

# Cathacoat® 316



## Epoxy Zinc-Rich

### PRODUCT DESCRIPTION

A two component, metallic zinc rich epoxy primer.

### INTENDED USES

For the interior and exterior protection of potable water tanks.

Ideal for cathodic protection of steel structures, tanks, equipment, piping and other steel surfaces exposed in mild to severe industrial environments. Also ideal for touch-up and maintenance work because of its easy application, wide compatibility and fast dry-to-recoat.

Meets Class A slip and creep for faying surfaces.

When used for potable water tank applications, please review the approval available at [www.nsf.org](http://www.nsf.org) for current listing information.



Certified to NSF/ANSI  
Standard 61

### PRACTICAL INFORMATION FOR CATHACOAT 316

<b>Color</b>	Light Green
<b>Gloss Level</b>	Matte
<b>Volume Solids</b>	74% ± 2%
<b>Typical Thickness</b>	2.5-3.5 mils (62-88 microns) dry equivalent to 3.4-4.8 mils (84-119 microns) wet
<b>Theoretical Coverage</b>	396 sq.ft/US gallon at 3 mils d.f.t and stated volume solids 9.87 m <sup>2</sup> /liter at 75 microns d.f.t and stated volume solids
<b>Practical Coverage</b>	Allow appropriate loss factors
<b>Method of Application</b>	Airless Spray, Roller, Air Spray, Brush,

### Drying Time

Temperature	Touch Dry	Hard Dry	Overcoating interval with self	
			Minimum	Maximum
41°F (5°C)	*1	20 hours	5 hours	90 days <sup>2</sup>
59°F (15°C)	*1	5 hours	2 hours	90 days <sup>2</sup>
77°F (25°C)	*1	1 hour	1 hour	90 days <sup>2</sup>

<sup>1</sup> \* not applicable

<sup>2</sup> See Product Characteristics section for further details

**REGULATORY DATA** **Flash Point (Typical)** Part A 70°F (21°C); Part B 86°F (30°C); Mixed 81°F (27°C)

**Product Weight** 28.0 lb/gal (3.35 kg/l)

**VOC** 2.01 lb/gal (241 g/l) EPA Method 24

See Product Characteristics section for further details

## Protective Coatings

## Epoxy Zinc-Rich

### SURFACE PREPARATION

#### Steel Substrates

All surfaces to be coated should be clean, dry and free from contamination. Prior to paint application all surfaces should be assessed and treated in accordance with ISO 8504:2000.

Where necessary, remove weld spatter and smooth weld seams and sharp edges.

Blast to near-white metal surface cleanliness in accordance with SSPC-SP10 or ISO8501-1:2007 Sa2½ for immersion service, or commercial blast cleanliness in accordance with SSPC-SP6 or ISO8501-1:2007 Sa2½ for non-immersion service. Blast profile on steel should be 1.5 to 2.5 mils (38-62 microns) in depth and be of a sharp, angular nature as opposed to a “peen” pattern (from shot blasting). Surfaces must be free of grit dust.

Apply Cathacoat 316 before oxidation occurs. If oxidation does occur the entire oxidized area should be reblasted to the standard specified.

#### Previously Painted Surfaces

Cathacoat 316 may not be applied to existing coatings. All coatings must be removed by abrasive blast cleaning to a minimum standard of SSPC SP6, ISO8501-1:2007 Sa2½.

