LUXAPRIME® Zinc Phosphate

High Build Anticorrosive Primer-Finish **PC 612**

FEATURES

- CONTAINS HIGH LEVELS OF ZINC PHOSPHATE
- NON-TOXIC ANTICORROSIVE PIGMENTATION
- CONTAINS MICACEOUS IRON OXIDE
- SUITABLE AS A PRIMER OVER POORLY PREPARED SURFACES
- SELF PRIMING TOPCOAT
- AVAILABLE IN ATTRACTIVE ENVIRONMENTAL COLOURS

USES

LUXAPRIME® Zinc Phosphate is a single pack, high build anticorrosive primer which contains zinc phosphate and micaceous iron oxide pigments. The primer is highly resistant to moisture and gives superior performance over power or hand tool cleaned surfaces compared to conventional ROZP primers. The high build nature of the product allows up to 75 microns DFT in one coat.
LUXAPRIME® Zinc Phosphate is recommended as a primer or primer finish over steel, especially in circumstances where surface preparation is limited to power or hand tool clean standards. Abrasive blast cleaning is always recommended where it can be justified on economic or practical grounds.
LUXAPRIME® Zinc Phosphate is typically used on bridges, cranes, towers, tanks and roofs and especially as a primer-finish in environmental colours on general structural steelwork such as warehouses and factories.

SPECIFICATIONS AS 3750.19 Type 2

RESISTANCE GUIDE

HEAT RESISTANCE	Up to 120°C dry heat.
WEATHERABILITY	On exterior exposure some chalking may also occur. This will not detract from the protective properties of the coating. Use a weatherable topcoat if required for appearance.
SOLVENTS	Withstands intermittent splash and spillage of aliphatic and aromatic hydrocarbons.
ACIDS	Not recommended where fumes, splash or spillage may occur.
ALKALIS	Not recommended where fumes, splash or spillage may occur.
SALTS	Excellent resistance to splash and spillage of neutral salt solutions.
WATER	Resists rain and condensation. Not recommended for permanently damp or immersed exposure.
ABRASION	Good when fully cured.

TYPICAL PROPERTIES AND APPLICATION DATA

CLASSIFICATION	Anticorrosive primer-finish
FINISH	Metallic lustre
COLOUR	Light Grey, Blue and Standard Red (MTO)
COMPONENTS	One
SOLIDS BY VOLUME	45% (Light Grey)
VOC LEVEL	<440 g/L (Light Grey)
FLASH POINT	5°C
POT LIFE	Not applicable
MIXING RATIO (V/V)	Single Pack

THINNER	**Brush**		Mineral Turpentine
	Spray	965-63034	DUTHIN® 340 Spray Thinner
PRODUCT CODE		866-63112	Light Grey
		866-63065	Blue
		866-63303	Standard Red (MTO)

APPLICATION CONDITIONS	Min	Max
Air Temperature	10°C	45°C
Substrate Surface Temperature	10°C	45°C
Relative Humidity		85%

	Min	Max	Recom.
Wet film per coat (microns)	110	175	165
Dry film per coat (microns)	50	80	75

SUITABLE SUBSTRATES Abrasive blast cleaned, hand cleaned or power tool cleaned steel.

APPLICATION METHODS Brush, roller, conventional, airless spray or air assisted spray.

Drying characteristics at 75 microns dry film thickness

Temperature	Humidity	Touch	Handle	Full Cure	Overcoat Min	Overcoat Max
10° C	50%	1 Hour	8 Hours*	7 Days	24 Hours	Indefinite
15° C	50%	45 Minutes	5 Hours*	7 Days	24 Hours	Indefinite
25° C	50%	30 minutes	2 Hours*	7 Days	24 Hours	Indefinite

These figures are given as a guide only, as ventilation, film thickness, humidity, thinning and other factors will influence the rate of drying.
The surface can be marked for several days after application.

TYPICAL SPREADING RATE AT RECOMMENDED DRY FILM BUILD

A spreading rate of 6.0 sq. metres per litre corresponds to 75 microns dry film thickness assuming no losses.
Practical spreading rates will vary depending on such factors as method and conditions of application and surface roughness.

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TYPICAL SYSTEMS

(The typical systems are offered as a guide only and are not to be used as a specification. It is recommended that the specific needs of a project be discussed with a Dulux Protective Coatings Consultant.)

