

## Guide to Using ZRC in Immersion Service

1. Determine ZRC compatibility with immersion liquid.
2. If compatibility is acceptable, sandblast surface to Near-White Profile.
3. Immediately apply ZRC using two coats to attain a minimum dry film of thickness of 3 Mils leaving 12 hours minimum dry time (1 week max.) between coats. Recoating too soon may result in premature failure due to solvent entrapment in first coat.
4. Allow fully coated surface to dry/cure for 14 days at 25 degrees C before subjecting to immersion service.

**PLEASE NOTE:** 14 day cure time for immersion service is critical due to ZRC's curing mechanisms.

ZRC cures using two methods; The first, and most obvious, is solvent evaporation. Newly applied ZRC appears as a wet, glossy, dark gray surface which turns to light, flat gray upon solvent evaporation. Secondly, once the majority of solvent is gone (within two to three hours), ZRC's binder will begin to oxidize, forming a hard, dense coating.

Initially, the ZRC coating is porous and will allow water to penetrate, perhaps right down to the metal surface, which could cause premature failure. The oxidation process (complete after the prescribed 14 day period) acts to close these pores thereby cutting off the water penetration.

5. In very severe environments (specifically chemical and when pH is < 6.5 and > 10.5) ZRC must be top-coated with materials suited to that particular application to avoid rapid zinc depletion. Please refer to ZRC's Guide to Topcoating for further information.