



# Dimetcote 19

## Inorganic Zinc Coating

### Product Data/ Application Instructions

- A heavy-duty primer that protects with just a single coat
- Outstanding application characteristics over a wide range of atmospheric conditions
- Can be applied by airless or conventional spray
- Excellent heavy-build tolerance in corners and angles
- High-metallic zinc content provides long-term corrosion protection that reduces maintenance costs

#### Typical Uses

As a single coat, Dimetcote 19 resists severe weathering and marine environments. As a primer with recommended topcoats, Dimetcote 19 is resistant to industrial and chemical exposure as well as marine exposure of structural steel and pipes, tank exteriors, bridges, offshore platforms, marine hulls, superstructures and decks.

#### Recommended Systems

Dimetcote 19 can be topcoated amongst others with suitable polysiloxanes and epoxies. For specific recommendations consult your PPG representative.

#### Resistance

Dimetcote 19 without a topcoat has excellent resistance to weathering and ultraviolet exposure. With suitable topcoats Dimetcote 19 is recommended for fumes and splash of mild alkalies, dilute acids (fumes only), salt solutions of most types. Dimetcote 19 is not recommended for spillage of acid or alkaline solutions.

#### Repair

Rusted areas must be spot blasted in accordance with instructions under "Surface Preparation" before touching up with Dimetcote 19. When blasting is not practical, suitable Amercoat zinc-based primers may be used for repair. See product literature for selection according to topcoat compatibility.

#### Physical Data

Finish .....	flat
Colour .....	grey
Components .....	2
Mixing ratio (by weight)	
liquid .....	1 part
powder .....	2.8 parts
Curing mechanism .....	solvent release and reaction with atmospheric moisture
Volume solids .....	62% (ISO 3233)*
VOC .....	22% by weight / 567 g/l
Dry film thickness .....	65 µm per coat
Number of coats .....	1
Calculated .....	9.5 m <sup>2</sup> /l at 65 µm
Allow for application losses, surface irregularities, etc.	
Specific gravity .....	2.58 kg/l mixed product
Flash points	
(Closed Cup).....	°C    °F
liquid .....	12    53
Thinner 40-25 .....	12    53
Thinner 90-58 .....	24    75

\* Volume solids is measured in accordance with ISO 3233. Slight variations ±3% may occur due to colour and testing variances.

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## Topcoating

Dimetcote 19 surface must be clean and dry before topcoating. Water soluble contaminants must be washed off with water. Oil, grease and similar contaminants may be removed. Rinse with clean water and allow to dry. Solvent wiping is not satisfactory as contamination may be spread and not removed. NOTE: a mist coat / full coat may be required when applying a subsequent coat on top of Dimetcote 19 to prevent application bubbling. Consult your PPG representative for recommendations

## Surface Preparation

**STEEL** - Dry abrasive blast in accordance with Swedish Standard Sa 2½ SIS 05 5900 - 1967, ISO 8501-1 or Steel Structures Painting Council SP-10. NOTE: Blast to achieve a 35 to 65 µm profile as determined with Testex Tape or similar instrument. Rougher profiles are acceptable but require increased film thickness for equivalent protection. Remove abrasive residues and dust from surface. Apply Dimetcote 19 as soon as possible after surface preparation to prevent any contamination. Do not leave blasted steel uncoated overnight. Spot reblast steel if needed.

## Application Equipment

The following equipment is listed as a guide and suitable equipment from other manufacturers may be used. Adjustments of pressure and change of tip size may be needed to obtain the proper spray characteristics.  
**AIRLESS SPRAY** - Standard airless spray equipment, such as Graco, DeVilbiss, Nordson-Bede, Spee-Flo, or others having a 28:1 or higher pump ratio and a fluid tip with a 0.48 mm (0.019 inch) orifice or larger.  
**CONVENTIONAL SPRAY** - Industrial equipment such as DeVilbiss MBC or JGA gun with 704 or 765 air cap and "E" nozzle with leather or Teflon needle packing and heavy mastic spring. Separate air and fluid pressure regulators, variable speed agitator in the pressure pot and a moisture and oil trap in the main air supply line are recommended.  
**MIXER** - Use power mixer powered by an air motor or an explosion proof electric motor.

