

ZINCANODE[®] 402

Two Pack Zinc Rich Epoxy Primer

PC 122

- FEATURES**
- OVERCOAT WITH EPOXIES, POLYURETHANE, CHLORINATED RUBBERS WITHOUT SPECIAL TECHNIQUES
 - ECONOMICAL AND USER FRIENDLY EPOXY ZINC COATING
 - PROVIDES EXCELLENT CORROSION PROTECTION
 - RAPID DRY AND OVERCOAT TIMES
 - SUITABLE FOR USE IN ENVIRONMENTS UP TO 200°C

USES ZINCANODE[®] 402 is a two-pack epoxy zinc rich primer designed to provide exceptional corrosion resistance in harsh exposures by sacrificial methods.
ZINCANODE[®] 402 is recommended for use over abrasive blast cleaned steel surfaces in most harsh environments, especially where overcoating is required without special mist or seal coat techniques.
ZINCANODE[®] 402 offers ease of application, high film builds without mud-cracking and exceptional adhesion to field weld areas cleaned by power sanding or power wire brushing. It is specified for use in power generation plants, bulk handling equipment and oil refineries. Also in mining and chemical processes, offshore structures and exposed pipelines.

SPECIFICATIONS Approved to APAS 2916
AS/NZS 3750-9 Type 2

RESISTANCE GUIDE

HEAT RESISTANCE	Up to 200°C dry heat.	ALKALIS	Do not use in strongly alkaline conditions unless suitably topcoated.
WEATHERABILITY	Epoxy coatings may yellow with time. On exterior exposure some chalking may also occur. This will not detract from the protective properties of the coating. Use a weatherable topcoat if required for appearance.	SALTS	Excellent resistance to neutral and alkali salts when suitably topcoated.
SOLVENTS	Resists splash and spillage of aromatic hydrocarbon solvents and most common alcohols.	WATER	Suitable for immersion in fresh and salt water when suitably topcoated.
ACIDS	Not recommended for acid conditions.	ABRASION	Very good when fully cured.

TYPICAL PROPERTIES AND APPLICATION DATA

CLASSIFICATION	Zinc Rich Epoxy Primer	APPLICATION CONDITIONS	Min	Max
FINISH	Matt	Refer to page 2		
COLOUR	Grey-Green			
COMPONENTS	Two			
SOLIDS BY VOLUME	Refer to page 2			
VOC LEVEL	Refer to page 2			
FLASH POINT	Base 32°C, Hardeners 23-27°C			
POT LIFE	Refer to page 2			
MIXING RATIO (V/V)	Part A : 4 Part B : 1			
THINNER	920-08925 Dulux [®] Epoxy Thinner			
PRODUCT CODE	730-81386 Part A 976-63033 Standard Hardener 976-H0114 Cold Cure Hardener	Wet film per coat (microns)	Min	Max
		Dry film per coat (microns)		Recom.
		Refer to page 2		
		SUITABLE SUBSTRATES	Abrasive blast cleaned steel.	
		TOPCOATS	Single and two pack products.	
		APPLICATION METHODS	Conventional, airless spray or air assisted spray. Brush and roller for small areas.	

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Standard Hardener							
COATING THICKNESS				APPLICATION CONDITIONS			
	Min	Max	Recom.		Min	Max	
Wet film per coat (microns)	125	165	155	Air Temperature	10°C	45°C	
Dry film per coat (microns)	60	80	75	Substrate Surface Temperature	10°C	45°C	
				Relative Humidity		85%	
SOLIDS BY VOLUME	48%			POT LIFE	8 Hours (4L, 25°C)		
VOC LEVEL	<460 g/L						
Drying characteristics at 75 microns dry film thickness							
Temperature	Humidity	Touch	Handle	Full Cure	Overcoat		Max
10° C	50%	2 Hours	17 Hours	7 Days	17 Hours	Indefinite	
15° C	50%	2 Hours	10 Hours	7 Days	10 Hours	Indefinite	
25° C	50%	1 Hour	5 Hours	7 Days	5 Hours	Indefinite	
TYPICAL SPREADING RATE AT RECOMMENDED DRY FILM BUILD				A spreading rate of 6.4 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.			

