

ZINC RICH 1P

One Pack Zinc Rich Phenoxy Primer

PC 102

- FEATURES**
- SINGLE PACK "COLD GALVANISING" PRIMER
 - MAY BE OVERCOATED WITH MOST HEAVY DUTY TOPCOATS
 - EXCELLENT PRIMER FOR POWDER COATING

USES ZINC RICH 1P is recommended as a convenient sacrificial primer in conjunction with heavy duty finishes to increase the corrosion resistance and life of any system or as a single application protective coating.

ZINC RICH 1P is most often used as a general primer for structural steelwork in industrial and commercial environments especially for the protection of tankage, pipelines, cranes and bridges. It is also recommended for the repair of damaged galvanised steel and wrought iron balustrades and railings.

ZINC RICH 1P is an effective anti corrosive primer for steel to be powder coated.

SPECIFICATIONS

RESISTANCE GUIDE	
WEATHERABILITY	Will chalk on exterior exposure. Use a weatherable topcoat if required for appearance.
HEAT RESISTANCE	Up to 200°C dry heat. Not recommended for hot, wet conditions.
SALTS	Good resistance to most neutral and alkaline salts
ACIDS	Not recommended for acid conditions
SOLVENTS	Good resistance to splash and spillage of most aromatic hydrocarbon solvents
WATER	Good resistance but not suitable for immersion
ALKALIS	Not recommended for strongly alkaline conditions
ABRASION	Good when fully cured

TYPICAL PROPERTIES AND APPLICATION DATA

CLASSIFICATION	Zinc rich single pack phenoxy	APPLICATION CONDITIONS			
FINISH	Matt		Min	Max	
COLOUR	Grey	Air Temp.	5°C	45°C	
		Substrate Temp.	5°C	45°C	
		Relative Humidity		85%	
COMPONENTS	One	COATING THICKNESS (MICRONS)			
VOLUME SOLIDS	24.5%		Min	Max	Recommended
VOC LEVEL	<670 g/L	Wet film per coat (µm)	210	250	210
FLASH POINT	-7°C	Dry film per coat (µm)	50	60	50
POT LIFE	Not Applicable	SUITABLE SUBSTRATES	Abrasive blast cleaned steel. Prepared galvanised steel		
MIXING RATIO V/V	Single Pack	PRIMERS	Not applicable		
THINNER	920-08925 Dulux® Epoxy Thinner	TOPCOATS	Most Dulux® single pack and two pack topcoats and Dulux® Powder Coatings		
THINNER – UNDER POWDER COATING	965-08410 Duthin® 540	APPLICATION METHODS	Brush, roller, conventional, airless spray or air assisted spray		
PRODUCT CODE	812-19530 Grey				

DRYING CHARACTERISTICS AT 50 µm DRY FILM THICKNESS*

Temperature	Humidity	Touch	Handle	Full Cure	OVERCOAT	
					Min	Max
25° C	50%	5 Minutes	15-30 Minutes	7 Days	4 Hours	Extended

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

SPREADING RATE 4.7 square metres per litre equals 50 µm dry film thickness

ASSUMING NO LOSSES

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

ZINC RICH 1P

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	Mild - Moderate (AS2312.1 Cat C2-4)	Abrasive blast clean AS1627.4 Class 2.5	1 st Coat Zincrich 1P 2 nd Coat Duremax® GPE 3 rd Coat Weathermax® HBR	50 µm 125 µm 100 µm
GALVANISED STEEL	Exterior	Clean, degrease and abrade surface	Spot prime Zincrich 1P 2 nd Coat Duremax® GPE 3 rd Coat Weathermax® HBR	50 µm 125 µm 100 µm

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 blast cleaning 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. Galvanised steel: Round off all rough welds, sharp edges and zinc dags and remove weld spatter. Clean surface in accordance with AS1627.1. Whip blast, taking care not to damage the galvanising layer. Remove all dust by vacuum cleaning.									
APPLICATION	Mix each can thoroughly using a power mixer until the contents are uniform. Remix thoroughly before and during application to prevent settling.									
BRUSH/ROLLER	Suitable for small areas only. Apply even coats of the mixed material to the prepared surface. Thin if necessary with up to 100 ml/litre with Dulux® Epoxy Thinner (920-08925) to ease application. When brushing and rolling additional coats may be required to attain the specified thickness.									
CONVENTIONAL SPRAY	Thin up to 100ml/litre with Dulux® Epoxy Thinner (920-08925) to aid atomisation. For use under Powder Coatings use DUTHIN® 540. Ensure paint is regularly agitated during application to prevent separation.									
	<table border="0"> <tr> <td>Typical Set-up</td> <td>Graco AirPro:</td> <td>1.8mm (239543)</td> </tr> <tr> <td></td> <td>Pressure at Triton 308:</td> <td>100-140 kPa (15-20 p.s.i.)</td> </tr> <tr> <td></td> <td>Pressure at Gun:</td> <td>280-420 kPa (40-60 p.s.i.)</td> </tr> </table>	Typical Set-up	Graco AirPro:	1.8mm (239543)		Pressure at Triton 308:	100-140 kPa (15-20 p.s.i.)		Pressure at Gun:	280-420 kPa (40-60 p.s.i.)
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AIRLESS SPRAY	Standard airless spray equipment such as a Graco Merkur 30:1 with a fluid tip of 15-19 thou (0.38-0.48mm) and an air supply capable of delivering 550-690 kPa (80-100 p.s.i.) at the pump. Ensure paint is regularly agitated during application to prevent separation.									
PRECAUTIONS	This is an industrial product designed for use by experienced Protective Coating applicators. Ensure that you read and understand the safety precautions on the relevant Material Safety Data Sheets before using. The surface to be coated must be totally free of moisture and contaminants. 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. Where application conditions are outside the parameters stated in this Product Data Sheet, or where any variation to the recommendations within this document are sought, contact your Dulux® Consultant for written consent or specifications prior to application. Topcoats of a saponifiable nature such as alkyds must never be applied directly to Zinc Rich 1P. When used under powder coatings Duthin® 540 must be used.									
CLEAN UP	Clean all equipment with Dulux® Epoxy Thinner (920-08925) immediately after use									
OVERCOATING	Degrease with Gamlen CA No. 1 according to the manufacturer's written instructions and all safety warnings. Test adhesion of existing coating by 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 bonded area under cover. Store in well-ventilated area away from sources of heat or ignition. Keep containers closed at all times.									
HANDLING	Contents of container may be under pressure. Containers should be carefully opened by first placing a rag, then a hand, over the lid then gently easing the lid off. 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. Users must always 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. 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
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DuluxGroup (New Zealand) Pty Ltd
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PACKAGING, TRANSPORT AND STORAGE

PACKAGING Available in 4 litre cans

TRANSPORTATION WEIGHT 1.57 kg/litre

DAANGEROUS GOODS Class 3 UN 1263

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