



Protective
&
Marine
Coatings

ZINC CLAD® III HS 100 ORGANIC ZINC-RICH EPOXY PRIMER

PART A
PART B
PART F

B69A110
B69V110
B69D11

BASE
HARDENER
ZINC DUST

APPLICATION BULLETIN

6.10

APPLICATION PROCEDURES

Surface preparation must be completed as indicated.

Zinc Clad III HS 100 comes in 3 premeasured containers which when mixed provides 3.25 gallons (12.3L) of ready-to-apply material.

Mixing Instructions:

Mix contents of component A and B thoroughly with a low speed power agitator. Make certain no pigment remains on the bottom of the can. Then combine 1 part by volume of Part A with 1 part by volume of Part B, then add Part F (73 lb zinc dust). Thoroughly agitate the mixture with power agitation. After mixing, pour through a 30-60 mesh screen. Allow the material to sweat-in as indicated. Re-stir before using.

If reducer solvent is used, add only after components have been thoroughly mixed, after sweat-in. Continuous agitation of mixture during application is required, otherwise zinc dust will quickly settle out.

Apply paint at the recommended film thickness and spreading rate as indicated below:

Recommended Spreading Rate per coat:

	Minimum	Maximum
Wet mils (microns)	5.0 (125)	8.0 (200)
Dry mils (microns)	3.0 (75)	5.0 (125)
~Coverage sq ft/gal (m ² /L)	190 (4.6)	320 (7.8)
Theoretical coverage sq ft/gal (m ² /L) @ 1 mil / 25 microns dft	960 (23.5)	

NOTE: Brush or roll application may require multiple coats to achieve maximum film thickness and uniformity of appearance.

Drying Schedule @ 5.0 mils wet (125 microns):

	@ 40°F/4.5°C	@ 77°F/25°C 50% RH	@ 120°F/49°C
To touch:	45 minutes	30 minutes	10 minutes
To handle:	2 hours	1 hour	30 minutes
To recoat*:			
minimum:	4 hours	2 hours	1 hour
maximum:	1 year	1 year	1 year
To cure:	10 days	7 days	5 days
Drying time is temperature, humidity, and film thickness dependent.			
*NOTE: Film must be free of solvent, hard and firm. When rubbed with the face of a coin or knife the film should polish but not flake or chip.			
Pot Life:	6 hours	4 hours	2 hours
Sweat-in-Time:	1 hour	30 minutes	15 minutes

Application of coating above maximum or below minimum recommended spreading rate may adversely affect coating performance.

CLEAN UP INSTRUCTIONS

Clean spills and spatters immediately with R7K111 or R6K10. Clean tools immediately after use with R7K111 or R6K10. Follow manufacturer's safety recommendations when using any solvent.

DISCLAIMER

The information and recommendations set forth in this Product Data Sheet are based upon tests conducted by or on behalf of The Sherwin-Williams Company. Such information and recommendations set forth herein are subject to change and pertain to the product offered at the time of publication. Consult your Sherwin-Williams representative to obtain the most recent Product Data Information and Application Bulletin.

PERFORMANCE TIPS

Stripe coat all crevices, welds, and sharp angles to prevent early failure in these areas.

When using spray application, use a 50% overlap with each pass of the gun to avoid holidays, bare areas, and pinholes. If necessary, cross spray at a right angle.

Spreading rates are calculated on volume solids and do not include an application loss factor due to surface profile, roughness or porosity of the surface, skill and technique of the applicator, method of application, various surface irregularities, material lost during mixing, spillage, overthinning, climatic conditions, and excessive film build.

Excessive reduction of material can affect film build, appearance, and performance.

Do not mix previously catalyzed material with new.

Do not apply the material beyond recommended pot life.

In order to avoid blockage of spray equipment, clean equipment before use or before periods of extended downtime with R7K111 or R6K10.

Keep pressure pot at level of applicator to avoid blocking of fluid line due to weight of material. Blow back coating in fluid line at intermittent shutdowns, but continue agitation at pressure pot.

Application above recommended film thickness may result in mud cracking.

Refer to Product Information sheet for additional performance characteristics and properties.

SAFETY PRECAUTIONS

Refer to the MSDS sheet before use.

Published technical data and instructions are subject to change without notice. Contact your Sherwin-Williams representative for additional technical data and instructions.

WARRANTY

The Sherwin-Williams Company warrants our products to be free of manufacturing defects in accord with applicable Sherwin-Williams quality control procedures. Liability for products proven defective, if any, is limited to replacement of the defective product or the refund of the purchase price paid for the defective product as determined by Sherwin-Williams. NO OTHER WARRANTY OR GUARANTEE OF ANY KIND IS MADE BY SHERWIN-WILLIAMS, EXPRESSED OR IMPLIED, STATUTORY, BY OPERATION OF LAW OR OTHERWISE, INCLUDING MERCHANTABILITY AND FITNESS FOR A PARTICULAR PURPOSE.