DUREPON® P14
Two Pack Epoxy Zinc Phosphate Primer

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

USES
DUREPON® P14 is a two pack epoxy primer enhanced with zinc phosphate pigment for inhibitive corrosion protection on mild steel. It is suitable as a primer for steelwork in sugar and paper mills and food & beverage plants including abattoirs, breweries and canneries. DUREPON® P14 also has a long and successful history as a primer in the chemical and petroleum industries.

DUREPON® P14 can be overcoated with epoxy, polyurethane or acrylic finishes depending upon service requirements.

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

RESISTANCE GUIDE

SOLVENTS
- Resists splash and spillage of most hydrocarbon solvents, refined petroleum products and most common alcohols

WATER
- Excellent resistance to fresh and salt water

ALKALIS
- Excellent resistance to splash and spillage of most common alkalies

ABRASION
- Good when fully cured

TYPICAL PROPERTIES AND APPLICATION DATA (STANDARD HARDENER)

CLASSIFICATION
Epoxy zinc phosphate primer

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

COATING THICKNESS (MICRONS)

Min Max Recommended
- Wet film per coat (μm) 95 170 140
- Dry film per coat (μm) 50 90 75

SUITABLE SUBSTRATES
- Abrasive blast cleaned steel

PRIMERS
- Not applicable

TOPCOATS
- Dulux® single and two pack products

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

DRYING CHARACTERISTICS AT 75 μm DRY FILM THICKNESS* (STANDARD HARDENER)

<table>
<thead>
<tr>
<th>Temperature</th>
<th>Humidity</th>
<th>Touch</th>
<th>Handle</th>
<th>Full Cure</th>
<th>Min</th>
<th>Max</th>
</tr>
</thead>
<tbody>
<tr>
<td>10°C</td>
<td>50%</td>
<td>3 Hours</td>
<td>23 Hours</td>
<td>7 Days</td>
<td>23 Hours</td>
<td>4 Weeks</td>
</tr>
<tr>
<td>15°C</td>
<td>50%</td>
<td>2 Hours</td>
<td>13 Hours</td>
<td>7 Days</td>
<td>13 Hours</td>
<td>4 Weeks</td>
</tr>
<tr>
<td>25°C</td>
<td>50%</td>
<td>EASY</td>
<td>8 Hours</td>
<td>7 Days</td>
<td>8 Hours</td>
<td>4 Weeks</td>
</tr>
</tbody>
</table>

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

1 For best results, abrade surface before painting to ensure maximum intercoat adhesion.

SPREADING RATE
7.0 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.
DUREPON® P14

FAST CURE HARDENER

COATING THICKNESS (MICRONS)

<table>
<thead>
<tr>
<th></th>
<th>Min</th>
<th>Max</th>
<th>Recommended</th>
</tr>
</thead>
<tbody>
<tr>
<td>Wet film per coat (μm)</td>
<td>110</td>
<td>200</td>
<td>165</td>
</tr>
<tr>
<td>Dry film per coat (μm)</td>
<td>50</td>
<td>90</td>
<td>75</td>
</tr>
</tbody>
</table>

APPLICATION CONDITIONS

<table>
<thead>
<tr>
<th></th>
<th>Min</th>
<th>Max</th>
</tr>
</thead>
<tbody>
<tr>
<td>Air Temperature</td>
<td>10°C</td>
<td>45°C</td>
</tr>
<tr>
<td>Substrate Surface Temperature</td>
<td>10°C</td>
<td>45°C</td>
</tr>
<tr>
<td>Relative Humidity</td>
<td>85%</td>
<td></td>
</tr>
</tbody>
</table>

SOLIDS BY VOLUME

<table>
<thead>
<tr>
<th>VOC LEVEL</th>
<th>&lt;470 g/L</th>
</tr>
</thead>
<tbody>
<tr>
<td>POT LIFE</td>
<td>8 hours (4 litre kit, 25°C)</td>
</tr>
</tbody>
</table>

DRYING CHARACTERISTICS AT 75 μm DRY FILM THICKNESS* (FAST CURE HARDENER)

<table>
<thead>
<tr>
<th>Temperature</th>
<th>Humidity</th>
<th>Touch</th>
<th>Handle</th>
<th>Full Cure</th>
<th>Min</th>
<th>Max</th>
</tr>
</thead>
<tbody>
<tr>
<td>10°C</td>
<td>50%</td>
<td>2 Hours</td>
<td>6 Hours</td>
<td>7 Days</td>
<td>6 Hours</td>
<td>4 Weeks</td>
</tr>
<tr>
<td>15°C</td>
<td>50%</td>
<td>1.5 Hours</td>
<td>4 Hours</td>
<td>7 Days</td>
<td>3 Hours</td>
<td>4 Weeks</td>
</tr>
<tr>
<td>25°C</td>
<td>50%</td>
<td>1 Hour</td>
<td>3 Hours</td>
<td>7 Days</td>
<td>2 Hours</td>
<td>4 Weeks</td>
</tr>
</tbody>
</table>

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

1 For best results, abrade surface before painting to ensure maximum intercoat adhesion.

Use of fast or low temperature hardeners may result in increased yellowing and a reduction of gloss level

SPREADING RATE

6.1 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.

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.

