

# CATHA-COAT<sup>®</sup> 302H

## Reinforced Inorganic Zinc Primer

Cat. # 302HXXXX

### PRODUCT DESCRIPTION

**Generic:** Reinforced Inorganic Zinc Silicate

**General Description:** A high performance, two component, reinforced inorganic zinc-rich primer with proven cathodic protection of steel structures.

This unique formula features a pre-mixed zinc base which, when converted, can be applied over commercial abrasive-blasted steel (SP6, Sa2). Most ICI Devoe Coatings High Performance Finishes can be applied as soon as solvents evaporate from the film without topcoat bubbling normally experienced over inorganic zinc-rich primers.

**Typical Uses:** Ideal for cathodic protection of steel structures, tanks, equipment, piping and other steel surfaces exposed in mild to severe industrial environments. Also ideal for touch-up and maintenance work because of its easy application, wide compatibility and fast dry-to-recoat.

### SPECIFICATION DATA

**Color:** Green (302H0250)

**Finish:** Flat

**Reduction Solvent:** T-10 Thinner

**Clean-up Solvent:** T-10 Thinner

**Weight/Gallon:** 19.5 lbs./gal. (2.34 kg/L)

**VOC:** (EPA 24) 2.37 lbs./gal. (282 g/L)

**Solids By Volume:** 78% (wet/dry method)

**Theoretical Coverage at 1.0 Mil Dry:** 1250 sq. ft./gal. (30.6 m<sup>2</sup>/L)

**Recommended Film Thickness:** 2.0-4.0 mils (50-100 microns) dry – 2.6-5.0 mils (65-125 microns) wet

**Systems:** Please consult the appropriate system guide, the particular job specification or your ICI Devoe Coatings' Industrial Coatings Specialist for proper systems using this product. Systems must be selected considering the particular environment involved.

**Service Temperature Limits:** 400°F (205°C) dry, intermittent

**Minimum Dry Time (ASTM D 1640):** At 3 mils (75 microns) DFT

Substrate Temperature	40°F (4°C)	60°F (16°C)	80°F (27°C)
Minimum Recoat	5.5 Hours	2 Hours	1 Hour
Dry Hard	13 Hours	7 Hours	4 Hours
Maximum Recoat			
Self	90 Days	90 Days	90 Days
224HS	14 Days	14 Days	14 Days
231, 233H, 236	90 Days	90 Days	90 Days
235	60 Days	60 Days	60 Days
Devthane 369	60 Days	30 Days	7 Days

**Warning:** The above table provides general guidelines only. Always consult your ICI Devoe Coatings Specialist for appropriate recoat windows since the maximum aged recoat time of this product may be significantly shortened or lengthened by a variety of conditions, including, but not limited to humidity, surface temperature, and the use of additives or thinners. The use of accelerators or force curing may shorten the aged recoat of individual coatings. The above recoat windows may not apply if recoating with a product other than those listed above. If the maximum aged recoat window is exceeded, please consult your ICI Industrial Coatings Specialist for appropriate recommendations to enhance adhesion. Failure to observe these precautions may result in intercoat delamination.

**Shelf Life:** Over 24 months at 77°F (25°C) – unopened

**Hardness (ASTM D 3363, 7 day cure @ 77°F (25°C):** 6H

**Mix Ratio By Volume:** 9 (base): 1 (converter) – see mixing instructions.

**Induction:** 15 minutes minimum below 60°F (16°C) – see mixing instructions.

**Pot Life:** 8 hours @ 77°F (25°C) & 50% R.H.

### FEATURES

**Advantages:**

- Exceptional corrosion resistance
- Provides cathodic protection
- Easy to mix
- Zinc premixed in base component
- Fast dry to handle and recoat
- Formulated to resist topcoat bubbling
- Exceptional resistance to mud cracking
- Applies easily by brush, roll or spray
- Accepts a wide variety of topcoats for severe exposures
- Formulated without lead, chromate, or mercury components
- Does not require humidity to cure

**Limitations of Use:** Do not topcoat with alkyd or alkyd-urethane coatings. Not suitable for solvent or chemical immersion.

