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Combo Coatings

“Combo” Coatings Use Two Different Paints to Achieve Better Overall Performance

- I. For graphite parts such as rotors or stators used with degassing units where moving molten metal requires toughness and abrasion-resistance, yet non-wetting is also desired.**

FIRST COATING: Coverguard (or MW-50 or SC-1400)
TOPCOATING: Boron Nitride Lubriccoat

Note: The coatings are compatible since both have pH-Acidic (like lemon juice) systems.

- II. For wheel casting & permanent-mold casting, this “combo” is regularly used in order to achieve the thermal-insulation undercoat but have the best non-wetting, release, and surface finishes.**

FIRST COATING: Standard thermally-insulating mold coating
TOPCOATING: Boron Nitride Releasecoat

Note: The coatings are compatible as BN-Releasecoat is pH-near-Neutral and OK with all pH paints.

- III. For metal parts such ladles where a hard undercoat is desired, yet the best non-wetting is also desired.**

FIRST COATING: Boron Nitride Hardcoat
TOPCOATING: Boron Nitride Lubriccoat-ZV

Note: The coatings are compatible since both have pH-Basic/Alkaline (like housepaints) systems.

- IV. For ceramic parts such as sintered-fused-silica where some surface sealing is desired along with non-wetting.**

FIRST COATING: Z-Guard
TOPCOATING: Boron Nitride Lubriccoat (regular version)

Notes: The coatings are compatible since both have pH-Acidic (like lemon juice) systems. The Z-Guard is thin and penetrating, but penetration/sealing can be improved with vacuum-assist if available.

- V. For used hot-top billet casting tables that have residual Bone Ash or Red Mud on them – to seal the dust in and protect from its interaction with BN coatings.**

FIRST COATING: Z-Primercoat (see BINDERS for details about Z-Primercoat)
TOPCOATING: Boron Nitride Lubriccoat (regular version)

Note: Z-Primercoat is “forgiving” and, even though it is pH-Basic, allows top-coating with either pH-Acidic (like regular BN Lubriccoat) or pH-Basic coatings. Z-Primercoat is just like house paint primers in this application.

OTHER NOTES: Thoroughly dry the first coating before applying the top-coating. Then make sure that the “combo” is thoroughly dry before use. DO NOT CONTACT WET COATINGS WITH MOLTEN METALS. Consult MSDS before use.