ZINCANODE® 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® 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® 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
- APAS 0014/2 - assessed and confirmed to meet all requirements on specific certified products
- AS/NZS 3750.9 Type 2
- Tested in accordance with AS 4100-1998 – Steel Structures Appendix J – Standard Test for Evaluation of Slip Factor

Refer to a Dulux® Protective Coatings Consultant for more details.

RESISTANCE GUIDE

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

TYPICAL PROPERTIES AND APPLICATION DATA

CLASSIFICATION	Zinc Rich Epoxy Primer
FINISH	Matt
COLOUR	Grey
COMPONENTS	Two
VOLUME SOLIDS	49% ± 2
VOC LEVEL	<440 g/L
FLASH POINT	>23°C
POT LIFE	8 Hours (4 Litre kit, 25°C)
MIXING RATIO V/V	Part A : 4 Part B : 1
THINNER	920-08925 Dulux® Epoxy Thinner
PRODUCT CODE	730-63029 Part A 976-63047 Hardener

APPLICATION CONDITIONS

	Min	Max
Air Temp.	10°C	40°C
Substrate Temp.	10°C	40°C
Relative Humidity		85%

COATING THICKNESS (MICRONS)

	Min	Max	Recommended
Wet film per coat (µm)	95	185	105
Dry film per coat (µm)	45	90	50

SUITABLE SUBSTRATES	Abrasive blast-cleaned steel
PRIMERS	Not applicable
TOPCOATS	Most Dulux® single pack and two pack topcoats
APPLICATION METHODS	Conventional, airless spray or air-assisted spray. Brush and roller suitable for small areas only

DRYING CHARACTERISTICS AT 50 µm DRY FILM THICKNESS*

					OVERCOAT	
Temperature	**Humidity**	**Touch**	**Handle**	**Full Cure**	**Min**	**Max[1]**
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.

[1]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	1st Coat Zincanode® 202 2nd Coat Duremax® GPE 3rd 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	1st Coat Zincanode® 202 2nd Coat Ferreko® No. 3 3rd 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	1st Coat Zincanode® 202 2nd 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

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.

APPLICATION

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.

BRUSH/ROLLER

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.

CONVENTIONAL SPRAY

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.)

AIRLESS SPRAY

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.

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. 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.

CLEAN UP

Clean all equipment with Dulux® Epoxy Thinner (920-08925) 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. 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

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. Contents of container may be under pressure.

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 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 is 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 and 8 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