

#### Product Description

Endura-Zinc 768 provides outstanding galvanic protection against corrosion in severe environments. It delivers excellent resistance to chemicals and severe weathering making it the strong foundation of a protective coating system. Endura-Zinc 768 can be used as a shop-primer, field-applied maintenance primer on abrasive blasted steel, or for repair of galvanized and inorganic zinc coatings.

#### Intended Uses

- |                                 |                   |                           |                                |  |  |
|---------------------------------|-------------------|---------------------------|--------------------------------|--|--|
| <b>Apply to:</b>                |                   |                           | <b>Protects:</b>               |  |  |
| • Interior or exterior surfaces | • Ferrous metal   | • Tanks                   | • Equipment                    |  |  |
| • Galvanized metal              | • Aluminum        | • Chemical plants         | • Material handling facilities |  |  |
| • Riggings                      | • Sport complexes | • Processing plants       | • Structural or support steel  |  |  |
| • Composites                    | • Pipes           | • Power generating plants |                                |  |  |
- The above are general recommendations and not intended to limit the use of Endura-Zinc 768. Test areas are always recommended to confirm results.  
NOT INTENDED FOR IMMERSION SERVICE.

#### Physical Properties

Resin Type	3 Component Epoxy	
Finish/Sheen	Flat, 0–5 @ 60°	
Color	Reddish Gray LF-0255	
Cure (Part B)	Part B LM-0235	
Zinc Dust (Part C)	Part C Powder LM-0236	
Solids by Weight	90%	
Solids by Volume	64% ± 2%	
Percent Zinc @ DFT	79%	
Theoretical Coverage	1044 ft <sup>2</sup> /gal @ 1 mil	
Dry Film Thickness / Coat	2.0–3.5 mils (50-87.5 microns)	
Wet Film to Achieve DFT	4.0–5.5 mils (100-137.5 microns)	
Coverage at DFT*	298–418 ft <sup>2</sup> /gal	
VOCs	2.55 lbs./gal (306 grams/liter) Activated	
Reduction Solvents	Thin only as needed, up to 5%, Diamond Vogel N-4003 MIBK per gallon	
Clean-up Solvents	Diamond Vogel N-4003 MIBK	
Induction Time	None	
Mixing Ratio (by volume)	4 part A resin to 1 part B cure to 1 part C powder. Product packaged in premeasured kits.	
Pot Life**	7 hours at 70°F (21°C) and 50% Relative Humidity	
Drying Time*** [ASTM D1640]	<b>Dry Through:</b> 9 hours at 70°F (21°C) and 50% Relative Humidity	
Recoat/Topcoat Time***	<b>Minimum Recoat</b>	<b>Maximum Recoat</b>
	Endura-Zinc 768	8 hours at 70°F (21°C)

\* Coverage rates are estimates based on the products volume solids and make no allowance for material loss during application. Actual spread rates may vary dependent on applicator experience, surface porosity and texture.

\*\* Extreme temperatures can dramatically shorten pot life.

\*\*\* Dry times and recoat times vary with surface temperature, air movement, humidity and film thickness. Finish coat selection may extend maximum recoat, please request additional information by contacting Diamond Vogel Technical Service for detailed information.

#### Qualifications

Slip-Co-Efficient and Creep Resistance Class A specification for structural joints using ASTM A325 or A490 Bolts.  
SSPC Paint Specification 20 Type II, Level 2 for Zinc Dust Level Classification

**HIGH PERFORMANCE**

**TECHNICAL DATA**

**Surface Preparation**

All surfaces must be cured, clean, sound and free of all dirt, dust, efflorescence, wax, oil, grease, chalk and any other contamination that would interfere with new coating adhesion. Surface may be damp, but not wet. Bare surfaces must be properly prepared prior to application of this product.

**Ferrous Metal and Previously Paint Metal Surfaces:** Power or hand washing is recommended to remove contamination. If oil or grease is present, use of a cleaner/degreaser is required. All cleaning residue must be completely rinsed from the surface. For new steel and complete removal of the old coating, abrasive blast according to SSPC-SP-6, Commercial Blast Cleaning. Use proper abrasive to achieve a 1.5 to 2 mil profile as per SSPC-SP-6, Commercial Blast Cleaning. Blasted surfaces must be primed before flash rusting occurs.

