L [2.75 lb/US gal]		

VOC values may vary with shade, please consult the Safety Data Sheet, section 9. According to specific legislation, see details in the Explanatory Notes available at Rustbuster website, Rustbuster.com or at your local Rustbuster website. ^aEU Directive 2004/42/CE.

Handling

Handle with care. Before and during use, observe safety labels on packaging and paint containers and follow all local and national safety regulations. Always consult Rustbuster's Safety Data Sheet for this product along with the Product Data Sheet.

For professional use only.

Product data

Product code

RBZincRich

Product components

Base 1736U
Curing Agent 97043

Standard shade / code

Grey 19840

Gloss

Flat

Volume solids

65 ± 2%



Rustbuster Zinc Rich Epoxy Anode

Specific gravity

2.3 kg/L [19 lb/US gal]

Reference dry film thickness 60

micron [2.4 mils]

Surface preparation

Cleanliness

- Remove oil, grease and other contaminants by suitable detergent cleaning.
- Remove salts, detergents and other contaminants by high pressure fresh water cleaning.

New build:

- Abrasive blasting to min. Sa 2½ (ISO 8501-1) / SP 10 (SSPC). - Remove dust, blast media and loose materials.

Roughness

- Surface profile Medium (G) (ISO 8503-2).

Consult Rustbuster's separate Surface Preparation Guidelines for more details.

Application

Mixing ratio

Base 1736U : Curing Agent 97043
(8.5 : 1.5 by volume)

Products containing floating or settling particles/pigments need to be continuously stirred during application. This is especially important in case of heavy thinning.

Thinner/Cleaner

Above 20°C [68°F] Rustbuster's Epoxy Thinner

Pot life

Product 0°C 20°C 40°C temperature [32°F] [68°F] [104°F]

Pot life	5 hours	4 hours	1½ hours

Application method

Tool	Thinnin	Application parameters
	max vol.	
Airless spray	5%	Nozzle pressure: 220 bar [3200 psi] Nozzle orifice: 0.017-0.021"

If brush or roller application is used, more coats will be necessary to achieve the specified dry film thickness. Spray data are indicative and subject to adjustment. Pressure is for a material temperature of 20°C [68°F].

Film thickness

Specification range	Low	High	Recommended
Dry film thickness	40 micron [1.6 mils]	100 micron [3.9 mils]	60 micron [2.4 mils]
Wet film thickness	60 micron [2.5 mils]	150 micron [6 mils]	90 micron [3.5 mils]
Theoretical spreading rate	16 m²/L [650 sq ft/US gal]	6.5 m²/L [260 sq ft/US gal]	11 m²/L [450 sq ft/US gal]

Overthickness should be closely controlled and never locally exceed 200 micron [7.9 mils] DFT. On irregular surfaces it is recommended to employ special care in avoiding over application.

Application conditions

- Temperature of product must be above 15°C [59°F] during application.
- To avoid condensation, apply on a clean and dry surface with a temperature that is at least 3°C [5°F] above the dew point.
- Surface temperature must be above -10°C [14°F] during application and curing.
- Surface temperature must be below 40°C [104°F] during application and curing.

Relative Humidity:

- Relative humidity must be below 95% during curing.
- Relative humidity must be below 95% during application.



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Drying and overcoating

Product compatibility -

Previous coat: None.

- Subsequent coat: According to Rustbuster's Specification.

Drying time

Surface -10°C 0°C 20°C 40°C temperature [14°F] [32°F] [68°F] [104°F]

Determined for dry film thickness 60 micron [2.4 mils] at standard conditions, see Rustbuster's Explanatory Notes for details.

Overcoating

Rustbuster's specification supersedes any guidelines indicated in the overcoating table

Quality name	-10°C [14°F]	0°C [32°F]	20°C [68°F]	40°C [104°F]
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Overcoating times are indicative for products of the same generic chemistry. Consult Rustbuster's specification for more information.

Drying conditions

- To obtain the drying time stated, it is important to maintain sufficient ventilation during application, drying and curing.

Overcoating details

- If the maximum overcoating interval is exceeded, roughening of the surface is necessary to ensure intercoat adhesion.
- Remove zinc salts or other contamination before overcoating. - The surface must be dry and clean prior to application.

Other remarks

- Rustbuster's Specification supersedes any recommendations given in the Product Data Sheets.

Storage

Shelf life

Ambient 25°C 35°C temperature [77°F] [95°F]

Base	12 months	9 months
Curing Agent	36 months	24 months

Shelf life from date of production, when stored in original, unopened containers. Thereafter, the product quality must be re-inspected. Always check the best before date or expiry date on the label.

Storage conditions

- Product must be stored according to local legislation, at maximum 40°C [104°F], without direct sunlight and protected from rain.

Touch dry	min	50	30	10	5
Hard dry	hours	4½	3	1½	½

