

DURATION® P23

Premium Water Borne Zinc Phosphate Epoxy Primer

PC 850

- FEATURES**
- INHIBITIVE EPOXY PRIMER FOR STEEL AND OTHER PREPARED SURFACES
 - CONTAINS ANTI-CORROSIVE PIGMENTATION ZINC PHOSPHATE
 - LOW VOC & LOW ODOUR COMPARED TO SOLVENT BORNE SYSTEMS
 - FAST RECOAT TIME – 4 HOURS AT 25°C

USES DURATION® P23 is a premium, two-component epoxy zinc phosphate primer that is fast drying and exhibits very good anti corrosion properties over mild steel. DURATION® P23 can also be used as a primer over other metal substrates such as galvanized steel, zinc plated steel and aluminium. DURATION® P23 is the ideal primer coat as part of complete DURATION® water borne protective coatings system for steel that is exposed to sheltered or mild (C1-C3) corrosive environments including residential and commercial construction, hospitals, warehouses, schools, shopping centres and factories.

SPECIFICATIONS

RESISTANCE GUIDE

WEATHERABILITY	Will yellow with time. Will chalk on exposure to UV. Neither yellowing nor chalking detracts from the protective properties of the coating. Use a weatherable topcoat if appearance is important.	SOLVENTS	Good resistance to splash and spillage of aromatic and aliphatic hydrocarbon solvents and alcohols.
HEAT RESISTANCE	Up to 120°C dry heat	WATER	Excellent resistance to fresh and salt water but not suitable for immersion.
SALTS	Excellent resistance to neutral and alkaline salts when suitably topcoated.	ALKALIS	Good resistance to splash and spillage of most common alkalis
ACIDS	Suitable for splash and spillage exposure to dilute acids.	ABRASION	Good when fully cured

TYPICAL PROPERTIES AND APPLICATION DATA

CLASSIFICATION	Two pack epoxy zinc phosphate primer		APPLICATION CONDITIONS			
FINISH	Low Gloss			Min	Max	
COLOUR	Grey		Air Temp.	10°C	40°C	
			Substrate Temp.	10°C	40°C	
			Relative Humidity		85%	
COMPONENTS	Two		COATING THICKNESS (MICRONS)			
VOLUME SOLIDS	43%			Min	Max	Recommended
VOC LEVEL	<70 g/L		Wet film per coat (µm)	175	235	175
FLASH POINT	N/A		Dry film per coat (µm)	75	100	75
POT LIFE	2 hours (4 litre kit, 25°C)		SUITABLE SUBSTRATES	Suitably prepared steel, aluminium and zinc coated steel		
MIXING RATIO V/V	Part A : 4 Part B : 1		PRIMERS	Not applicable		
THINNER – BRUSH	Potable Water		TOPCOATS	Dulux® Duration® topcoat range		
THINNER – SPRAY	Potable Water		APPLICATION METHODS	Airless spray, air assisted spray, brush, or roller		
PRODUCT CODE	H00-H0176	Grey				
	976-H0178	Standard Hardener				

DRYING CHARACTERISTICS AT 75 µm DRY FILM THICKNESS*

Temperature	Humidity	Touch	Handle	Full Cure	OVERCOAT	
					Min	Max ¹
25° C	50%	1 Hour	4 Hours	7 Days	4 Hours	7 days

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

¹ If the maximum overcoat interval is exceeded then the surface MUST be abraded to ensure maximum intercoat adhesion.

SPREADING RATE ASSUMING NO LOSSES

5.7 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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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	Low-medium corrosivity (AS2312.1 Cat C1-C3)	Abrasive blast AS1627.4 Class 2.5	1 st Coat Duration® P23 2 nd Coat Duration® X21 3 rd Coat Duration® T74	75 µm 50 µm 50 µm
STEEL - NEW	Low-medium corrosivity (AS2312.1 Cat C1-C3)	Abrasive blast AS1627.4 Class 2.5	1 st Coat Duration® P23 2 nd Coat Duration® X21 3 rd Coat Duration® T80	75 µm 50 µm 50 µm
STEEL - NEW	Interior	Abrasive blast AS1627.4 Class 2.5	1 st Coat Duration® P23 2 nd Coat Duration® X21 3 rd Coat Duration® X21	75 µm 50 µm 50 µm
GALVANISED STEEL AND ALUMINIUM	Exterior/Interior	Clean, degrease and abrade or whip blast	1 st Coat Duration® P23 2 nd Coat Duration® X21 3 rd Coat Duration® T74	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

SURFACE PREPARATION	<p>Mild Steel: Round off all rough welds, sharp edges and remove weld spatter. Remove grease, oil and other contaminants in accordance with AS1627.1 with Gamlen CA 1. Rust, mill scale, oxide deposits and old paint films on metal surfaces should be removed by abrasive blast cleaning to a minimum of AS1627.4 Class 2.5.</p> <p>Aluminium and galvanized steel: Remove grease, oil and other contaminants in accordance with AS1627.1 with Gamlen CA 1. Abrade surface by sanding or light whip blasting.</p>		
APPLICATION	<ol style="list-style-type: none"> Mix Part A and Part B thoroughly using a power mixer until the contents are uniform. Allow mixed product to stand for 10 minutes. Box all containers before use to ensure colour consistency. Remix thoroughly before application. 		
BRUSH/ROLLER	Application can be improved by thinning with up to 100 ml/litre with potable water. When brushing and rolling additional coats may be required to attain the specified thickness.		
CONVENTIONAL SPRAY	Thin up to 100ml/litre with potable water to aid atomisation. Apply in multiple wet coats overlapping each pass by 50%.		
	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 50ml/litre of potable water may be added to ease application.		
PRECAUTIONS	<p>This is an industrial product designed for use by experienced 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.</p> <p>Do not use any product past its pot life. Product past its pot life may still appear fit for use but will develop substantially reduced gloss and may develop brittleness. Freshly mixed material must not be added to material that has been mixed for some time. The rate of cure is dependent upon temperature. Do not apply at temperatures below 10°C, or where the surface temperature is below 10°C. Do not apply at relative humidity above 85% or when the surface is less than 3°C above the dewpoint.</p>		
CLEAN UP	Clean all equipment with clean warm water immediately after use followed by DULUX® EPOXY THINNER (920-08925).		
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	Both components are NOT classified as dangerous goods for transport or storage. Store in well ventilated bunded area under cover and away from sources of heat. 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 not flammable. 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	PACKAGING, TRANSPORT AND STORAGE
Dulux Protective Coatings a division of	PACKAGING Available in 4 litre packs
DuluxGroup (Australia) Pty Ltd 1956 Dandenong Road, Clayton 3168 A.B.N. 67 000 049 427	TRANSPORTATION WEIGHT 1.47 kg/litre (Average of components)
DuluxGroup (New Zealand) Pty Ltd 150 Hutt Park Road, Lower Hutt, NZ A.B.N. 55 133 404 118	DANGEROUS GOODS Part A: Non Dangerous Goods Part B: Non Dangerous Goods

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