EQUIPMENT FOUNDATION SYSTEMS

ITW Polymer Technologies

ITW RUST INHIBITIVE 7CZ PRIMER

Technical Bulletin # 1035

Product Description

ITW RUST INHIBITIVE 7CZ PRIMER is a lead and chromate free, rust inhibitive, two-component, epoxy primer specifically designed for use in conjunction with ITW Polymer Technologies coatings applied to metal substrates. It meets USDA standards for maintenance protective coatings not in direct contact with food in federally inspected meat and poultry plants.

Use & Benefits

ITW RUST INHIBITIVE 7CZ PRIMER is recommended for use as a metal primer in severe industrial and chemical environments. It possesses excellent adhesion to properly prepared iron and steel surfaces, providing rust resistance to ferrous substrates, both on initial application and in the event of damage to the topcoat. It can be used under many epoxy, urethane, vinyl, chlorinated rubber and coal tar/epoxy finish coats.

Surface Preparation

Steel: Surfaces must be dry, clean and free of all previous coatings, rust and surface contamination. Minimum surface preparation is abrasive blast to Commercial Grade SP-6. Blasted surfaces must be coated within 8 hours. Prior to blast cleaning, remove all deposits of oil or grease using Solvent Clean method SP-1.

Previously Painted Surfaces: If the paint is peeling or degrading in any way, it should be completely removed by sanding, blasting or stripping. If previous paint coating is completely intact, the surface may be cleaned with a strong detergent or solvent and scuff sanded to remove the gloss. A spot test should be made by applying a small amount of coating over old paint. The old finish may wrinkle or lift within 60 minutes. If it does not, wait 5 days and test for adhesion. Do this by cutting an "X" into the coating, place tape firmly over the cut, then strip with a hard, fast pull. If the old finish fails, it must be removed.

Application Instructions

1. Application should only take place when surface and ambient temperature is 40°F (4.4°C) or above and the material temperature is no lower than 50°F. Application not recommended with surface temperatures over 140°F. Surface to be painted must be at least 5°F(3°C) above the dew point.
2. ITW RUST INHIBITIVE 7CZ PRIMER should be applied to a minimum 2-3 mils (50-75 microns) dry film thickness above the averaged surface profile.
3. ITW RUST INHIBITIVE 7CZ PRIMER can be applied by spray, roller or brush. Spraying should be done perpendicular to the surface to insure complete coverage. Each pass of the spray gun should overlap the previous pass by 50%. Weld seams and edges should be stripe coated prior to complete prime coat.
4. ITW RUST INHIBITIVE 7CZ PRIMER is a two-part compound. Mechanically mix the base portion until homogenous. Pour the hardener into the container of base material and mechanically stir thoroughly until uniform (approximately three minutes). NO THINNERS MAY BE ADDED. Make sure that all sediment is stirred up off the bottom of the can.
5. ITW RUST INHIBITIVE 7CZ PRIMER does not require the usual induction period and may be applied immediately after mixing. Working pot life is 4 hours at 70°F.
6. The primed surface should be protected from contamination. Block off area to prevent any foot or rolling traffic.

ITW POLYMER TECHNOLOGIES
130 Commerce Drive • Montgomeryville, PA 18936
Phone 215-855-8450 • Fax 215-855-4688
www.chockfastgrout.com • www.escoweld.com

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7. If the non-skid application is delayed so that the surface becomes contaminated, clean the area again. Tack coat is not normally required provided the non-skid application is made within 7 days at 70°F (21°C). After 7 days, the primed surface must be mechanically abraided or brush blasted prior to application of a tack coat.
8. Clean tools and spray equipment immediately after completing installation using an epoxy solvent compliant with state and federal V.O.C. regulations.

Physical Properties

COLOR:	Gray
VOLUME SOLIDS (%):	71%
V.O.C:	2.0 lbs. per gal. (250 grams/liter)
POT LIFE:	4 hours @ 70ºF (21ºC)
DRY TIME:	Tack Free - 1 3/4 hour @ 70ºF (21ºC) Recoat - 12 hours @ 70ºF (21ºC)
COVERAGE:	270 sq. ft./gal. (4 milsDFT/6.5 mils WFT)
APPLICATION TEMPERATURE:	55°F minimum to 95°F maximum (13°C minimum to 35°F maximum) * 5°F (3°C) above dew point
SHELF LIFE:	12 months
RELATIVE HUMIDITY:	85% maximum
REDUCER:	None
CLEAN UP:	IMPAX IXT-59 Solvent
WEIGHT PER GALLON:	12.7 lbs. per gal. (1.52 kg./liter)
UNIT PACKAGING:	Resin (NH): 2.9 L (0.77 gal) in a 1 gal can Hardener (NH): 0.87 L (0.23 gal) in a quart can
UNIT WEIGHT:	Resin: 4.9 kg (10.8 lbs) Hardener: 0.86 kg (1.9 lbs)

Date

10/2007

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