ZINC CLAD® 4100
ORGANIC ZINC-RICH EPOXY PRIMER

PRODUCT INFORMATION

ZINC CLAD 4100 is a three-component, polyamide epoxy, zinc-rich coating. It contains 89.2% by weight of zinc dust pigment in its dried film.

- Meets Class B requirements for slip coefficient and creep resistance
- Provides cathodic protection
- Damaged film exhibits "self-healing" properties
- Fast Recoat Time
- Outstanding application properties

PRODUCT CHARACTERISTICS

Finish: Flat
Color: Gray-Green, mixed
Volume Solids: 74% ± 2%
Weight Solids: 90% ± 2%
VOC (mixed): <320 g/L; 2.67 lb/gal unreduced;
<340 g/L; 2.80 lb/gal 5% reduction
Zinc Dust Pigment Content in Dry Film: 89.2%
Mix Ratio: 3 components, premeasured

Recommended Spreading Rate per coat:

<table>
<thead>
<tr>
<th>Coverage sq ft/gal (m²/L)</th>
<th>Minimum</th>
<th>Maximum</th>
</tr>
</thead>
<tbody>
<tr>
<td>Wet mils (microns)</td>
<td>4.0 (100)</td>
<td>7.0 (175)</td>
</tr>
<tr>
<td>Dry mils (microns)</td>
<td>3.0 (75)</td>
<td>5.0 (125)</td>
</tr>
<tr>
<td>Theoretical coverage sq ft/gal (m²/L) @ 1 mil / 25 microns dft</td>
<td>1187 (29.1)</td>
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NOTE: Brush or roll application may require multiple coats to achieve maximum film thickness and uniformity of appearance.

Drying Schedule @ 4.0 mils wet (100 microns):

- To touch: 30 minutes 30 minutes 20 minutes 5 minutes
- To handle: 120 minutes 100 minutes 60 minutes 15 minutes
- To recoat: minimum: 4 hours 2 hours 30 minutes 20 minutes
  maximum*: unlimited unlimited unlimited unlimited

*Maximum Recoat: Unlimited. Must have a clean, dry surface for topcoating. "Loose" chalk or salts must be removed in accordance with good painting practice.

To cure: 7 days 7 days 5 days 3 days

Drying time is temperature, humidity, and film thickness dependent.

Pot Life: 8 hours 8 hours 4 hours 2 hours

Recommended Uses

For use over properly prepared steel.
- Bridge and Highway Structures
- Fabrication Shops
- Stadiums and sports complexes
- Drilling Rigs
- Piping
- Refineries
- Barges & ships
- Shop or field application

Performance Characteristics

Substrate*: HRS A36
Surface Preparation*: SSPC-SP 10 / NACE 2
System Tested*:
1 ct. Zinc Clad 4100 @ 3.0-5.0 mils (75-125 microns) dft
1 ct. Macropoxy 646 @ 3.0-10.0 mils (75-250 microns) dft
1 ct. Hi-Solids Polyurethane 250 @ 3.0-5.0 mils (75-125 microns) dft

*unless otherwise noted below

Test Name | Test Method | Results
--- | --- | ---
Adhesion (Zinc Primer only) | ASTM D4541, PATTI | 2,248 psi
Adhesion | ASTM D4541, PATTI | 2,828 psi
Corrosion Weathering | ASTM D5894, 15 cycles, 5,040 hours | Rating 10 per ASTM D610 for rusting; Rating 10 per ASTM D714 for blistering
Salt Fog Resistance | ASTM B117, 5,040 hours | Rating 10 per ASTM D610 for rusting; Rating 10 per ASTM D714 for blistering
Slip Coefficient (Zinc Primer only) | AISC Specification for Structural Joints using ASTM A325 or ASTM A490 Bolts | Class B @5 mil DFT (72 hour cure)

Meets the requirements of SSPC Paint 20, Type II, Level II

PART A | B69A120
PART B | B69V120
PART F | B69D11

Base Hardener: Zinc Dust

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continued on back
# ZINC CLAD® 4100
## ORGANIC ZINC-RICH EPOXY PRIMER

### PRODUCT INFORMATION

**Revised:** March 5, 2020

#### Recommended Systems

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<tr>
<td>1-2 cts. Fluorokem HS</td>
<td>2.0-3.0</td>
<td>(50-75)</td>
<td></td>
</tr>
</tbody>
</table>

#### Surface Preparation

Surface must be clean, dry, and in sound condition. Remove all oil, dust, grease, dirt, loose rust, and other foreign material to ensure adequate adhesion.

