

The film galvanising system Velle Zinc is a one pack coating that contains 96% zinc in the dry film and provides cathodic protection to ferrous metals. It can be used as a unique system as an alternative to hot-dip galvanisation or metallisation, as primer in a duplex system or as a recharging system for hot-dip galvanisation or metallisation. It can be applied by brushing, rolling or spraying on a clean and rough substrate in a wide range of atmospheric circumstances. Velle Zinc is also available as an aerosol and is sold as Velle Zinc Spray.

Physical data and technical information

• Wet product

Components	- zinc powder - aromatic hydrocarbons - binder
Density	2,67 Kg/dm ³ (± 0,06 Kg/dm ³)
Solid content	- 80% by weight (± 2%) - 58% by volume (± 2%) according to ASTM D2697
Type of thinner	Vellesolv
Flash point	≥ 40°C to < 60°C
VOC	474 g/L (EPA method 24) (= 178g/Kg)

• Dry film

Colour	matt metallic grey (colour darkens after contact with humidity)
Zinc content	96% (±1%) by weight, with a purity of 99,995% Velle Zinc gives full cathodic protection and conforms to the standard ISO 3549 in regard to its zinc purity of 99,995 % and to the standard ASTM A780 in regard of its use as repair coating for hot-dip galvanisation.
Special characteristics	- atmospheric temperature resistance - minimum : -40°C - maximum : 120°C with peaks up to 150°C - pH resistance in immersion: from 5,5 pH to 9,5 pH - pH resistance in atmospheric circumstances: from 5,5 pH to 12,5 pH - excellent UV resistance
Non-toxicity	A dry layer of Velle Zinc is not toxic and can be used in contact with potable water, according to the standard BS 6920.



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• Packing

400 ml	aerosol
1 Kg	available, packed in undividable boxes of 12 x 1 Kg
5 Kg	available
10 Kg	available

• Conservation

Storage	store in a cool and dry place
Shelf life	unlimited In case of long time storage it is recommended to shake the unopened tin in an automatic shaker at least once every 3 years.

Application data

• System recommendations

Unique system	<ul style="list-style-type: none">- Velle Zinc is used as a stand-alone system, applied in 2 or 3 layers to obtain a total maximum DFT* of 120 to 180 µm.- This system is strongly recommended because of the easy maintenance. In time the layer will become thinner as the Velle Zinc sacrifices itself due to the cathodic protection. A new layer of Velle Zinc can be directly applied once the surface has been properly cleaned and it will re-liquidise and recharge the previous Velle Zinc layer. The DFT of Velle Zinc that should be applied depends upon the remaining Velle Zinc layer.- The system Velle Zinc 2 x 60 µm DFT conforms to the standards: NORSOK M-501 syst. 7 ISO 12944-6: 2 x 60µm DFT Velle Zinc: C4-High, C5M-Medium and C5I-Medium 2 x 90µm DFT Velle Zinc: C5M-High and C5I-High
Duplex system	<ul style="list-style-type: none">- In a duplex system, Velle Zinc should be applied in one single application, preferably by spraying, to obtain a maximum DFT of 60 to 80 µm.- The surface of the Velle Zinc should be free of zinc salts and other contaminations prior to application of a topcoat.- Velle Zinc can be topcoated with a wide range of compatible sealers and topcoats. To avoid pinholes when topcoated, use the mist coat & full coat technique (meaning a standard diluted coat of 25 to 30µm DFT followed by a full coat of the same product).



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Stripe-coat	It is recommended to apply a stripe-coat of Velle Zinc by brush on all sharp edges, nuts and bolts and weld areas before the application of the first full layer of Velle Zinc.
Recharging system	Velle Zinc can be applied on top of a hot-dip galvanising layer, a metallisation layer or an old Velle Zinc layer in order to renew or enhance the cathodic protection. The DFT of Velle Zinc that should be applied depends upon the existing galvanising layer.

*DFT & WFT : dry film thickness and wet film thickness ; to be measured **above the peaks** of the roughness profile

- **Coverage and consumption**

Theoretical consumption	- for 60 µm DFT : 0,28 Kg/m ² or 0,10 L/m ² - for 120 µm DFT : 0,55 Kg/m ² or 0,21 L/m ²
Theoretical coverage	- for 60 µm DFT : 3,62 m ² /Kg or 9,67 m ² /L - for 120 µm DFT : 1,81 m ² /Kg or 4,83 m ² /L
Practical coverage	depends upon the roughness profile of the substrate and the application method

- **Environmental conditions during application**

Ambient temperature	- minimum -15°C - maximum 40°C
Relative humidity	- maximum 95%
Surface temperature	- minimum 3°C above the dew point - no visual presence of water or ice - maximum 60°C
Product temperature	During application the temperature of the Velle Zinc liquid must remain between 15 and 25°C. A lower or higher temperature of the product will influence the smoothness of the film when drying.

- **Drying process and overcoating**

Drying process	Velle Zinc dries by evaporation of the solvent. The drying process is influenced by the total WFT, the number of coats applied, the ambient air and surface temperatures and the air
Drying time	for 40 µm DFT at 20°C in a well-ventilated environment: - touch-dry: after 10 min. - dry to handle: after 1 hour - fully cured: after 48 hours - ready for immersion: after 2 hours
Overcoating	- with a new layer of Velle Zinc : - brush : 2 hours after touch dry - spray gun : 1 hour after touch dry - with a compatible paint : after 6 to 24 hours depending on the drying conditions
Reliquidisation	Each new layer of Velle Zinc reliquidises the former Velle Zinc layer so that both layers form one homogeneous layer.

