



Technical Data Sheet

Zinc Rich Primer ELSS 90056

Description: *ELSS90056, Zinc Rich Primer* is a thermosetting powder coating based on an epoxy resin. This product contains in excess of 50% by weight of Zinc for excellent corrosion protection and superior long term exterior performance when used with a suitable exterior durable product.

Typical Applications: Primer, functional protective coatings

Typical Physical Properties:	Film Thickness (ASTM D)	1.5-2.5 mil
	Gloss 60°angle (ASTM D-523-89)	1-5
	Hardness (ASTM D-3363-92A)	3H
	Flexibility (ASTM D-1737-89)	1/8 inch
	Adhesion (ASTM D-3359-95A)	5B (100%)
	Impact Direct/Indirect (ASTM D-2794-93)	120/120 in/lbs
	Salt Spray (ASTM B117)	4000 < 3 mm
	Specific Gravity	2.45±0.03

Application Data: *ELSS90056, Zinc Rich Primer* provides excellent protection against corrosion on the surface to which it is applied. However the efficiency of this protection depends upon the surface, its preparation before coating and the topcoat applied. It can be applied with either a corona electrostatic powder spray gun at between 60 kV – 100 kV or Tribo. Pretreatment should consist of a 5 stage iron phosphate (or equivalent) conversion coating, and/or SSPC 10 near White Blast with an optimum surface profile of 1.0 mil. Minimum film thickness is 1.0 mil over the blast profile.

Cure Schedules: *ELSS90056, Zinc Rich Primer* can be cured in a direct or indirect gas convection oven, electric oven, an Infrared, or combination of any of these, with air-temperatures not exceeding 420°F. It should be partially or fully cured using the recommended stoving schedules, before application of the topcoat. The part temperature must not go below 260°F or above 420°F.

Standard Cure: 10 Minutes @ 340°F Peak Metal Temperature
Primer Cure: 10 Minutes @ 300°F Peak Metal Temperature

Storage: Product should be stored at temperatures below 80⁰f, in a dry area away from any heat source.

Notes: All tests were performed on Bonderite 1000, iron phosphated panels with a nominal film thickness of 2 mils.
Lower gloss levels may require higher cure temperatures or longer dwell times.
Please refer to the MSDS for safety information.

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