

LUXAPRIME® ZP

High Build Anticorrosive Primer-Finish

PC 612

- FEATURES**
- CONTAINS HIGH LEVELS OF ZINC PHOSPHATE
 - CONTAINS MICACEOUS IRON OXIDE
 - SUITABLE AS A PRIMER OVER POORLY PREPARED SURFACES
 - AVAILABLE IN THREE COLOURS

USES LUXAPRIME® ZP is a single pack, high build anticorrosive primer-finish that contains both zinc phosphate and micaceous iron oxide pigments. The primer is resistant to moisture and gives superior performance compared to conventional ROZP primers over power or hand tool cleaned surfaces. Relatively high builds of up to 75 microns dry film thickness are achievable in a single coat.

LUXAPRIME® ZP is recommended direct to steel, especially in circumstances where abrasive blast cleaning is not viable and surface preparation is limited to power tool clean standards. LUXAPRIME® ZP is typically used on structural frames and trusses for interiors of factories and warehouses.

SPECIFICATIONS ASPAS 0032 - assessed and confirmed to meet all requirements on specific certified products. Refer to a Dulux Protective Coatings Consultant for more details.
AS 3750.19 Type 2

RESISTANCE GUIDE

WEATHERABILITY	Will chalk on exterior exposure. Chalking does not detract from the protective properties of the coating. Use a weatherable topcoat if required for appearance.	SOLVENTS	Good resistance to intermittent splash and spillage of aromatic and aliphatic hydrocarbon solvents.
HEAT RESISTANCE	Up to 120°C dry heat.	WATER	Resists rain and condensation. Not recommended for permanently damp or immersed exposure.
SALTS	Excellent resistance to neutral salts when suitably topcoated.	ALKALIS	Not recommended where fumes, splash or spillage may occur.
ACIDS	Not recommended where fumes, splash or spillage may occur.	ABRASION	Good when fully cured.

TYPICAL PROPERTIES AND APPLICATION DATA

CLASSIFICATION	Single pack anticorrosive primer	APPLICATION CONDITIONS			
FINISH	Flat with metallic lustre		Min	Max	
COLOUR	Light Grey, Blue and Standard Red (MTO)	Air Temp.	10°C	40°C	
		Substrate Temp.	10°C	40°C	
		Relative Humidity		85%	
COMPONENTS	One	COATING THICKNESS (MICRONS)			
VOLUME SOLIDS	45% ± 2% (depending on colour)		Min	Max	Recommended
VOC LEVEL	<480g/L	Wet film per coat (µm)	110	200	165
FLASH POINT	>23°C	Dry film per coat (µm)	50	90	75
POT LIFE	Not applicable	SUITABLE SUBSTRATES	Abrasive blast cleaned or power tool cleaned steel		
MIXING RATIO V/V	Single Pack	PRIMERS	Not applicable		
THINNER – BRUSH	Mineral Turpentine	TOPCOATS	Specified Dulux® Protective Coatings topcoats		
THINNER – SPRAY	965-63034 Duthin® 340 Spray Thinner	APPLICATION METHODS	Brush, roller, conventional, airless spray or air assisted spray		
PRODUCT CODE	866-63112 Light Grey 866-63065 Blue 866-63303 Standard Red (MTO)				

DRYING CHARACTERISTICS AT 75 µm DRY FILM THICKNESS

Temperature	Humidity	Touch	Handle	Full Cure	OVERCOAT	
					Min	Max
10° C	50%	1 Hour	8 Hours*	7 Days	24 Hours	Extended
15° C	50%	45 Minutes	5 Hours*	7 Days	24 Hours	Extended
25° C	50%	30 minutes	2 Hours*	7 Days	24 Hours	Extended

* These figures are a guide only, as ventilation, film thickness, humidity, thinning and other factors will influence the rate of drying. Do not overcoat before the minimum overcoat interval or wrinkling may occur. When overcoating with two pack finishes or with finishes containing aggressive solvents, a drying period of at least 72 hours at 25°C is recommended. If unsure, lightly sand and test a small area before commencing.

SPREADING RATE 6.0 square metres per litre equals 75 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.

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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	Medium corrosivity (AS2312 Cat C1-2) Exceeds System ACL1	Abrasive blast clean AS1627.4 Class 2.5 or power tool clean AS1627.2	1 st Coat Luxaprime® ZP 2 nd Coat Ferreko® No. 5 3 rd Coat Ferreko® No. 5	75 µm 50 µm 50 µm
STEEL – NEW	Mild - Moderate (AS2312.1 Cat C1-3) System ALK3	Abrasive blast AS1627.4 Class 2 or power tool clean AS1627.2	1 st Coat Luxaprime® ZP 2 nd Coat Metalshield® Premium	75 µm 40 µm
STEEL – NEW	Interior	Abrasive blast AS1627.4 Class 2 or power tool clean AS1627.2	1 st Coat Luxaprime® ZP 2 nd Coat Luxaprime® ZP	75 µm 75 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>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.</p> <p>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.</p>
APPLICATION BRUSH/ROLLER	Mix each can thoroughly using a power mixer until the contents are uniform. Remix thoroughly before application. Apply a full, even coat. When brushing and rolling additional coats may be required to attain the specified thickness. Do not thin except in hot weather – a small amount of mineral turpentine will then aid application.
CONVENTIONAL SPRAY	Thin up to 100ml/litre with Duthin® 340 Spray Thinner (965-63034) to aid atomisation. Apply in multiple wet coats overlapping each pass 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 (60-70 p.s.i.)
AIRLESS SPRAY	Standard airless spray equipment such as a Graco Merkur 30:1 with a fluid tip of 19-21 thou (0.48-0.53mm) 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 DUTHIN® 340 Spray Thinner (965-63034) may be added to aid application.
PRECAUTIONS	This is an industrial product designed for use by experienced Protective 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. 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. Do not overcoat before the minimum overcoat interval or wrinkling may occur. The surface can be marked for several days after application. Abrasive blast cleaned surfaces must be primed within 4 hours. When overcoating with approved two pack finishes or with finishes containing aggressive solvents, a drying period of at least 72 hours at 25°C is recommended. If unsure of the result lightly sand and test a small area before completing the major work.
CLEAN UP	Clean all equipment with Duthin® 340 Spray Thinner (965-63034) or mineral turpentine 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 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 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 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

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PACKAGING, TRANSPORT AND STORAGE

PACKAGING	Available in 4 litre and 15 litre packs
TRANSPORTATION WEIGHT	1.45 kg/litre (Standard Red)
DANGEROUS GOODS	Class 3 UN 1263

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