**Mildew:** Remove by using a solution of one part household bleach and three parts water. Apply to mildewed area and scrub. Allow solution to remain on the surface for 3 to 5 minutes and then rinse completely and allow to dry before coating application.

**Application**

Part A (epoxy resin) and Part B (cure) have a 4:1 mixing ratio. Mix Part A and Part B separately using an explosion-proof power drill and blade type mixer. Add Part B to Part A and thoroughly mix and blend using an explosion-proof power drill and blade type mixer, slowly add Part C zinc powder to mixed liquid components. Constant agitation is recommended to keep heavy zinc material in suspension. Minimum surface and air temperature required for application is 40°F (4°C) and at least 5°F (3°C) above the dew point. Curing is affected by temperature, humidity and air movement. The minimums must be maintained for at least eight (8) hours in order to achieve proper film formation. Application at elevated temperatures, wind conditions, and / or low humidity may require special application procedures to achieve proper film formation.

**Conventional Spray:** Use standard industrial equipment such as Devilbliss or Binks. A mechanical pot agitator and separate regulators for air and fluid pressure are recommended. Changes in pressures, hose and tip size may be needed to adjust for proper spray characteristics.

**Airless Spray:** Flush airless lines with Diamond Vogel N-4003 MIBK. Equipment must be clean prior to start. Thin only as needed for workability. Apply a wet coat in even, parallel passes with 50% overlap to avoid bare areas and pinholes. If required, crosshatch spray at right angles. Remove all filters from the unit and airless spray gun.

Tip Orifice	Atomizing Pressure	Material Hose ID	Manifold Filter
0.017" to 0.019"	2500–3000 PSI	1/4" or 3/8"	none

**Packaging**

**Shipping Weight**

Product	1 Gallon Kit	5 Gallon Kit	Product	1 Gallon Kit (activated)	5 Gallon Kit (activated)
Part A Resin	1 Gallon (80% fill)	5 Gallon (80% filled)	Endura-Zinc 768	22.13 lbs. (10.04 kg)	110.65 lbs. (50.15 kg)
Part B Std Cure	1 Quart (80% fill)	1 Gallon (full filled)			
Part C Zinc Powder	1 Gallon box (27% fill)	5 Gallon (27% fill)			

**Storage**

Two years from date of manufacture when maintained in protected area at a temperature of 40° to 100°F (4° to 38°C). Subject to inspection thereafter.

**Safety Precautions**

**\*WARNING!** If you scrape, sand, or remove old paint, you may release lead dust. LEAD IS TOXIC. EXPOSURE TO LEAD DUST CAN CAUSE SERIOUS ILLNESS, SUCH AS BRAIN DAMAGE, ESPECIALLY IN CHILDREN. PREGNANT WOMEN SHOULD ALSO AVOID EXPOSURE. Wear a NIOSH-approved respirator to control lead exposure. Clean up carefully with a HEPA vacuum and wet mop. Before you start, find out how to protect yourself and your family by contacting the National Lead Information Hotline at 1-800-424-LEAD or log on to [www.epa.gov/lead](http://www.epa.gov/lead).

Paint Products contain chemical ingredients, which are considered hazardous. Prior to use, read container label warnings and the current Safety Data Sheet for important health and safety information. Ensure these instructions are practiced during product application and cure. **Keep out of the reach of children.**

**Safety Data**

“Safety Data Sheets” are available from your Diamond Vogel representative or the Diamond Vogel website at [www.diamondvogel.com](http://www.diamondvogel.com). Prior to use of this product, obtain and review the Safety Data Sheet for health and safety information. Read and observe all precautionary notices on container labels. **NOT INTENDED FOR RESIDENTIAL USE.**

## Limited Warranty

The technical data and suggestions for use contained in this document are true and correct to the best of our knowledge at the date of issuance. The statements of this document do not constitute a warranty, expressed or implied, as to the performance of these products. Since Diamond Vogel does not control the application of its products, or the condition of the surfaces to which they are applied, Diamond Vogel's liability will under no circumstances exceed replacement of the product. **All technical information is subject to change without notice.**

## Additional Information

Cautions and Warnings information is located on the back panel of each product label.

For current information regarding VOC regulations for specific geographical regions, please contact Technical Service at Diamond Vogel Corporate Headquarters, (Contact information is located at the bottom of the page).