



Zinga Coating System – Stainless Steel 316 Z24 (c)



SCOPE:

<i>Material:</i>	Stainless steel up to 120°C		
<i>Environment:</i>	Atmospheric	<i>Exposure category</i>	C5 (high)
<i>Expected Lifespan:</i>	N/A	<i>Standard</i>	ISO 12944 - 5

SURFACE PREPARATION:

<i>Surface Pre-preparation:</i>	Steam Clean @ 150 bar (min) @ 80°C or High Pressure Fresh Water Wash @ 150 bar (min)
<i>Surface Preparation:</i>	Sa 2.5 (ISO 8501-1) SSPC-SP10 (Grit-blast or slurry blast. Also UHPAB to SSPC-SP12)
<i>Surface Profile:</i>	Rz 50 – 70µm (ISO 8503-2)
<i>Surface Roughness:</i>	Ra 12.5 – 15µm (ISO 8503-1)

SYSTEM:

<i>Product</i>	<i>Application Type</i>	<i>Volume Solids (%)</i>	<i>Required DRY Film Thickness (µm)</i>	<i>Theoretical Spreading Rate (m²/lt)</i>	<i>Application Method</i>	<i>Required WET Film Thickness (µm)</i>	<i>Solvent</i>	<i>Drying Time (Hrs)</i>			
								<i>5°C</i>	<i>10°C</i>	<i>15°C</i>	<i>20°C</i>
Zinga	F/C	58	60	2.4	A / S / B	105	Zingasolv	3.5	2.5	2.0	1.25
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Application Type Key: M/C = Mist Coat, F/C = Full Coat, S/C = Stripe Coat
Application Method Key: A = Airless Spray, S = Conventional Spray, E = Electrostatic P = Electric powder gun, R = Roller, B = Brush



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Notes on this Specification:

General:

1. Please use this specification in conjunction with the appropriate Technical Data Sheets and MSDS.
2. Application Conditions: please see the Technical Data Sheet for details of minimum temperatures, humidity etc. For optimum performance the surface should be completely dry and the Sa2.5 cleanliness standard strictly adhered to on the lower column sections.
3. Drying times will be affected by temperatures, humidity and ventilation conditions.
4. Measurements of DFT should only be taken when the zinc coating is fully cured, as false readings can be experienced up to 24 hours after application.

Welds:

5. All welds must be thoroughly inspected for blow-holes, undercutting etc and any flaws must be made good before proceeding.
6. All weld-spatter must be completely removed to avoid 'shadowing' during blasting and coating operations. Where necessary, these areas can be smoothed over with a P36 or P60 sanding-disc prior to commencing any blast-cleaning work.
7. If silicone anti-spatter spray has been used on any of the steelwork, these areas must be thoroughly cleaned off with acetone before proceeding with any other operations.

Blast-cleaning:



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8. All sharp edges must be radiused to a minimum of 2 - 3mm. This is considered as 'best practice' on all steel work.
9. Attention must be paid to all welds, inside angles, drilled-hole circumferences, brackets, bolts and fittings plus all edges.
10. Only garnet or other mineral abrasives should be used to avoid cross-contamination of the stainless steel.
11. Where there is no option but to use a slag abrasive, the steelwork must be very thoroughly blown-off using a minimum air-pressure of bars to remove all residues of the dust.
12. All blast-cleaned surfaces must be well blown-down or vacuumed before proceeding with the coating process.
13. Where the surfaces are slurry-blasted, the steelwork must be allowed to dry. It can remain damp when the zinc layer is applied.
14. Blast-cleaning must be done according to the 80/20 rule.

De-dusting:

15. All surfaces must be thoroughly de-dusted using a vacuum hose or by blowing off with an air-duster.
16. Maximum contamination value is Class 2.0 according to ISO 8502 - 3

Stripe-coating:

17. Stripe-coating shall be done to the standard SSPC-PAG 11. Some notes in the lines below.
18. All sharp edges, around brackets and fittings, drilled-hole circumferences and internals, inside angles, bolt-heads and weld seams must be stripe-coated by brush. Special attention must be paid to the welds along the rubbing strokes.
19. Outside angles and edges may be stripe-coated using a spray-gun, although a brush is preferable.
20. The Zinga stripe-coating must be allowed to flash-off for a minimum of 15 - 20 minutes @20°C before proceeding with application of the main coat onto adjacent surfaces.
21. During application of the main coating, the stripe-coats must be fully overlapped with the spray-fan.



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22. Where the humidity is very high and there is a danger of flash-rusting occurring before application of the main coating of Zinga, then this should be carried out first, and then the stripe-coatings applied after 20 minutes @20°C.

Full-coating:

23. The steelwork can now be fully coated with Zinga as normal. With airless spray must be diluted as per the TDS. Cold weather may require an extra 2-3% of dilution.
24. When applying the coatings by roller, they should be laid-on in one direction and then (without re-loading the roller) the coating must then be 'pulled out' at 90° to the original direction. This removes any 'streaking' marks from the roller and gives a neat 'sprayed on' appearance.
25. All coatings must be applied according to the 80/20 rule.

Important Notes:

26. The application of all the products mentioned in these documents must be done in strict accordance with the appropriate manufacturer's instructions and specifications. No liability can be accepted for any failures resulting from the incorrect application of any part of the recommended coating system.
27. The coverage rates shown are theoretical and are for guideline purposes only.
28. The information on these sheets is given to the best of our knowledge based on practical field experience and testing. However, as Zinga is often used under conditions beyond our control, we cannot guarantee anything other than the quality of the product itself.
29. Before any work is carried out, the Zinga technical department must be consulted in order to clarify any points or concerns raised in this specification document or in any of the associated Technical Data Sheets, MSDS, and any other relevant documents.

80 /20 Rule



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30. The 80/20 rule states that 80% of all readings of both blast-profiles and of DFT's must be greater than, or equal to, the absolute minimum of the specified figures, and none of the remaining 20% of readings must be below a minimum of 80% of the specified figures.

Maintenance:

31. All coated steelwork should be inspected after completion of works, and any damages found must be made good as per the original specification.