

DUREPON[®] P14

Two pack Epoxy Zinc Phosphate Primer

PC 206

- FEATURES**
- NON TOXIC ANTI-CORROSIVE PIGMENTATION
 - EXCELLENT CHEMICAL AND SOLVENT RESISTANCE
 - STANDARD INHIBITIVE EPOXY PRIMER FOR STEEL AND OTHER PREPARED SURFACES
 - INDEFINITELY RECOATABLE

USES DUREPON[®] P14 is recommended as the standard heavy-duty primer for suitably prepared surfaces in sugar and paper mills and food & beverage plants including abattoirs, breweries and canneries. It also has a history of successful use as a primer in the chemical and petroleum industries and in marine applications.
DUREPON[®] P14 is normally overcoated with epoxy, polyurethane or acrylic finishes depending upon end requirements.

SPECIFICATIONS Conforms to Alcoa[®] P14 Specifications
AS/NZS 3750.13 Type 2

RESISTANCE GUIDE

HEAT RESISTANCE	Up to 120°C dry heat.	ALKALIS	Excellent resistance to splash and spillage of most common alkalis.
WEATHERABILITY	Epoxy coatings may yellow with time. 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.	SALTS	Unaffected by splash and spillage of neutral and alkaline salt solutions.
SOLVENTS	Resists splash and spillage of most hydrocarbon solvents, refined petroleum products and most common alcohols.	WATER	Suitable for immersion in fresh and salt water when suitably topcoated.
ACIDS	Suitable for splash and spillage exposure to weak acids.	ABRASION	Good when fully cured.

TYPICAL PROPERTIES AND APPLICATION DATA

CLASSIFICATION	Epoxy zinc phosphate primer	
FINISH	Low Sheen	
COLOUR	Grey (Approximate match to AS2700 N12 Pastel Grey), Red Oxide & Lemon.	
COMPONENTS	Two	
SOLIDS BY VOLUME	REFER TO PAGE 2	
VOC LEVEL	REFER TO PAGE 2	
FLASH POINT	4°C (mixed)	
POT LIFE	REFER TO PAGE 2	
MIXING RATIO (V/V)	Part A : 4	Part B : 1
THINNER	920-08925	Dulux [®] Epoxy Thinner
PRODUCT CODE	410-51268	Grey
	410-33226	Red Oxide
	410-89052	Lemon
	980-50259	Standard Hardener
	980-83324	Fast Cure Hardener

APPLICATION CONDITIONS

REFER TO PAGE 2			
	Min	Max	Recom.
Wet film per coat (microns)	REFER TO PAGE 2		
Dry film per coat (microns)	REFER TO PAGE 2		
SUITABLE SUBSTRATES	Abrasives blast cleaned steel.		
TOPCOATS	Single and two pack products		
APPLICATION METHODS	Brush, roller, conventional, airless spray or air assisted airless spray.		

DUREPON® P14

Standard Hardener						
COATING THICKNESS			APPLICATION CONDITIONS			
	Min	Max	Recom.		Min	Max
Wet film per coat (microns)	95	170	140	Air Temperature	10°C	45°C
Dry film per coat (microns)	50	90	75	Substrate Surface Temperature	10°C	45°C
				Relative Humidity		85%
SOLIDS BY VOLUME	53%			POT LIFE	8 Hours (4L, 25°C)	
VOC LEVEL	<400 g/L					
Drying characteristics at 75 microns dry film thickness						
Temperature	Humidity	Touch	Handle	Full Cure	Overcoat Min	Max
10° C	50%	3 Hours	23 Hours	7 Days	23 Hours	Indefinite
15° C	50%	2 Hours	13 Hours	7 Days	13 Hours	Indefinite
25° C	50%	1.5 Hours	8 Hours	7 Days	8 Hours	Indefinite
TYPICAL SPREADING RATE AT RECOMMENDED DRY FILM BUILD				A spreading rate of 7.0 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.		

