

# Technical Data

## MUKI - Z No. 2001 FW



### Product description

Muki-Z No. 2001 FW is a two-pack, modified low zinc ethyl silicate shopprimer designed to utilize extra high productivity in connection with advanced welding technology (MIG/ MAG/G-FCAW). Other pronounced features with Muki-Z No. 2001 FW are the reduced health risk during welding and cutting and the reduction in weld defects.

### Recommended use

To be used as a preconstruction primer on blast-cleaned steel surfaces in automatic shop-priming plants to protect steel during transport, storage and production.

### Film thickness and spreading rate

	Minimum	Maximum
Film thickness, dry ( $\mu\text{m}$ )	15	20
Film thickness, wet ( $\mu\text{m}$ )	55	70
Theoretical spreading rate ( $\text{m}^2/\text{l}$ )	18.7	14

### Comments

Dry film thickness measured on a smooth test panel.

### Physical properties

Colour	Green, Grey and Red.
Solids (vol %)*	$28 \pm 2$
Flash point	$14^\circ\text{C} \pm 2$ (Setaflash)
Gloss	Flat
Water resistance	Very good
Abrasion resistance	Excellent
Solvent resistance	Excellent
Chemical resistance	Excellent within pH range 6-10.
Flexibility	Limited

\*Measured according to ISO 3233:1998 (E)

## Surface preparation

All surfaces should be clean, dry and free from contamination. The surface should be assessed and treated in accordance with ISO 8504.

### Bare steel

Cleanliness: Blast cleaning to Sa 2½ (ISO 8501-1:1988). Roughness: using abrasives suitable to achieve grade Fine to Medium G (30-85 µm, Ry5) (ISO 8503-2)

### Other surfaces

The coating may be used on other substrates. Please contact your local Jotun office for more information.

## Condition during application

The temperature of the substrate should be minimum at least 3°C above the dew point of the air, temperature and relative humidity measured in the vicinity of the substrate. Recommended steel temperature: 30-40°C.

## Application methods

**Spray** Use airless spray or conventional spray  
**Brush** Recommended for touch-up purposes.

## Application data

**Mixing ratio (volume)** 10 parts by volume Comp. A (Silicate solution) to be thoroughly mixed with 6,75 parts by volume Comp. B (Zinc paste).

**Pot life (23°C)** 24 hours. (Reduced at higher temperatures).

**Thinner/Cleaner** Jotun Thinner No. 4/25  
(No. 4 - Fast Evaporation) - (No. 25 - Slow evaporation).

### Guiding data airless spray

**Pressure at nozzle** 5 - 7 MPa (50 - 70 kp/cm<sup>2</sup>, 700 - 900 psi).

**Nozzle tip** 0.38 - 0.58 mm (0.015 - 0.023").

**Spray angle** 40 - 95°

### Note

\* Proper routines for cleaning and maintenance of the priming unit are necessary to achieve high productivity and uniform quality. Before start of work and after finishing with Muki-Z No. 2001 FW it is recommended to circulate Jotun Thinner No. 4 or No. 25 through the entire spraying equipment for some minutes. During application it is necessary to use a mechanical stirrer.

\* The Comp. B (Zinc paste) must be stirred continuously while the Comp. A (Silicate solution) is added.

## Drying time

Drying times are generally related to air circulation, temperature, film thickness and number of coats, and will be affected correspondingly. The figures given in the table are typical with:

- \* Good ventilation (Outdoor exposure or free circulation of air)
- \* Typical film thickness
- \* One coat on top of inert substrate
- \* Relative humidity at 80 %

Substrate temperature	23°C	40°C
Surface dry	1-3 min	20-40 sec
Through dry	3-5 min	
Cured <sup>1</sup>	1 d	1 d
Dry to recoat, minimum <sup>2</sup>	1 d	1 d
Dry to recoat, maximum <sup>3</sup>		

1. Curing time to be verified by MEK-test (ASTM D 4752-87).
2. Recommended data given for recoating with coatings normally specified on top of shopprimers.
3. The substrate should be free from any zinc salts and other contamination prior to application of the subsequent coat.

The given data must be considered as guidelines only. The actual drying time/times before recoating may be shorter or longer, depending on film thickness, ventilation, humidity, underlying paint system, requirement for early handling and mechanical strength etc. A complete system can be described on a system sheet, where all parameters and special conditions could be included.

## Typical paint system

**Muki-Z No. 2001 FW 1 x 15 - 20 µm (Dry Film Thickness measured on a smooth test panel).**

Undamaged shopprimer can be overcoated with a choice of systems based on epoxy, vinyl or chlorinated rubber resins.

**Other systems may be specified, depending on area of use**

## Storage

The product must be stored below 25°C and in accordance with national regulations. Storage conditions are to keep the containers in a dry, cool, well ventilated space and away from source of heat and ignition. Containers must be kept tightly closed.

## Handling

SHELF LIFE: 6 months at room temperature for Comp. A. Handle with care. Stir well before Use. Continuous stirring during application will prevent the heavy zinc pigment from settling.

## Packing size

10 L. Comp. A , 6,75 L. Comp. B

Packing may vary from country to country according to local requirements.

## Health and safety

Please observe the precautionary notices displayed on the container. Use under well ventilated conditions. Do not breathe or inhale mist. Avoid skin contact. Spillage on the skin should immediately be removed with suitable cleanser, soap and water. Eyes should be well flushed with water and medical attention sought immediately.

**For detailed information on the health and safety hazards and precautions for use of this product, we refer to the Material Safety Data Sheet.**

## DISCLAIMER

*The information in this data sheet is given to the best of our knowledge based on laboratory testing and practical experience. However, as the product is often used under conditions beyond our control, we cannot guarantee anything but the quality of the product itself. We reserve the right to change the given data without notice.*

### Head Office & Nordic

Jotun Paints  
P.O. Box 2021  
N-3248 Sandefjord  
Norway  
Phone +47 33 45 70 00  
Fax +47 33 46 46 13

### Europe

Jotun Paints (Europe) Ltd.  
Stather Road, Flixborough  
North Lincolnshire DN15 8RR  
United Kingdom  
Phone +44 172 44 00 000  
Fax +44 172 44 00 100

### Middle East

Jotun U.A.E Ltd. LLC.  
Al Quoz Industrial Area  
P.O Box 3671  
Dubai U.A.E  
Phone +971 4 3 39 50 00  
Fax +971 4 3 38 06 66

### South East Asia

Jotun (Singapore) Pte. Ltd.  
No 11-15, Sixth Lok Yang  
Road  
Jurong  
Singapore 628 111  
Phone +65 6265 4711  
Fax +65 6265 7484

Jotun is a World Wide company with factories, sales offices and stocks in more than 50 countries. For your nearest local Jotun address please contact the nearest regional office or visit our website at [www.jotun.com](http://www.jotun.com)

ISSUED 13 FEBRUARY 2002 BY JOTUN PAINTS  
THIS DATA SHEET SUPERSEDES THOSE PREVIOUSLY ISSUED