

ZR-6320 Temporary Protective Coating

TECHNICAL DATA SHEET

Product Description

ZR-6320 is a chrome-free, water-based coating formulated for the temporary protection of aluminum surfaces during manufacturing operations such as roll forming, stretch bending, drop-hammer and riveting operations. It provides a tough, abrasion-resistant, transparent film, thus permitting any layout work that may be necessary. ZR-6320 can be removed with BMS 15-12 Type II approved removers or SC-1101S. The service life of ZR-6320 is 8 months for outdoor or indoor storage.

- Chromate-free
- Water-based
- Non-flammable in liquid form
- Transparent-green
- Compatible with standard type spray guns - either air or airless
- 8 month service life for outdoor or indoor storage

Components



Mix ratio (by volume):

- ZR-6320

Single component, ready to use product

Specifications



ZR-6320 is qualified to the following specifications:

- BMS 15-12 Type I Class 1 & 6

Note: PPG Aerospace recommends you check the most recent specification QPLs for updated information.

Surface Preparation and Pretreatments



Apply to dirt and oil free surfaces.

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Instructions for Use



Mixing Instructions:

ZR-6320 is ready to use with no additional components. Check to ensure that no freezing has occurred in shipping or during storage period. Upon opening container, manually stir thoroughly to overcome any settling. Avoid shaking as product can foam when agitated. No thinning of the compound is required prior to application. The compound should not be admixed with or allowed to come in contact with solvents at any time, since this will cause coagulation. If, for any reason, thinning is desired, only water should be used. Spray equipment can be cleaned with water.



Induction Time:

Not Required



Viscosity: (23°C/73°F)

- Krebs Units 68 - 103



Pot Life:

Not Applicable

Application Guidelines

Recommended Application Conditions:

Temperature	18 - 30°C (65 - 86°F)
Relative Humidity	20 - 90%

Application:

A dry film of one mil in thickness is recommended. This is achieved by applying a wet film of three mils in one coat. Good spray techniques should be used in the application of ZR-6320. With an atomizing air system, a DeVilbiss MBC gun with an FF nozzle and #765 air cap or equivalent is recommended. Just sufficient pressure on the material should be used to deliver the compound to the gun. Atomizing air pressure of 70 lbs. per square inch minimum is desired. If airless spray is to be used, a Graco President Model 28:1 pump utilizing a Reflex gun with a #163-409 spray tip is recommended.

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Removability:

ZR-6320 is removed by applying a wet film of up to 20 mils thick of the SC-1101S remover. It should be allowed to soak into the ZR-6320 for approximately 5 to 20 minutes and then flushed off with water under pressure accompanied by mild brushing.

For spot removal, such as in areas to be riveted, toluene or denatured ethyl alcohol will readily dissolve a one mil coating of ZR-6320. (Heavier films of ZR-6320 are not necessary, and are more difficult to remove.) Apply the solvent with a cloth, allow a few seconds for penetration, and then wipe the area with a clean solvent-wet cloth.

These application guidelines represent PPG's best advice for usage in standard conditions. Some parameters will be influenced by environmental conditions, equipment settings, and other variables.



Theoretical Coverage:

43 square meters/liter at 25 microns dry film (455 square feet/gallon at 1 mil dry film)

Recommended dry film thickness; 25 microns (1 mil)



Equipment:

ZR-6320 is compatible with most forms of spray equipment. See Application section for details.

Equipment Cleaning:

Flush spray equipment ONLY with water.

Physical Properties (product)



Color: Transparent green



Gloss: Not Applicable

Percent Solids: 32.5 ± 2 %

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Dry Times	22 - 28°C (71 - 84°F)
Tack Free	10 minutes minimum
Full Hardness	24 hours

Drying can be accelerated by warm air.

VOC

VOC (EPA method 24):

ZR-6320 135 grams/liter

Physical Constants:

Weight/gallon: 8.7 ± 0.2 pounds/gallon



Flash point closed cup:

ZR-6320 93°C (>200°F)

Shelf Life:

BMS 15-12: 6 months from date of manufacture.

Note: Shelf life is provided for original, unopened containers.

Note: The application and performance property values above are typical for the material, but not intended for use in specifications or for acceptance inspection criteria because of variations in testing methods, conditions and configurations.

Storage Recommendations



Inspect the condition of the container to ensure compliance. The material should be stored at temperatures between 13°C to 32°C (55°F to 90°F) to ensure shelf life. This is a water-base compound and should be protected from freezing. Never allow this product to freeze. Once frozen, application and protective properties are unstable and not warranted.

Note: When procuring to a qualified material specification, follow those storage instructions.

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Health Precautions

This product is safe to use and apply when recommended precautions are followed. Before using this product, read and understand the Safety Data Sheet (SDS), which provides information on health, physical and environmental hazards, handling precautions and first aid recommendations. An SDS is available on request. Avoid overexposure. Obtain medical care in case of extreme overexposure.

For industrial use only. Keep away from children.

Additional information can be found at: www.ppgaerospace.com

For sales and ordering information call the local PPG office at the numbers listed below:

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