

ZINC RICH 1P

One Pack Zinc Rich Phenoxo Primer

PC 102

- FEATURES**
- SINGLE PACK "COLD GALVANISING" PRIMER
 - MAY BE OVERCOATED WITH MOST HEAVY DUTY TOPCOATS
 - EXCELLENT PRIMER FOR POWDER COATING

USES Zinc Rich 1P is recommended as a convenient sacrificial primer in conjunction with heavy duty finishes to increase the corrosion resistance and life of any system or as a single application protective coating. Zinc Rich 1P is most often used as a general primer for structural steelwork in industrial and commercial environments especially for the protection of tankage, pipelines, cranes and bridges. It is also recommended for the repair of damaged galvanised steel and wrought iron balustrades and railings and under powdercoat finishes.

SPECIFICATIONS

RESISTANCE GUIDE

HEAT RESISTANCE	Up to 200°C dry heat. Not recommended for hot, wet conditions.	ALKALIS	Should not be used in strongly alkaline environments.
WEATHERABILITY	Withstands exterior exposure when suitably topcoated.	SALTS	Resists most neutral and alkali salts.
SOLVENTS	Resists splash and spillage of most aromatic hydrocarbon solvents.	WATER	Suitable for damp environments. Not recommended for immersion conditions.
ACIDS	Not recommended for acid conditions.	ABRASION	Very good for single pack coating.

TYPICAL PROPERTIES AND APPLICATION DATA

CLASSIFICATION	Zinc rich, single pack phenoxo	APPLICATION CONDITIONS			Min	Max	
FINISH	Matt	Air Temperature	5°C	45°C			
COLOUR	Grey	Substrate Surface Temperature	5°C	45°C			
COMPONENTS	One	Relative Humidity				85%	
SOLIDS BY VOLUME	24.5%				Min	Max	Recom.
VOC LEVEL	<670 g/L	Wet film per coat (microns)	210	250	210		
FLASH POINT	-7°C	Dry film per coat (microns)	50	60	50		
POT LIFE	Not Applicable	SUITABLE SUBSTRATES	Abrasives blast cleaned steel. Prepared galvanised steel.				
MIXING RATIO (V/V)	Single Pack	TOPCOATS	Powder Coating and wide range of single and two pack products.				
THINNER	920-08925 Dulux [®] Epoxy Thinner Powder Coatings 965-08410 DUTHIN [®] 540	APPLICATION METHODS	Brush, roller, conventional, airless spray or air assisted spray.				
PRODUCT CODE	812-19530						

Drying characteristics at 50 microns dry film thickness

Temperature	Humidity	Touch	Handle	Full Cure	Overcoat	
					Min	Max
25° C	50%	5 Minutes	15-30 Minutes	7 Days	4 Hours	Indefinite

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

TYPICAL SPREADING RATE AT RECOMMENDED DRY FILM BUILD

A spreading rate of 4.7 sq. metres per litre corresponds to 50 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	Abrasive blast AS1627.4 Class 2.5	1st Coat	Zinc Rich 1P	50 Microns
		2nd Coat	DUREMAX® GPE	125 Microns
		3rd Coat	LUXATHANE® R	50 Microns
GALVANISED STEEL	Clean, degrease and abrade surface	Spot-prime	Zinc Rich 1P	50 Microns
		2nd Coat	DUREMAX® GPE	125 Microns
		3rd Coat	WEATHERMAX® HBR	100 Microns

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. Rust, millscale, oxide deposits and old paint films on metal surfaces must be removed by abrasive blast cleaning to a minimum of AS1627.4 Class 2.5. For less demanding uses where abrasive blast cleaning is not possible power tool clean to a minimum of AS1627.2. Class 2. Remove all dust by brushing or vacuum cleaning.

Galvanised steel:

Round off all rough welds, sharp edges and remove weld spatter. Remove grease, oil and other contaminants in accordance with AS1627.1. Abrade the surface with abrasive paper or whip blast. Remove all dust by vacuum cleaning.

APPLICATION

Stir contents of the can thoroughly with a broad flat stirrer using a stirring, lifting action or use a power mixer. Remix thoroughly before using and continue mixing during application.

BRUSH/ROLLER

Suitable for small areas only. Apply even coats of the mixed material to the prepared surface. Thin if necessary with up to 100 ml/litre with Dulux® Epoxy Thinner (920-08925) to ease application. When brushing and rolling additional coats may be required to attain the specified thickness.

CONVENTIONAL SPRAY

Thin up to 100ml/litre with Dulux® Epoxy Thinner (920-08925) to aid atomisation. For use under Powder Coatings use DUTHIN® 540. Ensure paint is regularly agitated during application to prevent separation.

Typical Set-up

Graco Delta Gun:	1.8mm (239543)
Pressure at Pot:	100-140 kPa (15-20 p.s.i.)
Pressure at Gun:	280-420 kPa (40-60 p.s.i.)

AIRLESS SPRAY

Standard airless spray equipment such as a Graco 33:1 Bulldog with a fluid tip of 15-19 thou (0.38-0.48mm) and a tip pressure of 14.8-16.9 MPa (2,100-2,400 psi). Ensure paint is regularly agitated during application to prevent separation.

PRECAUTIONS

This is an industrial product designed for use by experienced Protective Coatings 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. The rate of cure is dependent upon temperature. Do not apply at temperatures below 5°C. Do not apply at relative humidity above 85% or when the surface is less than 3°C above the dewpoint. Topcoats of a saponifiable nature such as alkyds must never be applied directly to ZINC RICH 1P. When used under powder coatings DUTHIN® 540 must be used.

CLEAN UP

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

SAFETY PRECAUTIONS

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

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.

STORAGE

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.

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 4 litre cans
TRANSPORTATION WEIGHT	1.57 kg/litre
DANGEROUS GOODS	Class 3 UN 1263

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