

# ZINCANODE<sup>®</sup> 202

## Two Pack Zinc Rich Epoxy Primer

**PC 120**

- FEATURES**
- RAPID DRY AND OVERCOAT TIMES
  - LONG SERVICE HISTORY IN INDUSTRIAL & MARINE EXPOSURES
  - TOP COATING REQUIRES NO SPECIAL MIST COATING TECHNIQUES
  - SUITABLE FOR USE IN ENVIRONMENTS UP TO 200°C
  - PROVIDES EXCELLENT CORROSION PROTECTION

**USES** ZINCANODE<sup>®</sup> 202 is a two pack epoxy zinc rich primer formulated with a high level of finely divided zinc metal to provide excellent galvanic corrosion protection. On curing, a hard abrasion resistant coating results, which is particularly suitable for overcoating with heavy duty finishes without the need for mist coating or use of a tie coat. Dry film zinc levels exceed Australian Standard requirements.

ZINCANODE<sup>®</sup> 202 has been widely used for the protection of industrial and chemical plant, in particular - oil refineries, power generation plant, mining facilities and bulk handling equipment. Ideal touch up primer for inorganic zinc silicates and galvanising in aggressive environments.

**SPECIFICATIONS** Approved to APAS 0014/2.  
AS/NZS 3750.9 Type 2.

### RESISTANCE GUIDE

<b>WEATHERABILITY</b>	Epoxy coatings 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.	<b>SOLVENTS</b>	Good resistance to splash and spillage of aromatic and aliphatic hydrocarbon solvents and alcohols
<b>HEAT RESISTANCE</b>	Up to 200°C dry heat	<b>WATER</b>	Excellent resistance to fresh and salt water when suitably topcoated
<b>SALTS</b>	Excellent resistance to neutral and alkaline salts when suitably topcoated	<b>ALKALIS</b>	Not recommended for alkaline conditions unless suitably topcoated
<b>ACIDS</b>	Not recommended for acid conditions	<b>ABRASION</b>	Very good when fully cured

### TYPICAL PROPERTIES AND APPLICATION DATA

<b>CLASSIFICATION</b>	Zinc Rich Epoxy Primer	<b>APPLICATION CONDITIONS</b>			
<b>FINISH</b>	Matt		Min	Max	
<b>COLOUR</b>	Grey	<b>Air Temp.</b>	10°C	40°C	
		<b>Substrate Temp.</b>	10°C	40°C	
		<b>Relative Humidity</b>		85%	
<b>COMPONENTS</b>	Two	<b>COATING THICKNESS (MICRONS)</b>			
<b>VOLUME SOLIDS</b>	47%		Min	Max	Recommended
<b>VOC LEVEL</b>	<450 g/L	<b>Wet film per coat (µm)</b>	95	191	105
<b>FLASH POINT</b>	>23°C	<b>Dry film per coat (µm)</b>	45	90	50
<b>POT LIFE</b>	8 Hours (4 Litre kit, 25°C)	<b>SUITABLE SUBSTRATES</b>	Abrasive blast cleaned steel		
<b>MIXING RATIO V/V</b>	Part A : 4    Part B : 1	<b>PRIMERS</b>	Not applicable		
<b>THINNER</b>	920-08925    Dulux <sup>®</sup> Epoxy Thinner	<b>TOPCOATS</b>	Most Dulux <sup>®</sup> single pack and two pack topcoats		
<b>PRODUCT CODE</b>	730-63029    Part A 976-63047    Hardener	<b>APPLICATION METHODS</b>	Conventional, airless spray or air assisted spray. Brush and roller suitable for small areas only		

### DRYING CHARACTERISTICS AT 50 µm DRY FILM THICKNESS\*

Temperature	Humidity	Touch	Handle	Full Cure	OVERCOAT	
					Min	Max <sup>1</sup>
25° C	50%	30 Minutes	2-3 Hours	7 Days	4 Hours	4 Weeks

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

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

### SPREADING RATE ASSUMING NO LOSSES

**9.3 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.

# ZINCANODE® 202

## 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	High corrosivity (AS2312.1 Cat C5)	Abrasive blast clean AS1627.4 Class 2.5	1 <sup>st</sup> Coat Zincanode® 202 2 <sup>nd</sup> Coat Duremax® GPE 3 <sup>rd</sup> Coat Weathermax® HBR	50 µm 125 µm 100 µm
STEEL – NEW	High corrosivity (AS2312.1 Cat C5)	Abrasive blast clean AS1627.4 Class 2.5	1 <sup>st</sup> Coat Zincanode® 202 2 <sup>nd</sup> Coat Ferreko® No. 3 3 <sup>rd</sup> Coat Ferreko® No. 3	50 µm 100 µm 100 µm
STEEL – NEW	Low-medium corrosivity (AS2312.1 Cat C2-3)	Abrasive blast clean AS1627.4 Class 2.5	1 <sup>st</sup> Coat Zincanode® 202 2 <sup>nd</sup> Coat Luxathane® HPX	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

<b>SURFACE PREPARATION</b>	<b>Steel:</b> 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.
<b>APPLICATION</b>	Mix each can thoroughly using a power mixer until the contents are uniform. Mix the contents of both packs together thoroughly with a power mixer and let stand for 10 minutes. Ensure clean-up solvent (Dulux® Epoxy Thinner) is available. Remix thoroughly before and during application.
<b>BRUSH/ROLLER</b>	For small areas only. Thinning is not normally required, however, up to 50 ml/litre of Dulux® Epoxy Thinner (920-08925) can be added to aid application. Additional coats may be required to attain the specified thickness.
<b>CONVENTIONAL SPRAY</b>	Thin up to 100ml/L with Dulux® Epoxy Thinner to aid atomisation. Stir paint during application to prevent settling. When using under Powder Coatings, thin with Duthin® 540.
	Typical Set-up Graco AirPro: 1.8mm (239543) Pressure at Triton 308: 70-100 kPa (10-15 p.s.i.) Pressure at Gun: 380-415 kPa (55-60 p.s.i.)
<b>AIRLESS SPRAY</b>	Standard airless spray equipment such as a Graco Xtreme 45:1 with a fluid tip of 15-17 thou (0.38-0.43mm) and an air supply capable of delivering 550-690 kPa (80-100 p.s.i.) at the pump. Agitate paint frequently during spraying to prevent separation. Thinning is not normally required but up to 50 ml/litre of Dulux® Epoxy Thinner may be added to aid application.
<b>PRECAUTIONS</b>	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. The rate of cure is dependent upon temperature. 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. Freshly mixed material must not be added to material that has been mixed for some time. Alkyds must never be applied to Zincanode® 202.
<b>CLEAN UP</b>	Clean all equipment with Dulux® Epoxy Thinner (920-08925) immediately after use.
<b>OVERCOATING</b>	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.
<b>SAFETY PRECAUTIONS</b>	<b>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</b>
<b>STORAGE</b>	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. Contents of container may be under pressure.
<b>HANDLING</b>	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.
<b>USING</b>	Use with good ventilation and avoid inhalation of spray mists and fumes. When spraying, wear combined organic vapour/particulate respirator. Users must comply with their respective State Spray Painting Regulations at all times.
<b>FLAMMABILITY</b>	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 <sub>2</sub> or dry chemical powder. On burning will emit toxic fumes.
<b>WELDING</b>	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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### PACKAGING, TRANSPORT AND STORAGE

PACKAGING	Available in 4 litre packs
TRANSPORTATION WEIGHT	2.5 kg/litre (Average of components)
DANGEROUS GOODS	Part A: Class 3 UN 1263
	Part B: Class 3 UN 1263

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