

# Nason<sup>®</sup> Industrial 2K ZP Epoxy Primer

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## Product Description

2K Zinc Phosphate polyamide cured epoxy primer.

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## Gloss

Flat

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## Product Features

- Wet on wet application
- Excellent over spray absorption
- Excellent surface filling properties
- Contains zinc phosphate
- High film build & sag resistance
- High chemical and abrasion resistance
- Excellent adhesion to prepared steel

## Product Benefits

- Reduced time to topcoat, high productivity
- High productivity for spraying large items
- Sandable to achieve a high quality finish
- Excellent corrosion resistance over steel
- Excellent coverage & run free finish
- Wide range of industrial environments
- Long term film integrity & protection

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## Product Uses / Applications

For use in coastal, chemical or marine environments, where a higher level of corrosion protection and/or chemical resistance is required (e.g. on mild steel; galvanised steel, stainless steel, aluminium) than is provided by conventional alkyd ZP primers. Also suitable for use on fiberglass.

- Commercial transport & components;
- Mobile mining, earth moving, construction & agricultural equipment and attachments;
- Structural steel – industrial and commercial;
- Industrial plant equipment and machinery;
- Pipeline & tank exteriors.

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## Not Recommended for

Immersion service;  
Application over QD Enamel and TPA Coatings.  
Application over etch primers.

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## Physical Data

Volume Solids:	54.4% (mixed)
VOC:	383 g/L (mixed)
Specific Gravity:	1.30 g/mL (mixed)
Dry Film Thickness:	50 - 70 µm per coat
Theoretical Coverage:	8.7 m <sup>2</sup> /L (at 50 µm DFT)
Flash Point:	-1.6°C



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## Dry Time

**Air Dry** at 20°C & 50% RH at recommended film thickness:

Wet-on-wet: 30 – 60 minutes (max. 5 days)

Dry to Handle: 4 - 8 hours      Hard Dry:      24 hours

**Bake:** 30 minutes @ 60°C after 20 minutes flash-off @ 20°C. Please see Table 1 for reducer selection.

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## Surface Preparation

### Previously painted surfaces:

Clean using an Axalta recommended wax and grease remover.

Lightly sand or scour with 3M Scotch Brite Pad grey, and subsequently re-clean all the areas before the application of 650-04 Nason® Industrial 2K ZP Epoxy Primer.

Test suitability of the existing coating before application of 650-04 Nason® Industrial 2K ZP Epoxy Primer.

### New work:

Cleaning:      Degrease using an approved wax and grease remover.

Sandblasting:      Class 2½, 40-50 µm profile (as per AS1627.4).



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## Application

Tintable up to 10% by weight with Nason Industrial ST tinters.

- Mixing Ratio:      4:1 with 750-82 Nason® Industrial 2K ZP Epoxy Primer Activator
- Conventional:      20 – 30% 861-62 Nason® Industrial Epoxy Reducer/AXT350 Multi Acrylic Thinner
- Airless:      10 – 20% 861-62 Nason® Industrial Epoxy Reducer/ AXT350 Multi Acrylic Thinner
- Pot Life:      6 hours @ 20°C

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## Gun Setup

- |                  |                |               |             |
|------------------|----------------|---------------|-------------|
| • Pressure Pot:  | 1.3 – 1.6 mm   | 1 - 2 bar     | 35 – 50 psi |
| • Conventional:  | 1.8 – 2.0 mm   | 3 – 4 bar     | 45 – 60 psi |
| • Airless Spray: | 0.33 – 0.36 mm | min. 2000 psi |             |
| • HVLP:          | 1.6 – 1.8 mm   | 0.7 bar       | 10 psi      |

Refer to spray equipment documentation for setting recommendations.

- Number of coats:      1 - 2
- Flash-off between coats:      10 - 15 minutes

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## Application Condition

Do not apply if material, substrate or ambient temperature is less than 10°C or above 45°C. The substrate must be at least 3°C above the dew point. Relative humidity should be below 90%.

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**Table 1 – Reducer Selection Guide**

**Reducer Selection Guide**

Ambient Temperature			10°C	15°C	20°C	25°C	30°C	35°C	40°C	
Nason® Industrial 2K ZP Epoxy Primer 650-04	Air Dry	AXT350	[Blue bar from 10°C to 30°C]							
		861-62							[Blue bar from 25°C to 40°C]	

**Cleanup Solvents**

Recommended gun cleaning thinner.

**Dry Film Characteristics\***

Maximum Service Temperature:	90°C (continuous service)
Exterior Exposure:	VERY GOOD
Water Resistance:	VERY GOOD
Chemical Resistance:	VERY GOOD
Abrasion Resistance:	VERY GOOD

**Overcoating**

With NI600, or NI610/620 2K PU with ST tint based topcoats. Can also be overcoated with NI610 Non APAS Camouflage Colours.

**Wet-on-wet:** 30 – 60 minutes (max. 5 days)

**With sanding:** (min. 8 hours @20C or overnight)

**Dry:** P320 – P400 (dry orbital sander with exhaust)

**Wet:** P600 – P800

Note: Light de-nibbing is possible after 4 – 6 hours

**Shelf Life**

24 months minimum in sealed original container.

Store at room temperature away from direct sunlight

**Availability**

Nason® Industrial 2K ZP Epoxy Primer off-white	16 L	650-04
Nason® Industrial 2K ZP Epoxy Primer off-white	3.5 L	650-04
Nason® Industrial 2K ZP Epoxy Primer Activator	4 L	750-82
Nason® Industrial 2K ZP Epoxy Primer Activator	1 L	750-82
Nason® Industrial Epoxy Reducer	20 L	861-62
Nason® Industrial Epoxy Reducer	4 L	861-62
AXT350 Multi Acrylic Thinner	20 L	AXT350
Nason® Industrial Std High OH 2K PU binder	10 L	ST100-610
Nason® Industrial Std High OH 2K PU binder	20 L	ST100-610
Nason® Industrial Std 2K PU binder	10 L	ST100-620
Nason® Industrial Std 2K PU binder	20 L	ST100-620

This product is intended for use by professional trade and industrial applicators in compliance with relevant Health, Safety & Environmental standards and legislation.

The applicator must use suitable Personal Protective Equipment (PPE), in particular full body coverall, gloves, goggles and air respirator, provide adequate ventilation when using in confined spaces

For more detailed information, refer to Material Safety Data Sheets of the products used.

This Technical Data Sheet is issued by Axalta Coatings Systems as a guidance only. The information contained herein is current and correct to the best of our knowledge at the time of issuance.

The user must ensure suitability of the product and its performance for the application at hand. Axalta Coating Systems assumes no responsibility nor provides any warranty.