440 ZP Industrial Primer

Description

440 ZP Industrial Primer is a 2 Pack, Zinc Phosphate, Isocyanate Free, Polyamide cured inhibitive Epoxy primer. May be overcoated with a wide range of high-performance topcoats for the Commercial Transport and Light Industrial markets to give a durable corrosion resistant paint system.

Formulated for use on correctly prepared mild steel, galvanised steel, stainless steel, and aluminium substrates. Ideal for use in coastal, chemical, or marine environments where a higher level of corrosion protection is required. Also suitable for use on composites and fiberglass.
Works very well as a holding primer for up to 3 months if kept out of weather.

Products

Product Type:	Two Component Isocyanate Free Zinc Phosphate Epoxy 2K Primer
Colour:	Light Grey, Black, White
Pot Life:	8hr at 21˚C
Induction Time:	N/A
Recommended DFT:	50 – 75 microns DFT per coat.
Theoretical Coverage:	10m2/L at 50 microns DFT 7m2/L at 75 microns DFT

Properties

Volume Solids:	52%
Recoat-ability:	Can be recoated with 2K polyurethanes wet-on-wet (non-sand) after 2 hours at 21˚C, or after 1 hour at 45˚C. 440 ZP Industrial Primer can be topcoated up to 3 days without sanding, following a thorough degrease/wipe down. Can be left up to 3 months as a holding primer non exterior but will require to be well abraded and cleaned prior to topcoating. For best practice It is **highly** recommended that you test a small sample area first to ensure compatibility of your topcoat to achieve a desirable finish and satisfactory product performance. If 440 ZP Industrial Primer has been left for 5 days or more, it is advisable to test a small area for topcoat performance given the varying nature of many topcoats. If necessary, abrade before topcoating.

Substrates

440 ZP Industrial Primer can be applied over correctly prepared:

- Steel
- Galvanised Steel
- Stainless Steel
- Aluminium
- Sanded cured substrates
- Sanded cured 2K substrates
- Composites such as Carbon Fibre and GRP

Surface Preparation

Coating performance is in general, proportional to the degree of surface preparation. Surfaces to be painted must be clean, dry, and free from all traces of contamination, corrosion and must be well abraded.

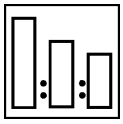
Heavy Steel:

On heavy steel with mill scale evident the substrate must be abrasive blasted with Garnett grade C to class 2.5 30-micron profile. The substrate should be clean white metal with no rust, mill scale, welding flux or any other surface contaminates. This exposed blasted surface should be kept in dry conditions and must not come into contact with any contaminates such as open or uncovered hands. The use of approved gloves is highly recommended. For best results this surface should have 440 ZP Industrial Primer applied as soon as practical or within the working day in a controlled environment such as a heated spray booth.

Aluminium & Galvanised Steel:

Degrease with Wax & Grease Remover or a quality solvent. Mechanically abrade with P150 to P180 disc. Surfaces to be painted must be clean, dry and free from all traces of contamination, corrosion and must be well abraded. Final clean with a quality degreaser or Methylated Spirits / Water mix and using approved gloves and lint free cloths. Air blow and tack clean ready for primer application.

Mix Ratios



Mixing By Volume:

Mix Ratio: 4:1:1

4 parts 440 ZP Industrial Primer to
1 Part 440 ZP Industrial Primer Hardener to
1 - 2 parts 440 ZP Industrial Thinner or Resene Slow #10 Thinner
(depending on high temperature or size of work)

Note: Substitute 50% BV of the reducer ratio with RALI electrostatic reducer at 4:1:1 BV, will achieve approx 20 Mega Ohm's for electrostatic application.

Dry Time @ 20°C: Touch Dry: 1 Hour / Handle: 4 Hours 20°C / can be force dried if needed. This is film build dependent and therefore a guide only.

Application Method:

Conventional spray, air assisted airless or airless, Electrostatic.

Points to Note:

1) Not designed to give extremely long-term protection without over coating with 2K topcoats however 440 ZP Industrial Primer can be used as a holding primer for up to 3 months providing total film builds are sufficient and kept inside or out of weather.

2) When spraying, use the correct primer gun set up as recommended by your equipment supplier to achieve a dry film thickness (DFT) 50 microns above the peaks of the blast profile.

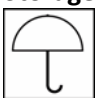
3) Application techniques should be adjusted as necessary to achieve the recommended dry film thickness. It is good practice to check this process on a small sample prior taking on a large project.

4) If you do not have a controlled environment to spray in, it is good practice NOT to continue if relative humidity is above 85% and in particular if temperatures are below 15°C or below 3 Deg C of Dew Point.

If using Electrostatic Reducer 440 ZP Industrial Primer can also be used through electrostatic spraying equipment however your equipment supplier would provide guidelines on appropriate resistant levels to achieve correct wrap.

Remember always filter strain products before using them

Spray Equipment: 	Conventional pressure feed and gravity feed guns. Tip Size: 1.4 - 1.8 mm Spray pressure: Pressure feed Pot or Pump 1 - 2 bar or 15 - 30 psi Gravity feed 1.8 - 2.5 bar or 25 - 35 psi Number of coats: 1 – 2 coats (10-15 minutes flash between coats) Air less / Air assisted airless & electrostatic: Follow equipment manufacturer's recommendations. ***Remarks: Do not use activated material beyond pot lifetime or by reducing it further to get the viscosity down again. This practice results in poor flow and adhesion failures.***
Health & Safety 	For detailed information refer to Safety Data Sheet (SDS). Inhalation of vapors or dust from sanding may cause respiratory sensitization. Splashes to eyes will cause irritation. Contact with skin may cause irritation. Applicators should use protective clothing and air feed respiratory equipment. Product is flammable, use and store away from heat and ignition sources

Transport & Storage 	**Sizes:**	4L & 8L
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	UN:	1263
	Hazchem:	3(Y)
	Packing Group:	III
	Shipment name:	PAINT Flammable Liquid Low Flash Point
	Flash point:	24°C