SURFACE	PREPARATION GUIDE	SYSTEM		DRY FILM THICKNESS
STEEL	Hand or Power tool clean AS1627.2 St 3 Abrasive blast AS1627.4 Class 1		Exterior or damp conditions	
		1st Coat	LUXAPRIME® Zinc Phosphate	75 Microns
		2nd Coat	LUXAPRIME® Zinc Phosphate	75 Microns
			Interior, cosmetic or mild inland	
		1st Coat	LUXAPRIME® Zinc Phosphate	75 Microns
			Exterior, mild industrial	
		1st Coat	LUXAPRIME® Zinc Phosphate	75 Microns
		2nd Coat	WEATHERSHIELD®	25 Microns

SURFACE PREPARATION

Round off all rough welds, sharp edges and remove weld spatter. Remove grease, oil and other contaminants in accordance with AS1627.1. Rust, millscale, oxide deposits and old paint films on metal surfaces should be removed by hand or power tool (AS1627.2 St 3) cleaning as a minimum. Coating performance is proportional to the degree of surface preparation and abrasive blast cleaning to a minimum AS1627.4 Class 2 is preferred for more severe environments. Remove all dust by brushing or vacuum cleaning.

APPLICATION

Stir each can thoroughly until the contents are uniform. Use of a power mixer is recommended. Remix thoroughly before using and continue mixing during application.

BRUSH/ROLLER

Apply a full coat without thinning. When brushing and rolling additional coats may be required to attain the specified thickness. In hot weather a small amount of mineral turpentine will ease application.

CONVENTIONAL SPRAY

Thin up to 100ml/litre with DUTHIN® 340 Spray Thinner (965-63034) to aid atomisation. Apply in multiple wet coats overlapping each pass 50%.

Typical Set-up

Graco Delta Gun:	1.8mm (239543)
Pressure at Pot:	70-100 kPa (10-15 p.s.i.)
Pressure at Gun:	410-480 kPa (60-70 p.s.i.)

AIRLESS SPRAY

Standard airless spray equipment such as a Graco 33:1 Bulldog with a fluid tip of 19-21 thou (0.48-0.53mm) and an air supply capable of delivering 550-690 kPa (80-100 p.s.i.) at the pump. Thinning is not normally required but up to 50 ml/litre of DUTHIN® 340 Spray Thinner (965-63034) may be added to ease application.

PRECAUTIONS

This is an industrial product designed for use by experienced Protective Coating applicators. Where conditions may require variation from the recommendations on this Product Data Sheet contact your nearest Dulux® representative for advice prior to painting. Do not apply in conditions outside the parameters stated in this document without the express written consent of Dulux Australia. Do not apply at temperatures below 10°C. Do not apply at relative humidity above 85% or when the surface is less than 3°C above the dewpoint. Do not overcoat before the minimum overcoat interval or wrinkling may occur. The surface can be marked for several days after application. Abrasive blast cleaned surfaces must be primed within 4 hours. When overcoating with approved two pack finishes or with finishes containing aggressive solvents, a drying period of at least 72 hours at 25°C is recommended. If unsure of the result lightly sand and test a small area before completing the major work.

CLEAN UP

Clean all equipment with DUTHIN® 340 Spray Thinner (965-63034) or mineral turpentine immediately after use.

OVERCOATING

Aged coating should be tested for lifting by a method appropriate for the coating thickness, for example 'X' cut or cross-hatch methods. If it lifts, remove it. The surface must be free of oil, grease and other contaminants. High-pressure water wash at 8.3 to 10.3 MPa (1,200 – 1,500 p.s.i.) to remove loosely adhering chalk and dust. Abrasion may be required depending on surface condition.

SAFETY PRECAUTIONS — **Read Data Sheet, Safety Data Sheet and any precautionary labels on containers.**

STORAGE
Store as required for a flammable liquid Class 3 in a bunded area under cover. Store in well-ventilated area away from sources of heat or ignition. Keep containers closed at all times.

HANDLING
As with any chemical, ingestion, inhalation and prolonged or repeated skin contact should be avoided by good occupational work practice. Eye protection approved to AS1337 should be worn where there is a risk of splashes entering the eyes. Always wash hands before smoking, eating, drinking or using the toilet.

USING
Use with good ventilation and avoid inhalation of spray mists and fumes. If risk of inhalation of spray mists exists, wear combined organic vapour/particulate respirator. When spray painting, users should comply with the provisions of the respective State Spray Painting Regulations.

FLAMMABILITY
This product is flammable. All sources of ignition must be eliminated in, or near the working area. DO NOT SMOKE. Fight fire with foam, CO_2 or dry chemical powder. On burning will emit toxic fumes.

WELDING
Avoid inhalation of fumes if welding surfaces coated with this paint. Grind off coating before welding.

SAFETY DATA SHEET is available from Dulux Customer Service (Australia 132 377 or New Zealand 0800 800 424)
www.duluxprotectivecoatings.com.au

Dulux Protective Coatings a division of

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PACKAGING	Available in 4 litre and 15 litre containers
TRANSPORTATION WEIGHT	1.45 kg/litre (Standard Red)
DANGEROUS GOODS	Class 3 UN 1263

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