

# Dimetcote® 302

(302 Series)

Reinforced inorganic-zinc primer

## Product Data/ Application Instructions (For Marine & Offshore use)

- Applies easier than any other inorganic zinc by all application equipment—spray, roller, brush, or even dip.
- Can be top coated with most organic type coatings as soon as Dimetcote 302 is solvent free, usually in 30 minutes.
- An excellent cathodic protection primer for most corrosion conditions
- Can be used with all PPG PMC High Performance Coating systems
- Zinc dust is already mixed into the liquid base
- Good resistant to dry spray, mudcracking and top coat bubbling

### Typical Uses

Dimetcote 302 Primer is a proven cathodic primer for protecting steel.

On all types of ships and barges, offshore platforms, drilling rigs and all marine structures

Dimetcote 302 Primer is ideal for touch-up and repair because of its ease of mixing, ease of application, fast recoat and wide compatibility.

### Surface Preparation

**Steel**—New without pits or depressions – Dry abrasive blast, SSPC-SP6 or pickle.

**Previously painted or pitted**—Dry abrasive blast, SSPC-SP10. Remove all traces of previous organic coatings as Dimetcote 302 will not adhere to organic coatings.

Blast to achieve a 1½ to 2½ mil (37 to 62 microns) profile as determined with a Keane-Tator Surface Profile Comparator, Testex Tape or similar device. Rougher profiles are acceptable but require increased film thickness for equivalent protection.

Apply Dimetcote 302 as soon as possible to avoid rusting or other recontamination. Do not leave blasted steel uncoated overnight. Spot reblast if needed.

**Galvanizing**—Remove oil, soap film or grease with neutral detergent or emulsion cleaner. Use a zinc treatment such as Galvaprep® or equivalent or blast lightly with fine abrasive.

### Environmental Conditions

Temperature	°F	°C
air	0 to 120	-18 to 49
surface	0 to 130	-18 to 54

Surface temperature must be at least 5°F (3°C) above dew point to prevent condensation. At freezing temperatures, surface must be free of ice.

### Physical Data

Finish	Flat	
Color	Green	
Components	2	
Curing mechanism	Solvent release and cure reaction	
Dry film thickness	3 mils (75 microns)	
Coats	1	
Theoretical coverage	ft <sup>2</sup> /gal	m <sup>2</sup> /L
	1 mil (25 microns)	898
	3 mils (75 microns)	299
VOC	lb/gal	g/L
	mixed	3.6
	mixed/thinned (1 pt/gal)	4.0
Temperature resistance, dry	°F	°C
	intermittent	400
	continuous	200
Flash point	°F	°C
	base	80
	converter	76
	T-10	76
	Amercoat 65	78
	Amercoat 101	145
	Amercoat 12	2
		-17

### Application Data

Applied over	Prepared steel, galvanizing			
Surface preparation	Abrasive blast SSPC-SP6 or 10, Pickling SSPC-SP8			
Method	Airless or conventional spray, brush, roller			
Mixing ratio (by volume)				
	base to converter	4:1		
Pot life (hours)	°F/°C			
	70/21	8		
Drying time (ASTM D1640) 3 mils	°F/°C			
	90/32	70/21	50/10	40/5
hard (hours)	3	5	9	14
through (hours)	5	9	16	—
topcoat with most topcoats (hours)	24			
recoat (hours)	1	1½	3	5
Thinner				
	below 70°F (21°C)	Amercoat 65 or T-10		
above 70°F (21°C)	Amercoat 101			
Equipment cleaner	Amercoat 12			

Use "E" version of thinner and cleaner in air pollution control areas.

## Application Equipment

The following is a guide; suitable equipment from other manufacturers may be used. Changes in pressure, hose and tip size may be needed for proper spray characteristics.

**Airless spray**—Standard equipment, such as Graco Bulldog Hydra-Spray or Speeflo Alaskan PZ and a fluid tip with a 0.021-inch (0.53 mm) orifice or larger.

**Conventional spray**—Industrial equipment such as a DeVilbiss MBC gun with 2E or 704E cap/tip, or a Binks 18 gun with a 66SS x 67PB nozzle setup. A variable speed agitator in the pressure pot and an oil and moisture trap in the main air supply line are essential. Separate air and fluid pressure regulators are recommended.

**Power mixer**—Jiffy Mixer, powered by air or explosion-proof electric motor.

## Application Procedure

Dimetcote 302 Primer is supplied in either a 5 gallon or 1 gallon kit which contains the proper ratio of ingredients. The entire contents of each container must be mixed together.

1. Converter zinc metal is ready mixed in the base portion. Stir thoroughly with a slow speed mixer while slowly adding the liquid component. Continue to mix at slow speeds to a homogeneous condition.
2. At temperatures lower than 60°F (16°C), allow a 15 minute induction time before using. Add about 10 minutes for each 10°F (6°C) lower temperature.
3. Thinning is not normally required or desirable; however, at lower temperatures, up to 10% T-10 Thinner can be added to the mixed components depending on local VOC and air quality regulations. The pot life, 8 hours at 70°F (21°C), will be longer at lower temperatures and shorter at higher temperatures.

## Topcoating

Dimetcote 302 surface must be clean and dry before topcoating. Water soluble contaminants may be washed off with water. Remove grease and similar contaminants with an emulsion type cleaner or neutral detergent. Rinse with clean water and allow to dry. Solvent wiping is not satisfactory as contamination may only be spread and not removed. In some cases a mist coat/full coat technique may be required to prevent application bubbling.

## Repair

Spot-blast rusted areas in accordance with surface preparation instructions before touching up with Dimetcote 302. When blasting is not practical, Amercoat 68HS may be used for repair. See primer product literature for selection according to topcoat compatibility.

## Shipping Data

Packaging units	1 gal	5 gal
Shipping weight (approx)	lb	kg
1-gal unit		
converter	7.6	3.4
base	14.5	6.6
5-gal unit		
converter	36	16.4
base	71	32.2
Shelf life when stored indoors at 40 to 100°F (5 to 38°C)		
converter and base	1 year from shipment date	

Numerical values are subject to normal manufacturing tolerances, color and testing variances. Allow for application losses and surface irregularities.

The mixed product is nonphotochemically reactive as defined by the South Coast Air Quality Management District's Rule 102 or equivalent regulations.

## Safety Precautions

Read each component's material safety data sheet before use. Mixed material has hazards of both components. Safety precautions must be strictly followed during storage, handling, and use.

**Caution – Improper use and handling of this product can be hazardous to health and cause fire or explosion.**

**Do not use this product without first taking all appropriate safety measures to prevent property damage and injuries. These measures may include, without limitation: implementation of proper ventilation, use of proper lamps, wearing of proper protective clothing and masks, tenting and proper separation of application areas. Consult your supervisor. Proper ventilation and protective measures must be provided during application and drying to keep solvent vapor concentrations within safe limits and to protect against toxic hazards. Necessary safety equipment must be used and ventilation requirements carefully observed, especially in confined or enclosed spaces, such as tank interiors and buildings.**

**This product is to be used by those knowledgeable about proper application methods. PPG makes no recommendation about the types of safety measures that may need to be adopted because these depend on application and space, of which PPG is unaware and over which it has no control.**

**If you do not fully understand the warnings and instructions or if you cannot strictly comply with them, do not use the product.**

**Note:** Consult Code of Federal Regulations Title 29, Labor, parts 1910 and 1915 concerning occupational safety and health standards and regulations, as well as any other applicable federal, state and local regulations on safe practices in coating operations.

***This product is for industrial use only. Not for residential use in California.***



PPG Protective &  
Marine Coatings

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