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Quality**



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Instructions for use

- **Surface preparation**

Cleanliness	<ul style="list-style-type: none"> - The most common method to obtain a clean (and at the same time rough) surface for the application of Velle Zinc is: The metal substrate should first be degreased, preferably by steam-cleaning at 140 bar at 80°C. After that it should be grit-blasted or slurry-blasted to cleanliness degree SA 2,5 according to the standard ISO 8501-1 or to the cleanliness degree described in the standards SSPC-SP10 and NACE nr 2. This means that the surface must be free from rust, grease, oil, paint, salt, dirt, mill scale and other contaminants. Once the grit-blasting is completed the surface should be de-dusted with non contaminated compressed air according to the standard ISO 8502-3 (class 2) or in case of slurry-blasting the surface should be dried with non-contaminated compressed air. - Another method to obtain a clean surface is UHP water-jetting to cleanliness degree WJ2 according to the standards NACE nr 5 and SSPC-SP12 level SC1. But keep in mind that this method does not create surface roughness. - This high degree of cleanliness is not needed when Velle Zinc is applied on a hot-dip galvanisation or a metallisation layer, or when it is applied on top of an existing Velle Zinc layer. Please consult with the Velle Zinc metall representative. - For substrates that will not be immersed Velle Zinc can be applied on mild flash rust (FWJ-2) occurring in the allowed time limit. For applications that will be immersed Velle Zinc can only be applied on an SA 2,5 prepared surface with contaminants to NACE No5/SSPC SP-12 level SC1 unless otherwise agreed with the Velle representative. - On small areas or on non-critical applications Velle Zinc can be applied on a surface that is manually prepared to degree St 3 according to ISO 8501-1. Please consult with the Velle representative.
Roughness	<ul style="list-style-type: none"> - Velle Zinc should be applied on a metal substrate that has roughness degree Rz 50 to 70 µm (for total DFT < 280 µm) or Rz 60 to 80 µm (for total DFT > 280 µm) according to the standard ISO 8503-2. This can be obtained by grit-blasting (with sharp particles) but not by shot-blasting (with spherical particles). Make sure that the surface is degreased before the grit-blasting. - This high degree of roughness is not needed when Velle Zinc is applied on a hot-dip galvanisation or a metallisation layer, or when it is applied on top of an existing Velle Zinc layer. Please consult with the Velle representative. - On small areas or on non-critical applications Velle Zinc can be applied on a surface that is manually prepared e.g. with a needle gun or a grinding disk, in order to obtain an adequate roughness for Velle Zinc. Please consult with the Velle representative.



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Maximum time to application	<p>Apply the Velle Zinc as soon as possible on the prepared surface.</p> <ul style="list-style-type: none"> - in dry circumstances : depending on the location - in case of water-cleaning or if the relative humidity is close to 80%: max. 4 hours waiting time <p>If contamination occurs before coating, the surface must be cleaned again as described above. Flash rust can be removed by means of a wire brush.</p>
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• Special instructions

Stirring	<ul style="list-style-type: none"> - Velle Zinc must be thoroughly stirred to achieve a homogeneous liquid before application. After a maximum of 20 min. re-mixing is necessary. - During the spraying application, the product must be stirred continuously.
Dilution	Velle Zinc can be diluted with 0 to 5% (volume on volume) of Vellesolv when using airless spray equipment and 0 to 25% for air supported applications. The Vellesolv must be added whilst stirring.
Rinsing of tools and equipment	Before and after using the spraying equipment, it must be rinsed with Vellesolv. Brushes and rollers should also be cleaned with Vellesolv. Never use White Spirit.
Special demands for spraying equipment	<ul style="list-style-type: none"> - Pour the Velle Zinc through a filter of 100 mesh (150 µm) into the drum. - For the spraying of Velle Zinc, it is better to remove all filters from the pistol and from the drum to avoid blockage.

• Application by brush and roller

Viscosity	Velle Zinc is ready for use when applied by brush or roller. Do not
First layer	The first layer must never be applied by roller, only by brush, in order to fill the cavities of the roughness profile and to wet the surface.
Type of brush and roller	<ul style="list-style-type: none"> - short hair roller (mohair) - industrial round brush

• Application by conventional spray-gun

Dilution	0 to 25% (volume on volume)
Spray viscosity	25 to 35 sec. Ford cup nr. 4 at 20°C
Pressure at the nozzle	2 to 4 bar
Nozzle opening	2,2 to 2,5 mm
Remark	Make sure Velle Zinc is stirred frequently so the zinc in Velle Zinc cannot settle to the bottom.



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- **Application by conventional spray-gun with pressure pot**

Dilution	0 to 25% (volume on volume)
Spray viscosity	25 to 35 sec. Ford cup nr. 4 at 20°C
Pressure at the nozzle	3 to 4 bar
Pot pressure	0,8 to 1,5 bar
Nozzle opening	1,8 to 2,2 mm

- **Application by airless spraying**

Dilution	0 to 5% (volume on volume)
Pressure at the nozzle	± 150 bar
Nozzle opening	± 0,023 inch

- **Other application methods**

Please consult with the Velle Zincmetall representative.

For more specific and detailed recommendations concerning the application of Velle Zinc, please contact the Velle Zinc representative. For detailed information about the health and safety hazards and precautions for use, please refer to the Velle Zinc **safety data sheet**.

Waiver*

* The information on this sheet is merely indicative and is given to the best of our knowledge based on practical experience and testing. The conditions or methods of handling, storage, use or disposal of the product cannot be controlled by us and are therefore outside our responsibility. For these and other reasons we retain no liability in case of loss, damage or costs that are caused by or that are linked in any way to the handling, storage, use or disposal of the product. Any claim concerning deficiencies must be made within 3 months upon reception of the goods quoting the relevant batch number. We retain the right to change the formula if properties of the raw material are changed. This data sheet replaces all former specimens.

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