<table>
<thead>
<tr>
<th>SURFACE</th>
<th>ENVIRONMENT</th>
<th>PREPARATION GUIDE</th>
<th>SYSTEM</th>
<th>DFT (μm)</th>
</tr>
</thead>
<tbody>
<tr>
<td>STEEL – NEW</td>
<td>Very high corrosivity (AS2312.1 Cat C5) System EHB5</td>
<td>Abrasive blast clean AS1627.4 Class 2.5</td>
<td>1st Coat Durepon® P14 2nd Coat Ferreko® No. 3 3rd Coat Ferreko® No. 3</td>
<td>75 μm 125 μm 125 μm</td>
</tr>
<tr>
<td>STEEL – NEW</td>
<td>High corrosivity (AS2312.1 Cat C4) System PUR 3</td>
<td>Abrasive blast clean AS1627.4 Class 2.5</td>
<td>1st Coat Durepon® P14 2nd Coat Durebild® GPE 3rd Coat Weathermax® HBR</td>
<td>75 μm 125 μm 100 μm</td>
</tr>
<tr>
<td>STEEL – NEW</td>
<td>Low - Medium (AS2312.1 Cat C2-3) System ACC2</td>
<td>Abrasive blast clean AS1627.4 Class 2.5</td>
<td>1st Coat Durepon® P14 2nd Coat Acrathane® IF</td>
<td>75 μm 50 μm</td>
</tr>
<tr>
<td>STEEL – NEW</td>
<td>Low - Medium (AS2312.1 Cat C2-3) System PUR2</td>
<td>Abrasive blast clean AS1627.4 Class 2.5</td>
<td>1st Coat Durepon® P14 2nd Coat Weathermax® HBR</td>
<td>75 μm 100 μm</td>
</tr>
<tr>
<td>STEEL – NEW</td>
<td>Low - Medium (AS2312.1 Cat C2-3) System PUR2</td>
<td>Abrasive blast clean AS1627.4 Class 2.5</td>
<td>1st Coat Durepon® P14 2nd Coat Luxathane® HPX</td>
<td>75 μm 50 μm</td>
</tr>
<tr>
<td>STEEL – NEW</td>
<td>Low - Medium (AS2312.1 Cat C2-3) System PUR2</td>
<td>Abrasive blast clean AS1627.4 Class 2.5</td>
<td>1st Coat Durepon® P14 2nd Coat Luxathane® HPX</td>
<td>75 μm 50 μm</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.

PC 206 August 2018 Page 2 of 3
**DUREPON® P14**

### 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. Dulux® recommends that surfaces be degreased with Gamlen CA 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 with a blast profile of 40-70 microns.

### APPLICATION

**Mix each can thoroughly using a power mixer until the contents are uniform. Mix the contents of both packs together thoroughly using a power mixer and allow to stand for 10 minutes.**

**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.**

<table>
<thead>
<tr>
<th>Typical Set-up</th>
<th>Pressure at Triton 308:</th>
<th>Pressure at Gun:</th>
</tr>
</thead>
<tbody>
<tr>
<td>Graco AirPro:</td>
<td>70-100 kPa (10-15 p.s.i.)</td>
<td>380-410 kPa (55-60 p.s.i.)</td>
</tr>
</tbody>
</table>

### AIRLESS SPRAY

**Standard airless spray equipment such as a Graco Xtreme 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® 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. 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

Degrease with Gamlen CA 1 according to the data sheet. Test adhesion of existing coating by standard cross hatch adhesion 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. Epoxies must be abraded if recoated outside the recoat window.

### SAFETY PRECAUTIONS

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

### STORAGE

As with any chemical, ingestion, inhalation and prolonged or repeated skin contact should be avoided by good occupational 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.

### HANDLING

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 spraying, users must comply with their respective State Spray Painting Regulations.

### USING

This product is flammable. All sources of ignition must be eliminated in, or near the working area. DO NOT SMOKE. Fire with foam, CO₂ or dry chemical powder. On burning will emit toxic fumes.

### FLAMMABILITY

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

### WELDING

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 highly corrosive areas and for large projects to ensure proper performance.

---

**Company Information**

<table>
<thead>
<tr>
<th>Dulux Protective Coatings a division of DuluxGroup (Australia) Pty Ltd</th>
<th>Packaging, Transport and Storage</th>
</tr>
</thead>
<tbody>
<tr>
<td>DuluxGroup (New Zealand) Pty Ltd</td>
<td>Available in 4 litre and 20 litre packs</td>
</tr>
<tr>
<td>1956 Dandenong Road, Clayton 3168</td>
<td>1.63 kg/litre (Average of components)</td>
</tr>
<tr>
<td>A.B.N. 67 000 049 427</td>
<td>Part A: Class 3 UN 1263</td>
</tr>
<tr>
<td>150 Hutt Park Road, Lower Hutt, NZ</td>
<td>Part B: Class 3 UN 1263</td>
</tr>
<tr>
<td>A.B.N. 55 133 404 118</td>
<td>DANGEROUS GOODS</td>
</tr>
</tbody>
</table>

*Dulux, Acrythane, Dulhin, Durepon, Ferreko, Luxathane and Weathermax are registered trade marks of DuluxGroup (Australia) Pty Ltd.*