### APPLICATION

<b>Mixing</b>	Material is supplied in two containers. Always mix whole units. The zinc metal is ready-mixed in Part A. Stir thoroughly with a slow speed mixer while slowly adding Part B. Continue to mix at slow speeds to a homogeneous condition. At temperatures of 60°F (16°C) or above, allow a 15 minute induction time before using. Add about 10 minutes for each 10°F (6°C) lower temperature.		
<b>Mix Ratio</b>	9 part(s) : 1 part(s) by volume		
<b>Working Pot Life</b>	41°F (5°C) 9 hours	59°F (15°C) 9 hours	77°F (25°C) 8 hours
<b>Airless Spray</b>	Recommended	Tip Range 25 thou (0.63 mm) Total output fluid pressure at spray tip not less than 3000 p.s.i. (211 kg/cm <sup>2</sup> ) See Product Characteristics section for further details	
<b>Air Spray (Pressure Pot)</b>	Suitable	Use a fluid tip of 0.070" (1.78mm') or larger, a professional grade conventional gun and agitated spray pots.	
<b>Brush</b>	Suitable		
<b>Roller</b>	Suitable		
<b>Thinner Cleaner</b>	Not normally required T-10 Thinner	See Product Characteristics section for further details	
<b>Work Stoppages</b>	Do not allow material to remain in hoses, gun or spray equipment. Thoroughly flush all equipment with T-10 Thinner. Once units of paint have been mixed they should not be resealed and it is advised that after prolonged stoppages work recommences with freshly mixed units.		
<b>Clean Up</b>	Clean all equipment immediately after use with T-10 Thinner. It is good working practice to periodically flush out spray equipment during the course of the working day. Frequency of cleaning will depend upon amount sprayed, temperature and elapsed time, including any delays. All surplus material and empty containers should be disposed of in accordance with appropriate regional regulations/legislation.		

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### PRODUCT CHARACTERISTICS

#### Advantages:

- Exceptional corrosion resistance
- Provides cathodic protection
- Easy to mix
- Zinc premixed
- Fast dry to handle and recoat
- Applies easily by brush, roll or spray
- Accepts a wide variety of topcoats for severe exposures
- Formulated without lead, chromate or mercury components
- Low VOC

Do not topcoat with alkyd or alkyd-urethane coatings.

Cathacoat 316 is not suitable for solvent or chemical immersion.

For airless spray application, use fluid hose 3/8" I.D. with maximum 50 ft. length. Pressure pots or pumps should be kept at same level or above spray guns. Keep fluid pressures to minimum. Use agitated spray pots.

For air spray application: Use fluid hose with 1/2" ID and maximum 50ft length, with 15psi pressure. Pressure pots or pumps should be kept at the same level or above spray guns.

Where Cathacoat 316 is to be overcoated with Bar-Rust 231, 231LV, 233H, 233H LV or 236 epoxy coatings, the self minimum and maximum overcoating intervals will apply.

Where Cathacoat 316 is to be overcoated with Bar-Rust 235 epoxy coating, the self minimum overcoating intervals apply, with a 60 day maximum overcoating interval. Where Cathacoat 316 is to be overcoated with Devran 224HS epoxy coating, the self-self minimum overcoating intervals apply, with a 14 day maximum overcoating interval.

Where Cathacoat 316 is to be overcoated with Devthane 359, 359H, 389 or 349QC, the following overcoating intervals will apply;

	Minimum	Maximum
41°F (5°C)	5 hours	15 days
59°F (15°C)	4 hours	12 days
77°F (25°C)	2 hours	10 days

Where Cathacoat 316 is to be overcoated with Devthane 378, 378H, 379 or 379H, the following overcoating intervals will apply;

	Minimum	Maximum
41°F (5°C)	5 hours	10 days
59°F (15°C)	4 hours	7 days
77°F (25°C)	2 hours	7 days

Thinning is not normally required or desirable. However, at lower temperatures, small amounts (5% or less) of T-10 Thinner can be added to the mixed components depending on local VOC and air quality regulations.

Do not thin for potable water applications.

Note: VOC values are typical and are provided for guidance purpose only. These may be subject to variation depending on factors such as differences in color and normal manufacturing tolerances.

### SYSTEMS COMPATIBILITY

The following topcoats are recommended:-

Bar-Rust 231	Devran 223	Interline 975P*
Bar-Rust 231LV	Devran 224V	Interseal 670HS
Bar-Rust 233H*	Devthane 349	
Bar-Rust 233H LV*	Devthane 359	
Bar-Rust 234P*	Devthane 359H	
Bar-Rust 235	Devthane 378	
Bar-Rust 235V	Devthane 378H	
Bar-Rust 236	Devthane 379	
Devran 201H	Devthane 379H	
Devran 203	Devthane 389	

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\* NSF-certified topcoats.