Refer to product Application Bulletin for detailed surface preparation information.

**Minimum recommended surface preparation:**

- **Iron & Steel:** SSPC-SP6/NACE 3, 2 mil (50 micron) profile
- **Ductile Iron Pipe:**
  - **Atmospheric:** NAPF 500-03-03 Power Tool Cleaning
  - **Buried & Immersion:** NAPF 500-03-04 Abrasive Blast Cleaning
  - **Cast Ductile Iron Fittings:** NAPF 500-03-05 Abrasive Blast Cleaning

#### Surface Preparation Standards

<table>
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<th>NACE</th>
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<td>White Metal</td>
<td>Sa 3</td>
<td>SP 6</td>
<td>2</td>
</tr>
<tr>
<td>Near White Metal</td>
<td>Sa 2.5</td>
<td>SP 10</td>
<td>1</td>
</tr>
<tr>
<td>Commercial Blast</td>
<td>Sa 2</td>
<td>SP 7</td>
<td>3</td>
</tr>
<tr>
<td>Brush-Off Blast</td>
<td>Sa 3</td>
<td>SP 7</td>
<td>4</td>
</tr>
<tr>
<td>Hand Tool Cleaning</td>
<td>Rusted</td>
<td>C St 2</td>
<td>SP 9</td>
</tr>
<tr>
<td></td>
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</table>

#### Tinting

Do not tint.

#### Application Conditions

- **Temperature:** 35°F (1.7°C) minimum, 120°F (49°C) maximum (air and surface)
- **Relative humidity:** 85% maximum

Refer to product Application Bulletin for detailed application information.

#### Ordering Information

<table>
<thead>
<tr>
<th>Packaging:</th>
<th>3.25 gallons (12.3L) mixed:</th>
</tr>
</thead>
<tbody>
<tr>
<td>Part A</td>
<td>1 gallon (3.78L) in a five gallon can</td>
</tr>
<tr>
<td>Part B</td>
<td>1 gallon (3.78L)</td>
</tr>
<tr>
<td>Part F</td>
<td>75 lb (33 Kg) Zinc Dust</td>
</tr>
</tbody>
</table>

- **1 gallon (3.78L) mixed:**
  - Part A 0.30 gallon (1.14L) |
  - Part B 0.30 gallon (1.14L) |
  - Part F 22 lb (10 Kg) Zinc Dust|

**Weight:** 27.82 ± 0.2 lb/gal ; 3.33 Kg/L, mixed

#### Safety Precautions

Refer to the SDS sheet before use.

Published technical data and instructions are subject to change without notice. Contact your Sherwin-Williams representative for additional technical data and instructions.

#### Disclaimer

The information and recommendations set forth in this Product Data Sheet are based upon tests conducted by or on behalf of The Sherwin-Williams Company. Such information and recommendations set forth herein are subject to change and pertain to the product offered at the time of publication. Consult your Sherwin-Williams representative to obtain the most recent Product Data Information and Application Bulletin.

#### Warranty

The Sherwin-Williams Company warrants our products to be free of manufacturing defects in accord with applicable Sherwin-Williams quality control procedures. Liability for products proven defective, if any, is limited to replacement of the defective product or the refund of the purchase price paid for the defective product as determined by Sherwin-Williams. **NO OTHER WARRANTY OR GUARANTEE OF ANY KIND IS MADE BY SHERWIN-WILLIAMS, EXPRESSED OR IMPLIED, STATUTORY, BY OPERATION OF LAW OR OTHERWISE, INCLUDING MERCHANTABILITY AND FITNESS FOR A PARTICULAR PURPOSE.**

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The systems listed above are representative of the product’s use, other systems may be appropriate.
Surface Preparations
Surface must be clean, dry, and in sound condition. Remove all oil, dust, grease, dirt, loose rust, and other foreign material to ensure adequate adhesion.

