



# Hi Build Zinc Phosphate Primers

Anticorrosive primers for steel fabrications

## Description

- Alkyd anticorrosive primers containing zinc phosphate

## Properties

- Fast drying
- Corrosion resistant
- Short to medium term exterior protection

## Typical Applications

- Structural steel
- Metal fabrications, (e.g. trailers)

## General Data

- |                       |  |
|-----------------------|--|
| ▪ Weather resistance  | Suitable for short to medium term outdoor exposure without topcoating              |
| ▪ Solvent resistance  | Resists splashes of hydrocarbon solvents; not recommended for continuous immersion |
| ▪ Chemical resistance | Poor   |
| ▪ Abrasion resistance | Fair   |
| ▪ Heat resistance     | up to 120°C dry heat   |
| ▪ Suitable topcoats   | Rapid Enamel, Purlenamel, Implement Enamel, Auto Enamel                            |

## Specifications (at 25°C and 50% relative humidity)

- Resin type.....Oil-modified Alkyd
- Solids content.....40% (by volume)
- Typical film thickness (per coat).....30 microns (dry)  
75 microns (wet)
- Theoretical coverage.....12 - 14m<sup>2</sup> / L @ 30 microns dry film thickness
- Touch dry.....10 - 15 minutes
- Hard dry.....24 hours
- Recoating..... may be topcoated with enamel finishes after 2 hours
- Baking..... 15 - 20 min. @120°C
- Gloss..... Low satin
- Colours.....Blue, Grey
- Shelf life..... minimum 12 months (in cool, dry conditions)

## Surface Preparation

- Bare steel surfaces should be degreased, then subjected to abrasive blasting (to AS 1627.4 Class 2½) or abrasion by power cleaning (e.g. disc sander) to AS 1627.2 – 2002.

## Mixing recommendation

- Mix the entire contents of the can before decanting
- Stir thoroughly with a broad paddle or mechanical mixer to ensure even consistency of the product
- Thin up to 30% by volume with Wagon Paints' T4 Enamel Thinner (see Application directions), and stir as above

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## Application

- May be spray applied using airless or conventional air spray equipment
- Small areas may be coated by brush
- **Airless Spray** nozzle size.....0.33 – 0.38 mm  
nozzle pressure.....2000 – 2500 psi (14 - 17mPa)  
volume of thinner.....up to 10%
- **Air Spray** nozzle size.....1.6 – 2.0 mm  
nozzle pressure.....45 – 60 psi (300 - 400kPa)  
volume of thinner.....up to 30%
- **Cleaning solvent** ..... T4 Enamel Thinner or T12 Gunwash

## Safety precautions

- **Refer to the relevant Material Safety Data Sheet**
- Contents are flammable – keep away from all ignition sources
- Avoid contact with skin and eyes – when mixing, wear gloves and goggles
- When spraying, ensure adequate ventilation and wear appropriate protective clothing and equipment

**Packaging Group III**

**UN No. 1263**

**Pack sizes**

20 litre, 200 litre

Authorised:

A. De Mello, Sales Manager  
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These technical data and recommendations are based on tests and information believed to be accurate at the time of printing. They should not be construed as containing any warranty, either expressed or implied. Users should conduct their own tests to determine final suitability of this product.



**Wagon Paints**

**5 Stephenson Road, Bayswater North, Victoria 3153 Australia**

**Phone: 61 3 97291344 Fax: 61 3 97202179 Email: sales@wagonpaints.com.au**