Cathacoat® 302H

Reinforced Inorganic Zinc

PRODUCT DESCRIPTION

A high performance, two component, reinforced inorganic zinc-rich primer.

INTENDED USES

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.

Formulated to minimise topcoat bubbling typically experienced with inorganic zinc rich primers.

PRACTICAL INFORMATION FOR CATHACOAT 302H

Color	Green
Gloss Level	Matte
Volume Solids	78% ± 2%
Typical Thickness	2.5-4 mils (62.50-100 microns) dry equivalent to 3.2-5.1 mils (81-128 microns) wet
Theoretical Coverage	386 sq.ft/US gallon at 3.2 mils d.f.t and stated volume solids 9.63 m²/liter at 81 microns d.f.t and stated volume solids
Practical Coverage	Allow appropriate loss factors
Method of Application	Airless Spray, Roller, Air Spray, Brush

Drying Time

			Overcoating Interval with recommended topcoats	
Temperature	**Touch Dry**	**Hard Dry**	*Minimum*	*Maximum*
41°F (5°C)	*[1]	13 hours	5.5 hours	90 days[2]
59°F (15°C)	*[1]	7 hours	2 hours	90 days[2]
77°F (25°C)	*[1]	4 hours	1 hour	90 days[2]

[1] * not applicable
[2] Where overcoating is with epoxy intermediates / finishes or self overcoating.
Overcoating intervals will be reduced where Cathacoat 302H is to be overcoated with approved finishes; see Product Characteristics for further information.

REGULATORY DATA

Flash Point (Typical)	Part A 81°F (27°C); Part B 81°F (27°C); Mixed 81°F (27°C)	
Product Weight	19.5 lb/gal (2.34 kg/l)	
VOC	2.35 lb/gal (282 g/lt)	EPA Method 24

See Product Characteristics section for further details

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SURFACE PREPARATION

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.

Steel Substrates

Abrasive blast to minimum SSPC-SP10 or ISO8501-1:2007 Sa2½. The blast profile should be jagged rather than “peened” and between 1.5 to 2.5 mils (38-62 microns). After blasting, vacuum or blow off all abrasive dust and ensure surface remains clean before painting.

Previously Painted Surfaces

Cathacoat 302H may not be applied to existing coatings. All coatings should be removed by abrasive blast cleaning to a minimum standard of SSPC SP10, ISO8501-1:2007 Sa2½.

APPLICATION

Mixing	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.	
Mix Ratio	9 part(s) : 1 part(s) by volume	
Working Pot Life	41°F (5°C) 10 hours 59°F (15°C) 9 hours 77°F (25°C) 8 hours	
Airless Spray	Recommended	Tip Range 25 thou (0.63 mm) Total output fluid pressure at spray tip not less than 3000 p.s.i. (211 kg/cm²) See Product Characteristics section for further details
Air Spray (Conventional)	Suitable	See Product Characteristics section for further details
Brush	Suitable	
Roller	Suitable	
Thinner	International GTA610.	See Product Characteristics section for further details
Cleaner	International GTA610	
Work Stoppages	Do not allow material to remain in hoses, gun or spray equipment. Thoroughly flush all equipment with International GTA610. 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.	
Clean Up	Clean all equipment immediately after use with International GTA610. 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 in base component
- Fast dry to handle and recoat
- Formulated to resist topcoat bubbling
- Exceptional resistance to mud cracking
- Applies easily by brush, roll or spray
- Accepts a wide variety of topcoats for severe exposures
- Formulated without lead, chromate or mercury components
- Does not require humidity to cure

Where Cathacoat 302H is to be overcoated with Devthane urethane finishes, the following overcoating intervals will apply;

	Minimum	Maximum
41°F (5°C)	5.5 hours	5 days
59°F (15°C)	2 hours	5 days
77°F (25°C)	1 hour	5 days

Do not topcoat with alkyd or alkyd-urethane coatings.

Cathacoat 302H 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.

For air spray application: Use a fluid tip of 0.070" (1.78mm') or larger, a professional grade conventional gun and agitated spray pots. Fluid pressure should be 15 psi with fluid hose of 1/2" ID and maximum 50 ft length.

Thinning is not normally required or desirable. However, at lower temperatures, small amounts (5% or less) of International GTA610 can be added to the mixed components depending on local VOC and air quality regulations.

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 approved for use with Cathacoat 302H:

Bar-Rust 231	Bar-Rust 231LV
Bar-Rust 235	Bar-Rust 235V
Bar-Rust 236	Devthane 349
Devthane 359	Devthane 359H
Devthane 379	Devthane 379H
Interfine 629HS	Intergard 345
Intergard 475HS	Interseal 670HS
Interthane 870	Interthane 990
Interthane 990V	Interzone 954
Tru-Glaze-WB 4426	Tru-Glaze-WB 4428

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ADDITIONAL INFORMATION

Further information regarding industry standards, terms and abbreviations used in this data sheet can be found in the following documents available at www.international-pc.com:

- Definitions & Abbreviations
- Surface Preparation
- Paint Application
- Theoretical & Practical Coverage

Individual copies of these information sections are available upon request.

SAFETY PRECAUTIONS

This product is intended for use only by professional applicators in industrial situations in accordance with the advice given on this sheet, the Safety Data Sheet and the container(s), and should not be used without reference to the Safety Data Sheet (SDS).

All work involving the application and use of this product should be performed in compliance with all relevant national, Health, Safety & Environmental standards and regulations.

In the event welding or flame cutting is performed on metal coated with this product, dust and fumes will be emitted which will require the use of appropriate personal protective equipment and adequate local exhaust ventilation.

If in doubt regarding the suitability of use of this product, consult AkzoNobel for further advice.

PACK SIZE

Unit Size	Part A		Part B	
	Vol	Pack	Vol	Pack
1 US gal	0.9 US gal	1 US gal	0.1 US gal	1 US quart
3 US gal	2.7 US gal	5 US gal	0.3 US gal	1 US gal

For availability of other pack sizes, contact AkzoNobel.

SHIPPING WEIGHT (TYPICAL)

Unit Size	Part A	Part B
1 US gal	19.2 lb	2.1 lb
3 US gal	58.1 lb	2.3 lb

STORAGE

Shelf Life	24 months minimum at 77°F (25°C). Subject to re-inspection thereafter. Store in dry, shaded conditions away from sources of heat and ignition.

Disclaimer

The information in this data sheet is not intended to be exhaustive; any person using the product for any purpose other than that specifically recommended in this data sheet without first obtaining written confirmation from us as to the suitability of the product for the intended purpose does so at their own risk. All advice given or statements made about the product (whether in this data sheet or otherwise) is correct to the best of our knowledge but we have no control over the quality or the condition of the substrate or the many factors affecting the use and application of the product. Therefore, unless we specifically agree in writing to do so, we do not accept any liability at all for the performance of the product or for (subject to the maximum extent permitted by law) any loss or damage arising out of the use of the product. We hereby disclaim any warranties or representations, express or implied, by operation of law or otherwise, including, without limitation, any implied warranty of merchantability or fitness for a particular purpose. All products supplied and technical advice given are subject to our Conditions of Sale. You should request a copy of this document and review it carefully. The information contained in this data sheet is liable to modification from time to time in the light of experience and our policy of continuous development. It is the user's responsibility to check with their local representative that this data sheet is current prior to using the product.

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