

DULUX

EPOXY ZINC PHOSPHATE PRIMER

A580-16252 (HIGH PERFORMANCE-SOLVENTBORNE)

PRODUCT INFORMATION

PRODUCT NAME	Dulux Epoxy Zinc Phosphate Primer.
PRODUCT CODE	Base: A580-16252. Activator: A275-19329.
DESCRIPTION	Dulux Epoxy Primer Off White is anti-corrosion two pack epoxy primer.
USAGE	Suitable for use on blast cleaned steel where a complete epoxy system is required. It is suitable as a patch primer for treatment of manually prepared steel.
BENEFITS	Provides good anti-corrosion protection. Facilitates adhesion of finish onto difficult substrates. Non-toxic:- Safer to use compared to chromate versions.
PACK SIZE	5 litres units comprising Base: 4 litres and Activator: 1 litre.
COLOUR RANGE	Beige.

PERFORMANCE GUIDE





FILM PROPERTIES	
Chemical Resistance	Resists most chemical environments when used with the recommended topcoat.
Heat Resistance	Can be used on heated surfaces up to 110°C.
Water Resistance	Excellent.
THEORETICAL COVERAGE	A guide to the theoretical coverage which can be achieved under normal conditions is 4.8-8.0m ² /L.

PRODUCT DATA




COMPOSITION (nominal)	Pigment : Zinc Phosphate, Non-Lead Pigments and Inert Mineral Extenders. Blinder : Polyamide Cured Epoxy. Solvent : Aromatic Hydrocarbons and Alcohol.
VOLUME SOLIDS	60% (nominal).
FLASH POINT	Base and Activator - 22°C.
POT LIFE	Up to 4 hours at 30°C.

APPLICATION

MIXING RATIO	4 parts Base to 1 part Activator by volume.
THINNING Conventional Spray Airless Spray	Add up to 1 part of Dulux Thinner 850-761 to 5 parts of paint (20%). Add up to 1 part of Dulux Thinner 850-761 to 20 parts of paint (5%).
SPRAY RECOMMENDATIONS Conventional Spray Airless Spray	Satisfactory through most equipment. A typical set up for airless spray application is a minimum working pressure on paint of 140kg/cm ² (2000 lb/sq in) with a spray tip size 0.43-0.53mm (17-21 thou) and a spray tip angle of 65°C.
SPRAY NOTES	It is important that the Base and the Activator are at the minimum temperature of 15°C when mixed for satisfactory spray application.
CURING TIMES Recoat At 30°C Full Cure	Single coat at standard thickness: 6 hours minimum. 7 days. Please note that the reaction of epoxies commences immediately after the two components are mixed. This reaction is temperature related and so the curing time will be approximately halved by a 10°C increase in temperature and doubled by a 10°C decrease in temperature.
CLEANING UP	Clean all equipment with Dulux Thinner 850-11 immediately after use.






















FILM THICKNESS	Wet: 125-210 micro-metres Dry: 75-125 micro-metres.
	 Application method  65° spraying tip  6 hours recoat time  Practise proper cleaning

PRE - APPLICATION

SURFACE PREPARATION	For optimum performance, blast clean to BS 7079 Part A1: 1989 Sa 2.5 to give an appropriate surface profile.						
SYSTEM INFORMATION	<table border="0"> <tr> <td>PRIMER (1 COAT)</td> <td>INTERMEDIATE or FINISH (1-2 COATS)</td> <td>FINISH (1 - 2 COATS)</td> </tr> <tr> <td>Dulux Epoxy Zinc Phosphate Primer (A580-16252)</td> <td>Dulux Hi Build Epoxy Tank Coating (A580)</td> <td>Dulux Epoxy Chemical Resistant Finish (A430) Or Dulux Textaclad Acrylic (A404)</td> </tr> </table>	PRIMER (1 COAT)	INTERMEDIATE or FINISH (1-2 COATS)	FINISH (1 - 2 COATS)	Dulux Epoxy Zinc Phosphate Primer (A580-16252)	Dulux Hi Build Epoxy Tank Coating (A580)	Dulux Epoxy Chemical Resistant Finish (A430) Or Dulux Textaclad Acrylic (A404)
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	<p>It is important to ensure that the substrate temperature is at least 3°C above dew point.</p> <p>The minimum temperature for application is 10°C. Relative humidity should not exceed 85%.</p> <p>Note: Where the Dulux Epoxy Zinc Phosphate Primer has been left exposed over a period of time, it will be necessary to thoroughly prepare the surface by removing all dirt, grease, oil, wax, salts etc before the overpainting. Where rusting of peaks has occurred on blast cleaned steel, flash blasting or thorough manual preparation followed by spot priming with an appropriate primer will be required.</p>						
	 Blast cleaning  Ensure good surface profile  Use abrasive paper						

PRECAUTION

SAFETY, HEALTHY AND ENVIRONMENTAL INFORMATION	<p>FLAMMABLE</p> <p>Toxic to aquatic organisms, may cause long-term adverse effects in the aquatic environment.</p> <p>Contains Epoxy constituents. See information provided by the manufacturer.</p> <p>Harmful by inhalation and in contact with skin.</p> <p>Irritating to eyes and skin. May cause sensitisation by skin contact.</p> <p>In case of contact with eyes, rinse immediately with plenty of water and seek medical advice.</p>
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	<p>If swallowed seek medical advice immediately and show this container or label.</p> <p>If swallowed, rinse mouth with water (Only if person is conscious). Keep away from food, drinks, animal feed and out of the reach of children.</p> <p>Keep away from combustible material.</p> <p>Container must be stored in a cool and shaded place. It must be tightly closed in a secure, upright position. Do not breathe dust.</p> <p>Work in a well-ventilated area and do not breathe in vapour or spray. When applying paint, wear suitable protective clothing, gloves and eye/face protection.</p> <p>In case of fire use foam, dry powder, AFFF, CO2 – Never use water.</p> <p>In case of a spillage, contain and collect spillage using sand or earth and do not empty into watercourses, drains or the environment.</p> <p>Dispose of any paint waste in accordance with the appropriate Environmental Quality Regulations.</p> <p>Refer to Dulux Product Safety Data Sheet for further details.</p> <p>In case of emergency, refer to Emergency Incident Response Hotline 1800 80 6187.</p>							
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