

Coating System Reference	TR0042 v.7 System1A
Surface Cleanliness	Sa2½ according to ISO 8501-1
Surface Roughness	Grade Medium G (50µm to 85µm, R _{y5}) according to ISO 8503

Product Name	Product Type	DFT (µm)			Volume Solid (%)	Theoretical m ² / ltr @ spec DFT	Mixing Thinner	Thinning %	Mix Ratio by Volume (Base:Additive)
		min	spec	max					
Zinc Clad II	Inorganic Zinc	60	60	125	62	7.75	No.4	≤ 5	9.9Kgs : 3.43 litres
Macropoxy 5400	Epoxy (mist coat)	25	25	75	72	NA	No.5	≤ 10	3:1
Macropoxy 5400	Epoxy	100	120	300	72	7.2	No.5	≤ 5	3:1
Sherloxane 800	Polysiloxane	100	100	150	90	9	NR	NR	4:1
		TOTAL		305	650				

Product Name	5°C			10°C			23°C			40°C		
	Overcoating Time		Full Cure Time ¹	Overcoating Time		Full Cure Time ¹	Overcoating Time		Full Cure Time ¹	Overcoating Time		Full Cure Time ¹
	min	max		min	max		min	max		min	max	
Zinc Clad II	²	Unlimited ³	14 days ⁴	48 hr ²	Unlimited ³	14 days ⁴	18 hr ²	Unlimited ³	14 days ⁴	18 hr ²	Unlimited ³	14 days ⁴
Macropoxy 5400	15hrs	30 days	5 days	10hrs	30 days	3 days	5hrs	30 days	2 days	2hrs	14 days	1 day
Macropoxy 5400	15hrs	30 days	5 days	10hrs	30 days	3 days	5hrs	30 days	2 days	2hrs	14 days	1 day
Sherloxane 800	16hrs	90d	8d	10 hrs	90d	8d	3hrs	90d	7d	1.5hrs	90d	3d

Notes

- Overcoating and Full Cure Times are based on a Relative Humidity level of 50%.
- Minimum Overcoating and Full Cure Time to be confirmed by carrying out 50 MEK double rubs. No zinc or only slight traces should be visible. Coin hardness test can also be used.
- Maximum Overcoating time is "Unlimited" providing any salting on the zinc surface due to weathering exposure is fully removed prior to topcoating.
- The time stated refers to cure-to-service. For handling times please see individual Product Technical Data Sheet.

NR Not Recommended