### PERFORMANCE DATA

**Salt Spray Resistance (ASTM B 117) – Excellent**

**Direct Impact Resistance (ASTM D 2794) – Excellent**

**Abrasion Resistance (ASTM D 4060) – Good**

**Humidity Resistance (ASTM D 2247) – Excellent**

**Water Immersion (ASTM D 1308) – Excellent**

## GENERAL SURFACE PREPARATION

All surfaces must be sound, dry, clean and free of oil, grease, dirt, mildew, form release agents, curing compounds, loose and flaking paint and other foreign substances, and be structurally sound. Round off welds and sharp edges and remove weld splatter.

**New Surfaces: Steel** – Abrasive blast to minimum SSPC-SP6, (SSI-Sa2). A cleaner surface (i.e. SSPC-SP10, SSI-Sa2½ near-white) will enhance primer and system performance. The blast profile should be jagged rather than “peened” and between 1½

to 2½ mils (38-62 microns). After blasting, vacuum or blow off all abrasive dust and ensure surface remains clean before painting.

**Previously Painted Surfaces:** Remove old paint to bare metal. Prepare surface and prime as for new steel. Achieve a minimum of SSPC-SP6 (SSI-Sa2) on rough or pitted steel.

## DIRECTIONS FOR USE

**Tinting:** Do not tint.

**Thinning:** Thinning is not normally required or desirable. However, at lower temperatures, small amounts (10% or less) of Devoe T-10 Thinner can be added to the mixed components depending on local VOC and air quality regulations.

**Mixing:** CATHA-COAT 302H Primer is supplied in either a 5 gallon or 1 gallon kit which contains the proper ratio of ingredients. The entire contents of each container must be mixed together. The zinc metal is ready-mixed in the base portion. Stir thoroughly with a slow speed mixer while slowly adding the converter. Continue to mix at slow speeds to a homogeneous condition. At temperatures of 60°F (16°C) or above, allow a 15 minute induction time before using. Add about 10 minutes for each 10°F (6°C) lower temperature. The pot life, 8 hours at 77°F (25°C), will be longer at lower temperatures and shorter at higher temperatures.

**Application:** Spray, roller or brush. Use brush and roller primarily for touch-up and repair. Brushing and rolling may require multiple coats to achieve correct film thickness and/or hiding. Spray is preferred for uniform film build. Use agitated spray pots. For air spray, use .070” or larger tip, 15 psi fluid pressure,

fluid hose 1/2” I.D. and maximum 50 ft. length. For airless spray use a sprayer capable of 3,000 psi (207 bars) and able to support a .025” diameter tip, fluid hose 3/8” I.D. and maximum 50 ft. length. Pressure pots or pumps should be at same level or above spray guns. Keep fluid pressures to minimum. Rough or heavily pitted steel requires higher (or increased) dry film thickness for optimum protection. Care should be taken to ensure that proper film thicknesses are applied.

**Spreading Rate:** Apply at 225-450 sq.ft. per gallon (6-11 m<sup>2</sup>/L) depending on surface texture and porosity. Make allowances for any losses due to overspray or surface irregularities.

**Topcoats:** CATHA-COAT 302H can be readily recoated by itself for easy touch-up. May be topcoated with DEVTRAN® 224HS or BAR-RUST™ Epoxy Coatings. No tie coat is required before applying finish coat. Do not topcoat with alkyd or alkyd-urethane coatings.

**Dry Time:** At 77°F (25°C) & 50% R.H., dries to recoat in 1½ hours; hard 4-6 hours.

**Clean-up:** Use T-10 Thinner.

## PRECAUTIONS

For industrial use only. Keep out of reach of children. Consult Material Safety Data Sheets appropriate for this product for important health and safety information prior to use.

	COMPONENT	HEALTH	FLAMMABILITY	REACTIVITY
HMIS DATA	302H BASE 302F0250	2*	3	2
	302H CONVERTER 302G0910	2*	3	1

\* Indicates possible chronic health hazard

## SHIPPING

**Freight Classification:** Paint, 3, PG III, UN1263 (Flammable Liquid)  
**Flash Point:** 80°F (27°C)  
**Packaging:** 1 gallon kit (3.785L)      5 gallon kit (18.925L)  
 0.90 gallon base      4.50 gallon base  
 0.10 gallon converter      0.50 gallon converter

**Shipping Weight:** 4-1 gallon kits - 85 lbs. (38.6 kg)  
 5 gallon kit - 102 lbs. (46.3 kg)

302HXXXX (9/99)  
 Ad Stock #68650A



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