**LUXAPRIME® ZP**

**High Build Anticorrosive Primer–Finish**

**PC 612**

**FEATURES**

- CONTAINS HIGH LEVELS OF ZINC PHOSPHATE
- CONTAINS MICACEOUS IRON OXIDE
- SUITABLE AS A PRIMER OVER POORLY PREPARED SURFACES
- AVAILABLE IN THREE COLOURS

**USES**

LUXAPRIME® ZP is a single pack, high build anticorrosive primer–finish that contains both zinc phosphate and micaceous iron oxide pigments. The primer is resistant to moisture and gives superior performance compared to conventional ROZP primers over power or hand tool cleaned surfaces. Relatively high builds of up to 75 microns dry film thickness are achievable in a single coat.

LUXAPRIME® ZP is recommended direct to steel, especially in circumstances where abrasive blast cleaning is not viable and surface preparation is limited to power tool clean standards. LUXAPRIME® ZP is typically used on structural frames and trusses for interiors of factories and warehouses.

**SPECIFICATIONS**

**AS 3750.19 Type 2**

**RESISTANCE GUIDE**

**WEATHERABILITY**

Will chalk on exterior exposure. Chalking does not detract from the protective properties of the coating. Use a weatherable topcoat if required for appearance.

**SOLVENTS**

Good resistance to intermittent splash and spillage of aromatic and aliphatic hydrocarbon solvents.

**WATER**

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

**SALTS**

Excellent resistance to neutral salts when suitably topcoated.

**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**

Single pack anticorrosive primer

**APPLICATION CONDITIONS**

**FINISH**

Low sheen with metallic lustre

**COLOUR**

Light Grey, Blue and Standard Red (MTO)

**COMPONENTS**

One

**VOLUME SOLIDS**

45% (Light Grey)

**VOC LEVEL**

<440 g/L (Light Grey)

**FLASH POINT**

5°C

**POT LIFE**

Not applicable

**MIXING RATIO V/V**

Single Pack

**THINNER − BRUSH**

Mineral Turpentine

**THINNER − SPRAY**

965-63034 Duthin® 340 Spray Thinner

**PRODUCT CODE**

866-63112 Light Grey

866-63065 Blue

866-63303 Standard Red (MTO)

**APPLICATION**

Conventional, airless spray

**TOPCOATS**

Dulux® single pack topcoats and selected two pack topcoats

**METHODS**

Brush, roller, conventional, airless spray or air assisted spray

**COATING THICKNESS (MICRONS)**

<table>
<thead>
<tr>
<th>Min</th>
<th>Max</th>
<th>Recommended</th>
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<tbody>
<tr>
<td>110</td>
<td>200</td>
<td>165</td>
</tr>
<tr>
<td>50</td>
<td>90</td>
<td>75</td>
</tr>
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</table>

**DRYING CHARACTERISTICS AT 75 μm DRY FILM THICKNESS**

<table>
<thead>
<tr>
<th>Temperature</th>
<th>Humidity</th>
<th>Touch</th>
<th>Handle</th>
<th>Full Cure</th>
<th>Overcoat</th>
</tr>
</thead>
<tbody>
<tr>
<td>10° C</td>
<td>50%</td>
<td>1 Hour</td>
<td>8 Hours*</td>
<td>7 Days</td>
<td>24 Hours Extended</td>
</tr>
<tr>
<td>15° C</td>
<td>50%</td>
<td>45 Minutes</td>
<td>5 Hours*</td>
<td>7 Days</td>
<td>24 Hours Extended</td>
</tr>
<tr>
<td>25° C</td>
<td>50%</td>
<td>30 minutes</td>
<td>2 Hours*</td>
<td>7 Days</td>
<td>24 Hours Extended</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. Do not overcoat before the minimum overcoat interval or wrinkling may occur. When overcoating with two pack finishes or with finishes containing aggressive solvents, a drying period of at least 72 hours at 25°C is recommended. If unsure, lightly sand and test a small area before commencing.

**SPREADING RATE**

6.0 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.
## 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>
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</thead>
<tbody>
<tr>
<td>STEEL – NEW</td>
<td>Medium corrosivity</td>
<td>Abrasive blast clean AS1627.4</td>
<td>1st Coat Luxaprime® ZP</td>
<td>75 µm</td>
</tr>
<tr>
<td>(AS2312 Cat C1-2)</td>
<td>Class 2.5</td>
<td>2nd Coat Ferreko® No. 5</td>
<td>50 µm</td>
<td></td>
</tr>
<tr>
<td></td>
<td>or power tool clean AS1627.2</td>
<td>3rd Coat Ferreko® No. 5</td>
<td>50 µm</td>
<td></td>
</tr>
<tr>
<td>STEEL – NEW</td>
<td>Mild - Moderate</td>
<td>Abrasive blast AS1627.4 Class 2</td>
<td>1st Coat Luxaprime® ZP</td>
<td>75 µm</td>
</tr>
<tr>
<td>(AS2312.1 Cat C1-3)</td>
<td>or power tool clean AS1627.2</td>
<td>2nd Coat Metalshield® Premium</td>
<td>40 µm</td>
<td></td>
</tr>
<tr>
<td>STEEL – NEW</td>
<td>Interior</td>
<td>Abrasive blast AS1627.4 Class 2</td>
<td>1st Coat Luxaprime® ZP</td>
<td>75 µm</td>
</tr>
<tr>
<td></td>
<td>or power tool clean AS1627.2</td>
<td>2nd Coat Luxaprime® ZP</td>
<td>75 µm</td>
<td></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 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. Remove all dust brushing or vacuum.

**Steel where abrasive blasting is not viable**: Rust, mill scale, oxide deposits and old paint films on metal surfaces must be removed by power tool cleaning according to AS1627.2 Class 2. Coating performance is proportional to the degree of surface preparation.

## APPLICATION

**BRUSH/ROLLER**
Mix each can thoroughly using a power mixer until the contents are uniform. Remix thoroughly before application. Apply a full, even coat. When brushing and rolling additional coats may be required to attain the specified thickness.

Do not thin except in hot weather – a small amount of mineral turpentine will then aid application.

**CONVENTIONAL SPRAY**
Thin up to 100ml/litre with Duthin® 340 Spray Thinner (965-63034) to aid atomisation. Apply in multiple wet coats overlapping each pass 50%.

**AIRLESS SPRAY**
Thin up to 50 ml/litre of DUTHIN® 340 Spray Thinner (965-63034) may be added to aid atomisation. Apply in multiple wet coats overlapping each pass 50%.

**PRESERVATIONS**

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 written consent of Dulux Australia. Do not apply at temperatures below 10°C or above 85% or when the surface is less than 3°C above the dewpoint. Do not overcoat before the minimum overcoat interval to welding may occur. The surface can be marked for several days after application. Abrasive blast cleaned surfaces must be primed within 4 hours. When overcoating with approved two pack finishes or with finishes containing aggressive solvents, a drying period of at least 72 hours at 25°C is recommended. If unsure of the result lightly sand and test a small area before completing the major work.

## CLEAN UP

Clean all equipment with Duthin® 340 Spray Thinner (965-63034) or mineral turpentine 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.

## 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, 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
1956 Dandenong Road, Clayton 3168
A.B.N. 67 000 049 427
DuluxGroup (New Zealand) Pty Ltd
150 Hutt Park Road, Lower Hutt, NZ
A.B.N. 55 133 404 118

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