Cold Cure Hardener							
COATING THICKNESS				APPLICATION CONDITIONS			
	Min	Max	Recom.		Min	Max	
Wet film per coat (microns)	125	165	155	Air Temperature	10°C	45°C	
Dry film per coat (microns)	60	80	75	Substrate Surface Temperature	10°C	45°C	
				Relative Humidity		85%	
SOLIDS BY VOLUME	48%			POT LIFE	8 Hours (4L, 25°C)		
VOC LEVEL	<460 g/L						
Drying characteristics at 75 microns dry film thickness							
Temperature	Humidity	Touch	Handle	Full Cure	Overcoat		Max
10° C	50%	60 mins	8 Hours	7 Days	8 Hours	Indefinite	
25° C	50%	30 mins	4 Hours	7 Days	4 Hours	Indefinite	
TYPICAL SPREADING RATE AT RECOMMENDED DRY FILM BUILD				A spreading rate of 6.4 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.			

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

* When used for non-immersion conditions. Refer to PRECAUTIONS section for overcoating intervals and requirements for immersion service.

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 Abrasive blast to AS1627.4 Class 3.0 for immersion service	1st Coat	ZINCANODE® 402	75 Microns
		2nd Coat	FERREKO® No 3	100 Microns
		3rd Coat	FERREKO® No 3	100 Microns
		1st Coat	ZINCANODE® 402	75 Microns
		2nd Coat	DUREMAX® GPE	125 Microns
		3rd Coat	WEATHERMAX™ HBR	100 Microns
		1st Coat	ZINCANODE® 402	75 Microns
		2nd Coat	LUXATHANE® R	50 Microns

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SURFACE PREPARATION	<p><u>Steel:</u> 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. Immersed steel must be prepared to AS1627.4 Class 3.</p>
APPLICATION	Stir each can thoroughly until the contents are uniform. Use of a power mixer is recommended. Mix the contents of both packs together thoroughly using a power mixer and allow to stand for 10 minutes. Ensure the clean-up solvent is available before commencing application. Remix thoroughly before using and continue mixing during application.
BRUSH/ROLLER	For small areas only. Apply even coats of the mixed material to the prepared surface. Thinning is not normally required, however, up to 50ml/litre of Dulux [®] Epoxy Thinner (920-08925) can be added to ease application. When brushing and rolling additional coats may be required to attain the specified thickness.
CONVENTIONAL SPRAY	Thinning is not normally required, however, up to 50ml/litre of Dulux [®] Epoxy Thinner (920-08925) can be added to ease application. Ensure paint is regularly agitated during application to prevent separation.
AIRLESS SPRAY	<p><u>Typical Set-up</u> Graco Delta Gun: 1.8mm (239543) Pressure at Pot: 70-105 kPa (10-15 p.s.i.) Pressure at Gun: 380-415 kPa (55-60 p.s.i.)</p> <p>Standard airless spray equipment such as a Graco 33:1 Bulldog or 45:1 Xtreme 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. Ensure paint is regularly agitated during application to prevent separation. Thinning is not normally required but up to 50 ml/litre of Dulux[®] Epoxy Thinner (920-08925) may be added to ease application.</p>
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. Freshly mixed material must not be added to material that has been mixed for some time. The rate of cure is dependent upon temperature. 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. When used for immersion conditions the maximum overcoat interval is 3 days at 25°C. The coating MUST be fully cured and solvent free prior to being placed under immersion conditions. For best results in water immersion conditions replace Dulux [®] Epoxy Thinner (920-08925) with CR Reducer (965-63020). Topcoats of a saponifiable nature such as alkyds must never be applied directly to ZINCANODE [®] 402.
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	<p>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.</p>
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, 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.

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

Dulux Protective Coatings a division of DuluxGroup (Australia) Pty Ltd 1956 Dandenong Road, Clayton 3168 A.B.N. 67 000 049 427 Dulux, Zincanode, Ferreko, Duremax, Weathermax and Luxathane are registered trade marks of DuluxGroup (Australia) Pty Ltd.	<table border="1"> <tr> <td>PACKAGING</td> <td>Available in 4 litre and 10 litre packs</td> </tr> <tr> <td>TRANSPORTATION WEIGHT</td> <td>2.12 kg/litre (Average of components)</td> </tr> <tr> <td>DANGEROUS GOODS</td> <td>Part A: Class 3 UN 1263 Part B: Class 3 UN 1263</td> </tr> </table>	PACKAGING	Available in 4 litre and 10 litre packs	TRANSPORTATION WEIGHT	2.12 kg/litre (Average of components)	DANGEROUS GOODS	Part A: Class 3 UN 1263 Part B: Class 3 UN 1263
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