CONGARD®
Single Pack Alkyd Primer-Finish

FEATURES
- SELF PRIMING TOPCOAT
- GLOSS FINISH
- CONTAINS ZINC PHOSPHATE
- RAPID DRYING
- TINTABLE – AVAILABLE IN OVER 5,000 COLOURS

USES
CONGARD® is a single pack, air drying, high build coating based on a modified alkyd resin. The incorporation of rust inhibitive zinc phosphate pigment enables direct application to blast or chemically cleaned steel, providing both corrosion protection and a decorative finish in the one product.

CONGARD® is ideal as a fast, economical primer finish in sheltered or mild environments or for simple refurbishing after repair. Typical areas of application include structural frames and trusses for factories and warehouses, farm or heavy engineering equipment and shipping containers.

CONGARD® is tintable to almost any colour in the Dulux® and AS2700 colour ranges.

SPECIFICATIONS

RESISTANCE GUIDE

WEATHERABILITY
Will chalk on exterior exposure. Neither yellowing nor chalking detracts from the protective properties of the coating.

SOLVENTS
Resists alcohol, mineral turpentine and similar solvents. Esters, ketones, ethers, chlorinated solvents or similar strong solvents are liable to attack the coating.

HEAT RESISTANCE
Up to 65°C dry heat

WATER
Resists rain and condensation. Not suitable for permanently damp or immersed exposure.

SALTS
Unaffected by splash and spillage of neutral salt solutions

ALKALIS
Not recommended where fumes, splash or spillage may occur.

ACIDS
Not recommended where fumes, splash or spillage may occur

ABRASION
Good when fully cured

TYPICAL PROPERTIES AND APPLICATION DATA

CLASSIFICATION
Modified alkyd primer-finish

FINISH
Gloss

COLOUR
White, Golden Yellow and a full range of tinted colours and MTO factory made colours.

APPLICATION CONDITIONS
Air Temp. 10°C - 45°C
Substrate Temp. 10°C - 45°C
Relative Humidity 85%

COATING THICKNESS (MICRONS)
Wet film per coat (μm) 160 - 240 - 200
Dry film per coat (μm) 60 - 90 - 75

COMPONENTS
One

VOLUME SOLIDS
38% (White)

VOC LEVEL
<540 g/L (White, untinted)

FLASH POINT
4°C

POT LIFE
Not applicable

MIXING RATIO V/V
Single pack

THINNER – BRUSH
965-63020 Dulux® CR Reducer

PRODUCT CODE
878-63001 White/Light Base
878-63002 Deep Base
878-63003 Clear Base
878-39141 Golden Yellow

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

PRIMERS
Not required

APPLICATION METHODS
Conventional, airless spray or air assisted spray

DRYING CHARACTERISTICS AT 75 μm DRY FILM THICKNESS*

<table>
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<tr>
<th>Temperature</th>
<th>Humidity</th>
<th>Touch</th>
<th>Handle</th>
<th>Full Cure</th>
<th>Min¹</th>
<th>Max¹</th>
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<tr>
<td>25°C</td>
<td>50%</td>
<td>15 Minutes</td>
<td>2 Hours</td>
<td>7 Days</td>
<td>4 Hours</td>
<td>8 Hours</td>
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</table>

¹ Overcoating can occur 4 hours after the initial application or before 8 hours. Failing to observe these limits may result in “frying” or wrinkling. If in doubt, test a small inconspicuous area first.

SPREADING RATE
5.0 square metres per litre equals 75 μm dry film thickness

NOTE: Practical spreading rates will vary depending on such factors as application method, ambient conditions, surface porosity and roughness.
CONGARD®

TYPICAL SYSTEMS

This is a guide only and not to be used as a specification. Your specific project needs must be discussed with a Dulux Protective Coatings Consultant.

