

# 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**

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

**TYPICAL PROPERTIES AND APPLICATION DATA**

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

**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.

# Zinc Rich 1P

## 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.

<b>APPLICATION</b>	Stir each can thoroughly until the contents are uniform. Use of a power mixer is recommended. 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.  <u>Typical Set-up</u> 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 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.
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.
<b>OVERCOATING</b>	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.
<b>SAFETY PRECAUTIONS</b>	<b>Read Data Sheet, Material Safety Data Sheet and any precautionary labels on containers.</b> 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, CO <sub>2</sub> 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](http://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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