## Application Data Summary

Like all high performance coatings, this product must be applied as recommended to obtain the maximum protection for which this coating is formulated. To obtain the maximum performance for which Dimetcote 19 is formulated, strict adherence to all application instructions, precautions, conditions and limitations is necessary. If conditions exist that are not within the requirements or limitations described, consult your PPG representative.

## Application Data

Substrate ..... steel  
Application ..... airless or conventional spray  
Potlife (at 20°C/68°F) ..... 8 hours

Potlife is dependent on temperature and quantities mixed.

### Environmental Conditions

(during application)  
Air temperature: ..... -5 to 50°C      23 to 122°F  
Surface temperature: ..... -5 to 65°C      23 to 149°F

To prevent moisture condensation during application, surface temperature must be at least 3°C/5°F above dew point. At freezing temperatures surface must be free of ice.

Never apply coatings under reverse environmental conditions. Ensure good ventilation when applied in confined areas to assist evaporation and elimination of solvents.

### Drying Times

(at 20°C/68°F)  
dry to touch ..... 5 minutes  
dry to handle ..... 30 minutes  
dry to topcoat ..... 6 hours (R.H. 50% or higher)

NOTE: Drying times are dependent on air and steel temperature, applied film thickness, ventilation and other environmental conditions. Times are proportionally shorter at higher temperature and longer at lower temperatures. Prior to recoating ensure the surface is clean. Maximum recoating time depends on coating system to be used. Consult your PPG representative for specific recommendations.

Thinner ..... Thinner 40-25  
Cleaner ..... Thinner 90-58

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## Application Procedure

Dimetcote 19 is packaged in the proper mixing proportions of powder and liquid.

Powder: 19 kg in a 10 l can.

Liquid: 6.8 kg in a 10 l jerrycan.

1. Flush all equipment with recommended cleaner to remove any moisture that may be present. Moisture can cause hardening of Dimetcote 19 in equipment.
2. Stir liquid.
3. Discard desiccant bag from powder can and gradually stir powder into liquid. Continue stirring until powder is well dispersed and mixture is free of lumps.
4. Strain material through 250 µm (60 mesh) screen to prevent possible clogging of equipment.
5. Since potlife is limited and shortened by high temperatures, do not mix more material than will be used within the following times (in hours).

°C/°F	10/50	20/68	30/86	50/122
	24	8	6	3

IMPORTANT: At the end of the potlife, 'kick-out' or separation of the liquid and solids occur, together with gassing.

Do not keep mixed material which will not be used before the end of the pot life in tightly closed containers as gassing can create enough pressure to cause containers to burst. Cover containers loosely.

6. Keep containers loosely covered until ready to use to prevent skinning or gelling due to moisture in air. Skins should be skimmed off the top and the material strained through cheese-cloth or 60 mesh screen to remove any remaining pieces of skin. Discard gelled material.
7. Thinning is normally not required. If thinning is necessary for workability or when a rough film or "dry spray" is obtained because of fast evaporation during hot weather or high wind, thin with no more than 10 vol % of recommended thinner.
8. Adjust spray equipment to apply to an even wet coat with minimum overspray.
9. Continue slow stirring during application to maintain uniformity of material. Avoid fast stirring as this may cause a rise in material temperature shortening pot life.
10. Apply in even, parallel passes and overlapping each pass 50%. Pay special attention to welds, cut-outs, sharp edges, rivets, bolts, etc. to ensure proper thickness.
11. Check thickness of dry coating with a non-destructive dry film thickness gauge, such as Mikrotest or Elcometer. Recoat if greater thickness is required. Normal recommended thickness is 65 µm. Allowable thickness range is 50 to 150 µm, assuming the surface profile is within the recommended range. Greater thickness may develop cracking.
12. Random pinholes, holidays and small damaged or bare areas can be touched up by brush when film is dry to touch. Larger areas should be resprayed.  
NOTE: Maximum recoat time with itself is 16 hours. No condensation or rain may be allowed on the surface of the dry coating before recoating.
13. Prevent contact with water until the freshly applied coating is at least dry to touch.
14. In confined areas ventilate with clean air during application and drying until all solvents are removed. Temperature and humidity of ventilating air must be such that moisture condensation will not form on surface.
15. Clean all equipment with recommended cleaner immediately after use or at least at the end of each working day or shift. Clean spray guns more often during hot weather. When left in equipment Dimetcote 19 will harden and plug spray equipment.