Zinc rich coatings require direct contact between the zinc pigment in the coating and the metal substrate for optimum performance.

Iron & Steel (atmospheric service)
Remove all oil and grease from surface by Solvent Cleaning per SSPC-SP1. Minimum surface preparation is Commercial Blast Cleaning per SSPC-SP6/NACE 3. For better performance, use Near White Metal Blast Cleaning per SSPC-SP10/NACE 2. Blast clean all surfaces using a sharp, angular abrasive for optimum surface profile (2 mils / 50 microns). Coat any bare steel the same day as it is cleaned or before flash rusting occurs.

Ductile Iron Pipe, Atmospheric Service:
Minimum surface preparation is Power Tool Clean per NAPF 500-03-01. Remove all oil and grease from surface by Solvent Cleaning per NAPF 500-03-01.

Ductile Iron Pipe, Buried and Immersion Service:
Minimum surface preparation is Abrasive Blast Cleaning per NAPF 500-03-04. Ductile iron pipe external surfaces, in some cases, can be damaged by excessive abrasive blast cleaning beyond this standard. Remove all oil and grease from surface by Solvent Cleaning per NAPF 500-03-01.

Ductile Iron Fittings:
Minimum surface preparation is Abrasive Blast Cleaning of Cast Ductile Iron Fittings per NAPF 500-03-05. Remove all oil and grease from surface by Solvent Cleaning per NAPF 500-03-01.

Galvanized Steel
Allow to weather a minimum of six months prior to coating. Solvent Clean per SSPC-SP1 (recommended solvent is VM&P Naphtha). When weathering is not possible, the surface has been treated with chromates or silicates, first Solvent Clean per SSPC-SP1 and apply a test patch. Allow paint to dry at least one week before testing adhesion. If adhesion is poor, brush blasting per SSPC-SP16 is necessary to remove these treatments. Rusty galvanizing requires a minimum of Hand Tool Cleaning per SSPC-SP2, prime the area the same day as cleaned or before flash rusting occurs.

Weathered Zinc-Rich Primer
Remove zinc salts by either high pressure water washing and scrubbing with stiff bristle brush or sweep blast followed by water flush. Allow to dry.

Note: If blast cleaning with steel media is used, an appropriate amount of steel grit blast media may be incorporated into the work mix to render a dense, angular 1.5-3.0 mil (38-75 micron) surface profile, per Keane-Tator Surface Profile Comparator. A profile up to 5 mils (127 microns) is acceptable, however, coating must be applied to achieve a minimum of 3 mils (75 microns) dft. This method may result in improved adhesion and performance.

Surface Preparation Standards

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Application Conditions
Temperature: 35°F (1.7°C) minimum, 120°F (49°C) maximum (air and surface)
40°F (4.5°C) minimum, 120°F (49°C) maximum (material)
At least 5°F (2.8°C) above dew point
Relative humidity: 85% maximum

Application Equipment
The following is a guide. Changes in pressures and tip sizes may be needed for proper spray characteristics. Always purge spray equipment before use with listed reducer. Any reduction must be compliant with existing VOC regulations and compatible with the existing environmental and application conditions.

Reducer/Clean Up
Below 80°F .................. Reducer #58 or MEK
Above 80°F .................. Reducer #58 or Reducer #104

Airless Spray
(use Teflon packings and continuous agitation)
Pressure.................................2000 - 2500 psi
Hose..................................3/8" ID
Tip......................................015" - .019"
Filter...................................none
Reduction.........................As needed up to 5% by volume

Conventional Spray
(continuous agitation required)
Gun.................................Binks 95
Fluid Nozzle.......................68
Air Nozzle..........................68P
Atomization Pressure..............50 psi
Fluid Pressure....................10 - 20 psi
Reduction.........................As needed up to 5% by volume

Keep pressure pot at level of applicator to avoid blocking of fluid line due to weight of material. Blow back coating in fluid line at intermittent shutdowns, but continue agitation at pressure pot.

