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TECHNICAL DATA SHEET

TETRAZINC 440

Product description

TETRAZINC 440 is a two-component epoxy primer with zinc phosphate and metallic zinc powder.

Intended uses

It is recommended for use as part of anti-corrosion coating systems to protect metal structures from corrosion.

Product data

Indicative film thickness, dry:	70 µm			
Indicative film thickness, wet:	140 µm			
Theoretical coverage 70µm:	7,1 m ² /l			
Suggested dry film thickness:	60-80 µm			
Gloss (GU 60 °)	Matte (5-20)			
Solids by volume	50 %			
Density (A+B)	1,80 gr/ml			
Mixing ratio A:B	3:1 per volume			
Working pot life (A+B)	5h (23±2 °C) Time varies with increasing or decreasing temperature.			
Indicative drying times and overcoating/ Relative humidity 50%±5	°C	Touch Dry, Minutes	Hard Dry, Hours	Overcoating, Hours
	15°	45min	2,5h	24h
	25°	25min	1,5h	16h
Colours	White 140.1, Grey 140.2, Red-Brown 140.3, Black 140.4			
VOC (Volatile Organic Compounds)	EU limit value for this product Category A/j, Type: SB, Two-pack reactive performance coatings for specific end use such as floors, is 500g/l (2010). This product contains max 499g/l			



Surface preparation

Surfaces must be clean, dry and free of oily substances and deposits of other materials which will prevent or affect adhesion.

Prior to application, surfaces must be assessed and treated accordingly.

Sandblasting to Sa2½ level (EN ISO 8501-1:2007) is recommended, while for surfaces to be prepared by hand they should be prepared to a minimum St3 level (EN ISO 8501-1:2007) at the time of painting.

After applying TETRAZINC 440, the surface is sealed with a suitable coating (recommended products below).

In case the recoating time needs to be extended, the surfaces must be stored indoors and away from the effects of sunlight.

Application

Apply one layer for DFT 60-80µm. Its composition allows the required thickness to be achieved in one layer without sagging during application.

Application methods

The product can be applied by:

Air spray: 1,6-1,8mm, 2 - 2.5 bar (29 - 36 psi)

Airless spray: 0,017-0,021", 150 bar (2175psi)

Brush and Roller. Recommended for small areas. Care must be taken to achieve the specified dry film thickness.

Thinner solvent

Thinners: No810

Air spray: 10-15% (V)

Airless spray: 5-10% (V)

Brush and Roller: 5-10% (V)

Cleaning solvent

Thinner No806

Next coat

INTERPOX 341

Application conditions

In conditions of high relative humidity (80-85%), good ventilation conditions are essential. Substrate temperature shall be at least 3°C above the dew point and always above 0°C. Application at ambient air temperatures below 5°C is not recommended.



Safety

Handle with care. Before and during use, observe all safety labels on packaging and paint containers, consult TETRALUX Safety Data Sheets and follow all local or national safety regulations.

Remarks

Caution

This product is for professional use only. The applicators and operators shall be trained, experienced and have the capability and equipment to mix/stir and apply the coatings correctly. Applicators and operators shall use appropriate personal protection equipment when using this product.

Storage

Keep the containers in a dry, cool, well ventilated space and away from sources of heat and ignition. Containers must be kept tightly closed. Handle with care.