

CONGARD[®]

Single Pack Alkyd Primer-Finish

PC 640

- FEATURES**
- SELF PRIMING TOPCOAT
 - GLOSS FINISH
 - REQUIRES MINIMAL SURFACE PREPARATION
 - CONTAINS ZINC PHOSPHATE
 - RAPID DRYING
 - AVAILABLE IN OVER 2,500 PASTEL COLOURS

USES CONGARD[®] is a single pack, air drying, high build coating based on a modified alkyd resin. The incorporation of rust inhibitive zinc phosphate pigment enables direct application to blast or chemically cleaned steel, providing both corrosion protection and a decorative finish in one coat. CONGARD[®] should be considered as an economical finishing alternative in sheltered or mild environments or for simple refurbishing after repair. Typical areas of application include structural frames and trusses for factories and warehouses, farm or heavy engineering equipment and shipping containers.

SPECIFICATIONS

RESISTANCE GUIDE

HEAT RESISTANCE	Up to 65°C dry heat.	ALKALIS	Not recommended where fumes, splash or spillage may occur.
WEATHERABILITY	On exterior exposure some chalking may also occur. This will not detract from the protective properties of the coating.	SALTS	Unaffected by splash and spillage of neutral salt solutions.
SOLVENTS	Resists alcohol, mineral turpentine and similar solvents. Esters, ketones, ethers, chlorinated solvents or similar strong solvents are liable to attack the coating.	WATER	Resists rain and condensation. Not recommended for permanently damp or immersed exposure.
ACIDS	Not recommended where fumes, splash or spillage may occur.	ABRASION	Good when fully cured.

TYPICAL PROPERTIES AND APPLICATION DATA

CLASSIFICATION	Modified alkyd primer-finish	APPLICATION CONDITIONS	Min	Max	
FINISH	Gloss	Air Temperature	10°C	45°C	
COLOUR	White, LF Golden Yellow, a range of pastel tinted colours and MTO factory made colours.	Substrate Surface Temperature	10°C	45°C	
		Relative Humidity		85%	
COMPONENTS	One		Min	Max	Recom.
SOLIDS BY VOLUME	38% (White)	Wet film per coat (microns)	160	240	200
VOC LEVEL	<540 g/L (White)	Dry film per coat (microns)	60	90	75
FLASH POINT	5°C	SUITABLE SUBSTRATES	Abrasive blast cleaned, hand cleaned or power tool cleaned steel.		
POT LIFE	Not applicable	APPLICATION METHODS	Conventional, airless spray or air assisted spray.		
MIXING RATIO (V/V)	Single pack				
THINNER	965-63020 Dulux [®] CR Reducer				
PRODUCT CODE	878-63001 White/Light Base 878-39141 LF Golden Yellow				

Drying characteristics at 75 microns dry film thickness

Temperature	Humidity	Touch	Handle	Full Cure	Overcoat	
					Min	Max
25° C	50%	15 Minutes	2 Hours	7 Days	4 Hours	8 Hours

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

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

TYPICAL SPREADING RATE AT RECOMMENDED DRY FILM BUILD

A spreading rate of 5.0 sq. metres per litre corresponds to 75 microns dry film thickness assuming no losses. Practical spreading rates will vary depending on such factors as method and conditions of application and surface roughness.

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TYPICAL SYSTEMS

(The typical systems are offered as a guide only and are not to be used as a specification. It is recommended that the specific needs of a project be discussed with a Dulux Protective Coatings Consultant.)

SURFACE	PREPARATION GUIDE	SYSTEM		DRY FILM THICKNESS
STEEL	Hand or Power tool clean AS1627.2 St 3 Abrasive blast AS1627.4 Class 2	1st Coat	CONGARD [®]	75 Microns

SURFACE PREPARATION Round off all rough welds, sharp edges and remove weld spatter. Remove grease, oil and other contaminants in accordance with AS1627.1. Rust, millscale, oxide deposits and old paint films on metal surfaces should be removed by hand or power tool (AS1627.2 St 3) cleaning as a minimum. Coating performance is proportional to the degree of surface preparation and abrasive blast cleaning to a minimum AS1627.4 Class 2 is preferred for more severe environments. Remove all dust by brushing or vacuum cleaning.

APPLICATION Stir each can thoroughly until the contents are uniform. Use of a power mixer is recommended. Ensure bases have been tinted to the correct colour before use – DULUX ASSUMES NO RESPONSIBILITY FOR THE APPLICATION OF AN INCORRECT COLOUR. Box all containers before use to ensure colour consistency. Remix thoroughly before using.

BRUSH/ROLLER Recommended only for spot patching on rivets, seams, etc. When brushing and rolling additional coats may be required to attain the specified thickness.

CONVENTIONAL SPRAY Thin up to 50ml/litre with Dulux[®] CR Reducer (965-63020) to aid atomisation. Add only enough thinner to achieve atomisation. Apply in multiple wet coats overlapping each pass 50%.

Typical Set-up

Graco Delta Gun:	1.8mm (239543)
Pressure at Pot:	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 30:1 President with a fluid tip of 17 thou (0.43mm) 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 Dulux[®] CR Reducer (965-63020) may be added to ease 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[®] representative for advice prior to painting. Do not apply in conditions outside the parameters stated in this document without the express 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. Overcoating can occur 4 hours after the initial application or before 8 hours. Failing to observe these limits may result in "frying" or wrinkling. If in doubt test a small inconspicuous area first. Allow longer times under cold conditions. Check a small area before commencing recoat work. Do not apply over scale bearing steel. Do not apply on structures subject to sustained surface temperatures above 65°C or where spillage of strong solvent or oils may occur. Do not exceed a spreading rate of 5.0 sq. meters per litre. Abrasive blast cleaned surfaces must be primed within 4 hours. This product is not suitable to be topcoated by two pack heavy-duty coatings or directly applied over galvanised iron, or zinc rich coatings.

CLEAN UP Clean all equipment with Dulux[®] CR Reducer (965-63020) immediately after use.

OVERCOATING Aged coating should be tested for lifting by a method appropriate for the coating thickness, for example 'X' cut or cross-hatch methods. If it lifts, remove it. The surface must be free of oil, grease and other contaminants. High-pressure water wash at 8.3 to 10.3 MPa (1,200 - 1,500 p.s.i.) to remove loosely adhering chalk and dust. Abrasion may be required depending on surface condition. If the maximum overcoat interval is exceeded then the surface MUST be abraded to ensure maximum intercoat adhesion.

SAFETY PRECAUTIONS Read Data Sheet, Material Safety Data Sheet and any precautionary labels on containers.

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 spray painting, users should comply with the provisions of the 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, CO₂ 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.

MATERIAL SAFETY DATA SHEET is available from Customer Service (132377) or www.duluxprotectivecoatings.com.au

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PACKAGING	Available in 15 litre pails
TRANSPORTATION WEIGHT	1.23 kg/litre (White)
DANGEROUS GOODS	Class 3 UN 1263

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