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
- 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

WEATHERABILITY	Will yellow with time and chalk on exterior exposure. Neither yellowing nor chalking detracts from the protective properties of the coating. Use a weatherable topcoat if required for appearance.	**SOLVENTS**	Resists splash and spillage of most hydrocarbon solvents, refined petroleum products and most common alcohols
HEAT RESISTANCE	Up to 120°C dry heat	**WATER**	Excellent resistance to fresh and salt water
SALTS	Unaffected by splash and spillage of neutral and alkaline salt solutions	**ALKALIS**	Excellent resistance to splash and spillage of most common alkalis
ACIDS	Suitable for splash and spillage of weak acids	**ABRASION**	Good when fully cured

TYPICAL PROPERTIES AND APPLICATION DATA (STANDARD HARDENER)

CLASSIFICATION	Epoxy zinc phosphate primer
FINISH	Low Sheen
COLOUR	Grey (Approximate match to AS2700 N12 Pastel Grey), Red Oxide & Lemon
COMPONENTS	Two
VOLUME SOLIDS	53% (White)
VOC LEVEL	<400 g/L
FLASH POINT	4°C
POT LIFE	8 hours (4 litre kit, 25°C)
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

	Min	Max
Air Temp.	10°C	40°C
Substrate Temp.	10°C	40°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)

					OVERCOAT	
Temperature	**Humidity**	**Touch**	**Handle**	**Full Cure**	**Min**	**Max[1]**
10° C	50%	3 Hours	23 Hours	7 Days	23 Hours	4 Weeks
15° C	50%	2 Hours	13 Hours	7 Days	13 Hours	4 Weeks
25° C	50%	1.5 Hours	8 Hours	7 Days	8 Hours	4 Weeks

*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
with Standard Hardener
assuming no losses

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.

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FAST CURE HARDENER

COATING THICKNESS (MICRONS)

	Min	Max	Recommended
Wet film per coat (µm)	110	200	165
Dry film per coat (µm)	50	90	75

APPLICATION CONDITIONS

	Min	Max
Air Temperature	10°C	40°C
Substrate Surface Temperature	10°C	40°C
Relative Humidity		85%

SOLIDS BY VOLUME	46%
VOC LEVEL	<470 g/L
POT LIFE	8 hours (4 litre kit, 25°C)

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

					OVERCOAT	
Temperature	Humidity	Touch	Handle	Full Cure	Min	Max[1]
10° C	50%	2 Hours	6 Hours	7 Days	6 Hours	4 Weeks
15° C	50%	1.5 Hours	4 Hours	7 Days	3 Hours	4 Weeks
25° C	50%	1 Hour	3 Hours	7 Days	2 Hours	4 Weeks

*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
with Fast Cure Hardener
assuming no losses

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.

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

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

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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. Remix thoroughly before application.
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.
	Typical Set-up — Graco AirPro: 1.8mm (239543); Pressure at Triton 308: 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 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	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 spraying, users must comply with their 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.

COMPANY INFORMATION

Dulux Protective Coatings a division of

DuluxGroup (Australia) Pty Ltd
1956 Dandenong Road, Clayton 3168
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DuluxGroup (New Zealand) Pty Ltd
150 Hutt Park Road, Lower Hutt, NZ
A.B.N. 55 133 404 118

PACKAGING, TRANSPORT AND STORAGE

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