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<th>SURFACE</th>
<th>ENVIRONMENT</th>
<th>PREPARATION GUIDE</th>
<th>SYSTEM</th>
<th>DFT (μm)</th>
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<tbody>
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<td>STEEL</td>
<td>Mild corrosivity (AS2312.1 Cat C1-2)</td>
<td>Power tool clean AS1627.2 St 3 or Abrasive blast AS1627.4 Class 2</td>
<td>1st Coat</td>
<td>Congard®</td>
</tr>
<tr>
<td></td>
<td></td>
<td></td>
<td>2nd Coat</td>
<td>Congard®</td>
</tr>
<tr>
<td>STEEL</td>
<td>Mild corrosivity (AS2312.1 Cat C1)</td>
<td>Power tool clean AS1627.2 St 3 or Abrasive blast AS1627.4 Class 2</td>
<td>1st Coat</td>
<td>Congard®</td>
</tr>
</tbody>
</table>

NOTE: If application is by brush or roller, additional coats will be necessary to achieve the minimum DFT and full opacity.

SURFACE PREPARATION

Steel: Round off all rough welds, sharp edges and remove weld spatter. Remove grease, oil and other contaminants in accordance with AS1627.1. Degrease with Gamlen CA No. 1 (a free-rinsing, alkaline detergent) according to the manufacturer’s written instructions and all safety warnings. Abrasive blast clean to a minimum of AS1627.4 Class 2.5.

Steel where abrasive blast cleaning is not viable: Rust, mill scale, oxide deposits and old paint films on metal surfaces must be removed by power tool cleaning (AS1627.2 St 3). Coating performance is proportional to the degree of surface preparation. Remove all dust by brushing or vacuum cleaning.

APPLICATION

Mix can thoroughly with power tool until the contents are uniform. Ensure product has been tinted to the correct colour before use. DULUX® ASSUMES NO RESPONSIBILITY FOR THE APPLICATION OF INCORRECT COLOUR. Box all containers before use to ensure colour consistency. Remix before application.

BRUSH/ROLLER

Recommended only for spot patching on rivets, seams, etc. When brushing and rolling additional coats may be required to attain the specified thickness.

CONVENTIONAL SPRAY

Thin up to 50ml/litre with Dulux® CR Reducer (965-63020) to aid atomisation. Add only enough thinner to achieve atomisation. Apply in multiple wet coats overlapping each pass 50%.

AIRLESS SPRAY

Standard airless spray equipment such as a Graco Xtreme 30:1 with a fluid tip of 15-17 thou (0.38-0.43 mm) 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® CR Reducer (965-63020) 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® Consultant 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. Allow longer dry times under cold conditions. Overcoating can occur 4 hours after the initial application or before 8 hours. Failure to observe these limits may result in “frying” or wrinkling. If in doubt test a small inconspicuous area first. Check a small area before commencing recoat work. Do not apply over scale bearing steel. Do not apply on structures subject to sustained surface temperatures above 65°C or where spillage of strong solvent or oils may occur. Do not exceed a spreading rate of 5.0 sq. meters per litre. Abrasive blast cleaned surfaces must be primed within 4 hours. This product must not be topcoated with two pack heavy-duty coatings. Do not apply directly on galvanized iron or zinc rich coatings.

CLEAN UP

Clean all equipment with Dulux® CR Reducer (965-63020) immediately after use.

OVERCOATING

Degrease with Gamlen CA 1 according to the data sheet. Test adhesion of existing coating by standard cross hatch adherence test. If the coating fails, remove it. High-pressure water wash at 8.3 to 10.3 MPa (1,200-1,500 p.s.i.) to remove chalk and dust. Abrade surface to provide a good key for the new coating.

SAFETY PRECAUTIONS

Read Data Sheet, SAFETY DATA SHEET and any other precautions on container labels. SAFETY DATA SHEET is available from Customer Service (13 23 77) or www.duluxprotectivecoatings.com.au

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 co.

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.

COMPANY INFORMATION

Dulux Protective Coatings a division of DuluxGroup (Australia) Pty Ltd

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