DUREPON® FRX
Two Pack Cold Curing Epoxy Zinc Phosphate Primer

FEATURES
• LOW TEMPERATURE CURE
• FAST RECOAT
• CONTAINS HIGH LEVELS OF ZINC PHOSPHATE
• EASY APPLICATION

USES
DUREPON® FRX is a versatile primer suitable for application to heavy duty steelwork at low temperatures. It is useful as a tie-coat over inorganic zinc primers and under a wide range of topcoats.

Unlike typical epoxies, DUREPON® FRX does not have a narrow recoat window – it can be recoated with itself or topcoated after longer periods than typical epoxies.

DUREPON® FRX can be overcoated with epoxy, polyurethane or acrylic finishes depending upon service requirements. It has excellent adhesion to blast-cleaned steel, excellent corrosion resistance and rapid dry times, even at temperatures down to 0°C.

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 aromatic and aliphatic hydrocarbon solvents and alcohols.

WATER
Excellent resistance to fresh and salt water

ALKALIS
Excellent resistance to splash and spillage of most common alkalis

ACRIDS
Suitable for splash and spillage of mild acids

ABRASION
Good when fully cured

TYPICAL PROPERTIES AND APPLICATION DATA

CLASSIFICATION
Epoxy zinc phosphate primer

APPLICATION CONDITIONS
Min Max

FINISH Semi gloss

COLOUR Light grey (Approximate match to AS2700 N12 Pastel Grey)

Air Temp. 0°C 45°C

Substrate Temp. 0°C 45°C

Relative Humidity 85%

COMPONENTS
Two

VOLUME SOLIDS
62%

VOC LEVEL <360 g/L

FLASH POINT – 7°C

POT LIFE 6 hours (4 litre kit, 25°C)

MIXING RATIO V/V Part A : 6 Part B : 1

THINNER 920-08925 Dulux® Epoxy Thinner

SUITABLE SUBSTANCES Abrasive blast cleaned steel

PRIMERS Not applicable

TOPCOATS Single and two pack Dulux® products

APPLICATION METHODS Conventional spray, 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>Overcoat</th>
</tr>
</thead>
<tbody>
<tr>
<td>10°C</td>
<td>50%</td>
<td>2 Hours</td>
<td>8 Hours</td>
<td>5 Days</td>
<td>3 Hours</td>
</tr>
<tr>
<td>15°C</td>
<td>50%</td>
<td>1 Hour</td>
<td>7 Hours</td>
<td>4 Days</td>
<td>2 Hours</td>
</tr>
<tr>
<td>25°C</td>
<td>50%</td>
<td>1 Hour</td>
<td>4 – 6 Hours</td>
<td>4 Days</td>
<td>1.5 Hours</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.

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

SPREADING RATE
with Standard Hardener assuming no losses

8.3 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><strong>STEEL – NEW</strong></td>
<td>High corrosivity</td>
<td>Abrasive blast clean</td>
<td>1st Coat</td>
<td>Durepon® FRX 75 µm</td>
</tr>
<tr>
<td>(AS2312.1 Cat C4)</td>
<td>System PUR 3</td>
<td>AS1627.4 Class 2.5</td>
<td>2nd Coat</td>
<td>Duremax® GPE 125 µm</td>
</tr>
<tr>
<td></td>
<td></td>
<td></td>
<td>3rd Coat</td>
<td>Weathermax® HBR 100 µm</td>
</tr>
<tr>
<td><strong>STEEL – NEW</strong></td>
<td>Severe Industrial Corrosivity</td>
<td>Abrasive blast clean</td>
<td>1st Coat</td>
<td>Durepon® FRX 75 µm</td>
</tr>
<tr>
<td>(AS2312.1)</td>
<td>System EVH4</td>
<td>AS1627.4 Class 2.5</td>
<td>2nd Coat</td>
<td>Duremax® HBE 250 µm</td>
</tr>
<tr>
<td></td>
<td></td>
<td></td>
<td>3rd Coat</td>
<td>Duremax® HBE 250 µm</td>
</tr>
<tr>
<td><strong>STEEL – NEW</strong></td>
<td>Moderate Industrial Corrosivity</td>
<td>Abrasive blast clean</td>
<td>1st Coat</td>
<td>Durepon® FRX 75 µm</td>
</tr>
<tr>
<td>(AS2312.1)</td>
<td>System EHB3</td>
<td>AS1627.4 Class 2.5</td>
<td>2nd Coat</td>
<td>Duremax® HBE 200 µm</td>
</tr>
<tr>
<td><strong>STEEL – NEW</strong></td>
<td>Low - Medium</td>
<td>Abrasive blast clean</td>
<td>1st Coat</td>
<td>Durepon® FRX 75 µm</td>
</tr>
<tr>
<td>(AS2312.1)</td>
<td>Cat C2-3 System PUR 2</td>
<td>AS1627.4 Class 2.5</td>
<td>2nd Coat</td>
<td>Luxathane® HPX 50 µm</td>
</tr>
<tr>
<td></td>
<td></td>
<td></td>
<td>3rd Coat</td>
<td>Luxathane® HPX (Optional) 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.

**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. Abrasive blast clean to a minimum of AS1627.4 Class 2.5.

**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.

Apply even coats of the mixed material to the prepared surface. 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. The specified thickness.

**CONVENTIONAL SPRAY**

Thin up to 100 ml/litre with Duthin® 450 (920-81942) to aid atomisation. At temperatures below 15°C, up to 150 ml/litre thinner may be required.

**PREPARATION GUIDES**

Steel: Abrasive blast clean using ainerary 150 grit paper to provide a good key for the new coating. Do not apply at relative humidity above 85% or when the surface is less than 3°C above the dewpoint. In hot conditions above 30°C Dulux® Epoxy Thinner (920-08925) may be used in place of Duthin® 450 to improve application. Do not use on galvanised steel as delamination can occur.

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

**COMPANY INFORMATION**

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