METALSHIELD®
HIGH BUILD ZP PRIMER
Fast Dry High Build Zinc Phosphate Primer

FEATURES
- FAST DRY PRIMER
- CONTAINS ZINC PHOSPHATE
- HIGH BUILD SHOP PRIMER
- SINGLE PACK PRODUCT
- TOUCHUP SPRAYPAK 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. The high build characteristics of METALSHIELD® HIGH BUILD ZP PRIMER offers greater protection than standard shop primers.

SPECIFICATIONS
AS/NZS 3750.19 Type 1

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

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 95°C dry heat

WATER
Resists rain and condensation. Not recommended 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
Moderate when fully cured

TYPICAL PROPERTIES AND APPLICATION DATA
CLASSIFICATION
High build 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) 100 185 120
Dry film per coat (μm) 40 75 50

SUITABLE SUBSTRATES
Abrasive blast cleaned, hand cleaned or power tool cleaned steel

PRIMERS
Not applicable

TOPCOATS
Dulux® single pack topcoats

APPLICATION METHODS
Conventional, airless spray or air assisted spray

DRYING CHARACTERISTICS AT 50 μm DRY FILM THICKNESS*

<table>
<thead>
<tr>
<th>Temperature</th>
<th>Humidity</th>
<th>Touch</th>
<th>Handle</th>
<th>Full Cure</th>
<th>Min¹</th>
<th>Max¹</th>
</tr>
</thead>
<tbody>
<tr>
<td>25°C</td>
<td>50%</td>
<td>15 Minutes</td>
<td>2 Hours</td>
<td>7 Days</td>
<td>12 Hours</td>
<td>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.

¹Overcoating can occur up to 2 hours after 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

SPREADING RATE
8.2 square metres per litre equals 50 μm dry film thickness

NOTE: Practical spreading rates will vary depending on such factors as application method, ambient conditions, surface porosity and roughness.
METALSHIELD® HIGH BUILD ZP PRIMER

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>
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<tbody>
<tr>
<td>STEEL – NEW</td>
<td>Low-med corrosivity (AS2312 Cal C1-3)</td>
<td>Power tool clean AS1627.2 St 3</td>
<td>1st Coat Metalshield® High Build ZP Primer</td>
<td>50 μm</td>
</tr>
<tr>
<td>System ACL1</td>
<td></td>
<td></td>
<td>2nd Coat Weathershield® Gloss</td>
<td>40 μm</td>
</tr>
<tr>
<td></td>
<td></td>
<td></td>
<td>3rd Coat Weathershield® Gloss</td>
<td>40 μm</td>
</tr>
<tr>
<td>STEEL – NEW</td>
<td>Low-med corrosivity (AS2312 Cal C1-3)</td>
<td>Power tool clean AS1627.2 St 3</td>
<td>1st Coat Metalshield® High Build ZP Primer</td>
<td>50 μm</td>
</tr>
<tr>
<td>System ALK6</td>
<td>Abrasive blast AS1627.4 Class 2</td>
<td>2nd Coat Ferrodor® 810</td>
<td>50 μm</td>
<td></td>
</tr>
<tr>
<td></td>
<td></td>
<td>3rd Coat Ferrodor® 810</td>
<td>50 μm</td>
<td></td>
</tr>
<tr>
<td>STEEL – NEW</td>
<td>Low-med corrosivity (AS2312 Cal C1-3)</td>
<td>Power tool clean AS1627.2 St 3</td>
<td>1st Coat Metalshield® High Build ZP Primer</td>
<td>50 μm</td>
</tr>
<tr>
<td>System ALK2</td>
<td>Abrasive blast AS1627.4 Class 2</td>
<td>2nd Coat Metalshield® Premium Enamel</td>
<td>50 μm</td>
<td></td>
</tr>
<tr>
<td></td>
<td></td>
<td>3rd Coat Metalshield® Premium Enamel</td>
<td>50 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 according to the data sheet and SDS. 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.

Abrasives: A clean, dry abrasive free of contaminants in accordance with AS1627.1. Degrease with Gamlen CA 1 according to the data sheet and SDS.

CONVENTIONAL SPRAY

Thin to 60 ml/litre with Metalshield® Spray Thinner (965-H0009) to aid atomisation. Apply in multiple wet coats overlapping each pass 50%.

Typical Spray Air: 1.8mm (339543)

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 equipment such as a Graco Merkur 30:1 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 aid application. Metalshield® Brush Thinner (965-H0010) may be used in hot weather.

CLEAN UP

Clean all equipment with Metalshield® Spray Thinner (965-H0009) or Metalshield® Brush Thinner (965-H0010) 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.

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 must be worn while handling and using. Always wash hands before smoking, eating, drinking or using the toilet.

USING

Use with good ventilation and avoid inhalation of spray mists and fumes. When spraying, wear combined organic vapour/particulate respirator. Use of masks must comply with their respective State Spray Painting Regulations at all times.

FLAMMABILITY

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.

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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A.B.N. 67 000 049 427

Aerosols: Class 2 UN 1500

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