

METALSHIELD[®] HIGH BUILD ZP Primer

Fast Drying High Build Zinc Phosphate Primer

LI 004

- FEATURES**
- FAST DRY PRIMER
 - CONTAINS ZINC PHOSPHATE
 - HIGH BUILD SHOP PRIMER
 - SINGLE PACK PRODUCT
 - TOUCHUP SPRAYPAKS AVAILABLE

USES METALSHIELD[®] HIGH BUILD ZP PRIMER is an anti-corrosive shop or field primer used for the protection of steel in mild industrial and commercial environments and is ideal where fast turn around time is required. It offers greater protection than standard shop primers due to its high build characteristics.

SPECIFICATIONS AS/NZS 3750.19 Type 1

RESISTANCE GUIDE

HEAT RESISTANCE	Up to 95°C dry heat.	ACIDS	Not recommended where fumes, splash or spillage may occur.
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.	ALKALIS	Not recommended where fumes, splash or spillage may occur.
SOLVENTS	Resists alcohol, mineral turpentine and similar solvents. Esters, ketones, ethers, chlorinated solvents or similar strong solvents are liable to attack the coating.	SALTS	Unaffected by splash and spillage of neutral salt solutions.
		WATER	Resists rain and condensation. Not recommended for permanently damp or immersed exposure.
		ABRASION	Moderate when fully cured.

TYPICAL PROPERTIES AND APPLICATION DATA

CLASSIFICATION	High build zinc phosphate primer		APPLICATION CONDITIONS	Min	Max	
FINISH	Low Sheen		Air Temperature	10°C	45°C	
COLOUR	Grey, Red Oxide, Blue and Dark Grey (MTO). Touchup spraypaks also available.		Substrate Surface Temperature	10°C	45°C	
COMPONENTS	One		Relative Humidity		85%	
SOLIDS BY VOLUME	41% (Red Oxide)			Min	Max	Recom.
VOC LEVEL	<510 g/L (Red Oxide)		Wet film per coat (microns)	100	185	120
FLASH POINT	4°C		Dry film per coat (microns)	40	75	50
POT LIFE	Not applicable		SUITABLE SUBSTRATES	Abrasive blast cleaned, hand cleaned or power tool cleaned steel.		
MIXING RATIO (V/V)	Single pack		TOPCOATS	Chlorinated rubber, acrylic latex and alkyd based topcoats.		
THINNER	Brush	965-H0010	Metalshield [®] Brush Thinner			
	Spray	965-H0009	Metalshield [®] Spray Thinner			
PRODUCT CODE		366-87297	Red Oxide			
		366-87299	Blue			
		366-87300	Grey			
		366-89824	Dark Grey (MTO)			
			APPLICATION METHODS	Conventional, airless spray or air assisted spray.		

Drying characteristics at 50 microns dry film thickness

Temperature	Humidity	Touch	Handle	Full Cure	Overcoat	
					Min*	Max
25°C	50%	15 Minutes	2 Hours	7 Days	12 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.

Overcoating can occur up to 2 hours after the initial application or after 12 hours. Failing to observe these limits may result in "frying". If in doubt test a small inconspicuous area first. Allow longer times under cold conditions.

TYPICAL SPREADING RATE AT RECOMMENDED DRY FILM BUILD

A spreading rate of 8.2 sq. metres per litre corresponds to 50 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.

METALSHIELD® HIGH BUILD ZP PRIMER

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 Mild environments	<u>Interior use</u> Hand or Power tool clean AS1627.2 St 3 Abrasive blast AS1627.4 Class 1	1st Coat	METALSHIELD® HIGH BUILD ZP Primer	50 Microns
		1st Coat	METALSHIELD® HIGH BUILD ZP Primer	50 Microns
		2nd Coat	METALSHIELD® QD Enamel Topcoat	40 Microns
	<u>Exterior use</u> Abrasive blast AS1627.4 Class 2	1st Coat	METALSHIELD® HIGH BUILD ZP Primer	50 Microns
		2nd Coat	FERRODOR® 810	50 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 external 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.

BRUSH/ROLLER Suitable for small areas only. Apply even coats of the material to the prepared surface. When brushing and rolling additional coats may be required to attain the specified thickness. Thin if required with METALSHIELD® Brush Thinner (965-H0010).

CONVENTIONAL SPRAY Thin up to 60 ml/litre with METALSHIELD® Spray Thinner (965-H0009) 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: 380-410 kPa (55-60 p.s.i.)

AIRLESS SPRAY Standard airless spray equipment such as a Graco 33:1 Bulldog with a fluid tip of 13-15 thou (0.33-0.38mm) 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 METALSHIELD® Spray Thinner (965-H0009) may be added to ease application. METALSHIELD® Brush Thinner (965-H0010) may be used in hot weather.

TOUCHUP SPRAYPAKS For all application instructions and properties of the Touchup Spraypaks refer to the details located on the back of the aerosol can. Note – a slight colour variation maybe experienced compared to the standard product due to film build, application methods and technique.

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 dew point. Overcoating can occur up to 2 hours after the initial application or after 12 hours. Failing to observe these limits may result in "frying" or wrinkling. If in doubt test a small inconspicuous area first. Allow longer times under cold conditions. Do not apply over scale bearing steel for exterior use. Abrasive blast cleaned surfaces must be primed within 4 hours. This product is not suitable to be topcoated by two pack heavy-duty coatings or directly applied over galvanised iron.

CLEAN UP Clean all equipment with METALSHIELD® Spray Thinner (965-H0009) or METALSHIELD® Brush Thinner (965-H0010) 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. Apply a further coat of METALSHIELD® HIGH BUILD ZP Primer, METALSHIELD® PREMIUM UV Resistant Enamel Topcoat or METALSHIELD® QD ENAMEL Topcoat.

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, CO₂ 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 (Phone Australia 132 377 or New Zealand 0800 800 424)

www.duluxprotectivecoatings.com.au

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PACKAGING	Available in 1, 4 and 15 litre containers. Available in 300g Aerosols
TRANSPORTATION WEIGHT	1.25 kg/litre (Red Oxide)
DANGEROUS GOODS	Class 3 UN 1263 (Aerosols Class 2 UN 1950)

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.