Brush
Brush.................................Small areas only; natural bristle
Reduction.........................Not recommended

If specific application equipment is not listed above, equivalent equipment may be substituted.
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**Performance Tips**

Strip out all crevices, welds, and sharp angles to prevent early failure in these areas.

When using spray application, use a 50% overlap with each pass of the gun to avoid holidays, bare areas, and pinholes. If necessary, cross spray at a right angle.

Spreading rates are calculated on volume solids and do not include an application loss factor due to surface profile, roughness or porosity of the surface, skill and technique of the applicator, method of application, various surface irregularities, material lost during mixing, spillage, overthinning, climatic conditions, and excessive film build.

Excessive reduction of material can affect film build, appearance, and performance.

Do not mix previously catalyzed material with new.

Do not apply the material beyond recommended pot life.

In order to avoid blockage of spray equipment, clean equipment before use or before periods of extended downtime with MEK, R6K10.

Keep pressure pot at level of applicator to avoid blocking of fluid line due to weight of material. Blow back coating in fluid line at intermittent shutdowns, but continue agitation at pressure pot.

A maximum of 7 mils (175 microns) dry film thickness is acceptable for shop applications. Consult Sherwin-Williams technical representative for applications which may exceed this limit.

Refer to Product Information sheet for additional performance characteristics and properties.

**Safety Precautions**

Refer to the SDS sheet before use.

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**Application Bulletin**

**Application Procedures**

Surface preparation must be completed as indicated.

Zinc Clad 4100 comes in 3 premeasured containers which when mixed provide 3.25 gallons (12.3L) or 1 gallon (3.78 L) of ready-to-apply material depending on kit size.

Mixing Instructions:

Mix contents of component A and B thoroughly with low speed power agitator. Make certain no pigment remains on the bottom of the can. Then combine 1 part by volume of Part A with 1 part by volume of Part B, then add the appropriately sized Part F (zinc dust). Thoroughly agitate the mixture with power agitation. After mixing, pour through a 30-60 mesh screen. Re-stir before use. If reducer solvent is used, add only after components have been thoroughly mixed. Continuous agitation of mixture during application is required, otherwise zinc dust will quickly settle out.

Apply paint at the recommended film thickness and spreading rate as indicated below:

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NOTE: Brush or roll application may require multiple coats to achieve maximum film thickness and uniformity of appearance.

**Drying Schedule @ 4.0 mils wet (100 microns):**

| To touch: | 30 minutes | 30 minutes | 20 minutes | 15 minutes |
| To handle: | 120 minutes | 100 minutes | 60 minutes | 15 minutes |
| To recoat: | minimum: 4 hours | 2 hours | 30 minutes | 20 minutes |
| Maximum*: unlimited | unlimited | unlimited | unlimited |

*Maximum Recoat: Unlimited. Must have a clean, dry surface for topcoating. "Loose" chalk or salts must be removed in accordance with good painting practice.

**Pot Life:**

| 35°F/1.7°C | 50°F/10°C | 77°F/25°C | 100°F/38°C |
| 50% RH | 7 days | 7 days | 5 days | 3 days |

**Sweat-in-Time:**

| none | none | none | none |

Application of coating above maximum or below minimum recommended spreading rate may adversely affect coating performance.

**Clean Up Instructions**

Clean spills and spatters immediately with MEK. Clean tools immediately after use with MEK. Follow manufacturer's safety recommendations when using any solvent.

**ZINC CLAD® 4100**

**ORGANIC ZINC-RICH EPOXY PRIMER**

**PART A** B69A120 **BASE HARDENER**

**PART B** B69V120 **ZINC DUST**

**PART F** B69D11

**Application Bulletin**

**Revised:** March 5, 2020

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