## Shipping Data

Packaging  
powder ..... 19 kg in 10 l can  
liquid ..... 6.8 kg in 10 l jerrycan

Shipping weight  
powder ..... approx. 20.0 kg  
liquid ..... approx. 7.5 kg

Shelf life  
powder ..... 1 year from shipment date when stored indoors in unopened, original containers at 5 to 40°C (41 to 104°F).

liquid ..... 6 months from shipment date when stored indoors in unopened, original containers at 5 to 40°C (41 to 104°F).

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## Caution

This product is highly flammable. Dimetcote 19 powder is harmful dust. Contains zinc. Avoid breathing dust. Wash thoroughly before eating or smoking. Keep away from feed or food products. Contact with water liberates highly flammable gases, spontaneously flammable in air. If welding is to be performed in confined spaces on steel coated with Dimetcote 19, do so in accordance with instructions in USA Standard Z 49.1-1973 "Safety in Welding and Cutting". For specific information on hazardous ingredients, required ventilation, possible consequences of contact and safety measures see Safety Data Sheet.

## Safety

Since improper use and handling can be hazardous to health and cause of fire or explosion, safety precautions included with Product Data/Application Instruction and Material Safety Data Sheet must be observed during all storage, handling, use and drying periods.

## Warranty

PPG warrants its products to be free from defects in material and workmanship. PPG's sole obligations and Buyer's exclusive remedy in connection with the products shall be limited, at PPG's option, to either replacement of products not conforming this warranty or credit to Buyer's account in the invoiced amount of the non-conforming products. Any claim under this warranty must be made by Buyer to PPG in writing within five (5) days of Buyer's discovery of the claimed defect, but in no event later than the expiration of the applicable shelf life, or one year from the delivery date, whichever is earlier. Buyer's failure to notify PPG of such non-conformance as required herein shall bar Buyer from recovery under this warranty.

**PPG makes no other warranties concerning the product. No other warranties, whether express, implied or statutory, such as warranties of merchantability or fitness particular purpose, shall apply. In no event shall PPG be liable for consequential or incidental damages.**

Any recommendations or suggestion relating to the use of the products made by PPG, whether in its technical literature, or response to specific enquiry, or otherwise, is based on data believed to be reliable; however, the products and information are intended for use by Buyer's having requisite skill and know-how in the industry, and therefore it is Buyer to satisfy itself of the suitability of the products for its own particular use and it shall be deemed that Buyer has done so, as its sole discretion and risk. Variation in environment, changes in procedures of use, or extrapolation of data may cause unsatisfactory results.

## Limitation of Liability

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Due to PPG's policy of continuous product improvement, the information contained in this Product Data/Application Instructions sheet is subject to change without notice. It is the Buyer's responsibility to check that this issue is current prior to using the product. For the most up-to-date Product Data/Application Instructions always refer to the PPG Protective & Marine Coatings website at [www.ppgpmc.com](http://www.ppgpmc.com)

To avoid any confusion that may arise through translation into other languages, the English version of the Product Data/Application Instructions will be the governing literature and must be referred to in case of deviations with product literature in other languages.

## Condition of Sale

All our transactions are subject to our Terms and Conditions of Sale.