Fast Cure Hardener						
COATING THICKNESS			APPLICATION CONDITIONS			
	Min	Max	Recom.		Min	Max
Wet film per coat (microns)	110	200	165	Air Temperature	10°C	45°C
Dry film per coat (microns)	50	90	75	Substrate Surface Temperature	10°C	45°C
				Relative Humidity		85%
SOLIDS BY VOLUME	46%			POT LIFE	8 Hours (4L, 25°C)	
VOC LEVEL	<470 g/L					
Drying characteristics at 75 microns dry film thickness						
Temperature	Humidity	Touch	Handle	Full Cure	Overcoat Min	Max
10° C	50%	2 Hours	6 Hours	7 Days	6 Hours	Indefinite
15° C	50%	1.5 Hours	4 Hours	7 Days	3 Hours	Indefinite
25° C	50%	1 Hours	3 Hours	7 Days	2 Hours	Indefinite
TYPICAL SPREADING RATE AT RECOMMENDED DRY FILM BUILD				A spreading rate of 6.1 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.		

These figures are given as a guide only, as ventilation, film thickness, humidity, thinning and other factors will influence the rate of drying.

Use of fast or low temperature hardeners may result in a reduction of gloss level.

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	Abrasive blast AS1627.4 Class 2.5	1st Coat	DUREPON® P14	75 Microns
		2nd Coat	LUXATHANE® R	50 Microns
		3rd Coat	LUXATHANE® R (Optional)	50 Microns
		1st Coat	DUREPON® P14	75 Microns
		2nd Coat	DUREMAX® GPE	125 Microns
		3rd Coat	LUXATHANE® R	50 Microns
		1st Coat	DUREPON® P14	75 Microns
		2nd Coat	WEATHERMAX™ HBR	100 Microns
		1st Coat	DUREPON® P14	75 Microns
		2nd Coat	FERREKO® No. 3	100 Microns
		3rd Coat	FERREKO® No. 3 (Optional)	100 Microns

DUREPON® P14

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 abrasive blast cleaning to a minimum of AS1627.4 Class 2.5. Immersed steel must be prepared to AS1627.4 Class 3. 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. Mix the contents of both packs together thoroughly using a power mixer and allow to stand for 10 minutes. Remix thoroughly before using.
BRUSH/ROLLER	Apply even coats of the mixed material to the prepared surface. Thin if necessary with up to 60 ml/litre with Dulux® Epoxy Thinner to ease application. When brushing and rolling additional coats may be required to attain the specified thickness.
CONVENTIONAL SPRAY	Thin up to 125ml/litre with Dulux® Epoxy Thinner (920-08925) to aid atomisation. <u>Typical Set-up</u> Graco Delta Gun: 1.8mm (239543) Pressure at Pot: 70-100 kPa (10-15 p.s.i.) Pressure at Gun: 380-410 kPa (55-60 p.s.i.)
AIRLESS SPRAY	Standard airless spray equipment such as a Graco President 30:1 ratio with a fluid tip of 15 thou (0.38mm) 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 Dulux® Epoxy Thinner (920-08925) 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. Freshly mixed material must not be added to material, which has been mixed for some time. 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. Use of fast or low temperature hardeners may result in a reduction of gloss level.
CLEAN UP	Clean all equipment with Dulux® Epoxy Thinner (920-08925) 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, Material 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.

MATERIAL SAFETY DATA SHEET is available from Customer Service (132377) or www.duluxprotectivecoatings.com.au

Dulux Protective Coatings a division of DuluxGroup (Australia) Pty Ltd
1956 Dandenong Road, Clayton 3168
A.B.N. 67 000 049 427
Dulux, Durepon, Luxathane, Duremax, Weathermax and FERREKO are registered trademarks. DuluxGroup is a trademark.
ALCOA is a registered trademark of ALCOA INC.

PACKAGING	Available in 4 litre and 20 litre packs
TRANSPORTATION WEIGHT	1.63 kg/litre (Average of components)
DANGEROUS GOODS	Part A: Class 3 UN 1263 Part B: Class 3 UN 1263

Any advice, recommendation, information, assistance or service provided by DULUX Australia in relation to goods manufactured by it or their use and application is given in good faith and is believed by Dulux to be appropriate and reliable. However, any advice, recommendation, information, assistance or service provided by Dulux is provided without liability or responsibility PROVIDED THAT the foregoing shall not exclude, limit, restrict or modify the right entitlements and remedies conferred upon any person or the liabilities imposed upon Dulux by any condition or warranty implied by Commonwealth, State or Territory Act or ordinance void or prohibiting such exclusion limitation or modification. Products can be expected to perform as indicated in this sheet so long as applications and application procedures are as recommended. Specific advice should be sought from Dulux for application in coastal areas and for large projects to ensure proper performance.