

ZINCANODE[®] 202

Two Pack Zinc Rich Epoxy Primer

PC 120

- FEATURES**
- RAPID DRY AND OVERCOAT TIMES
 - LONG SERVICE HISTORY IN INDUSTRIAL & MARINE EXPOSURES
 - TOP COATING REQUIRES NO SPECIAL MIST COATING TECHNIQUES
 - SUITABLE FOR USE IN ENVIRONMENTS UP TO 200°C
 - PROVIDES EXCELLENT CORROSION PROTECTION

USES ZINCANODE[®] 202 is a two pack epoxy zinc rich primer which incorporates a high level of finely divided zinc to provide excellent corrosion resistance by sacrificial protection. On curing, a hard abrasion resistant coating results, which is particularly suitable for overcoating with heavy duty finishes without the need for mist coating or use of a tie coat. Dry film zinc levels exceed Australian Standard requirements.

ZINCANODE[®] 202 has been widely used for the protection of industrial and chemical plant, in particular - oil refineries, power generation plant, mining facilities and bulk handling equipment. Ideal touch up primer for inorganic zinc silicates and galvanising in aggressive environments.

SPECIFICATIONS Approved to APAS 0014/2.
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	Air Temperature	10°C	45°C	
COLOUR	Grey	Substrate Surface Temperature	10°C	45°C	
COMPONENTS	Two	Relative Humidity		85%	
SOLIDS BY VOLUME	47%		Min	Max	Recom.
VOC LEVEL	<450 g/L	Wet film per coat (microns)	95	130	105
FLASH POINT	23°C mixed	Dry film per coat (microns)	45	60	50
POT LIFE	8 Hours (25°C)	SUITABLE SUBSTRATES	Abrasive blast cleaned steel.		
MIXING RATIO (V/V)	Part A : 4 Part B : 1	TOPCOATS	Single and two pack products.		
THINNER	920-08925 Dulux [®] Epoxy Thinner	APPLICATION METHODS	Conventional, airless spray or air assisted spray. Brush and roller in small areas.		
PRODUCT CODE	730-63029 Part A 976-63047 Hardener				

Drying characteristics at 50 microns dry film thickness

Temperature	Humidity	Touch	Handle	Full Cure	Min	Overcoat	Max*
25° C	50%	30 Minutes	2-3 Hours	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.

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

TYPICAL SPREADING RATE AT RECOMMENDED DRY FILM BUILD

A spreading rate of 9.3 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.

ZINCANODE® 202

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	ZINCANODE® 202	50 Microns
		2nd Coat	FERREKO® No 3	100 Microns
		3rd Coat	FERREKO® No 3	100 Microns
		1st Coat	ZINCANODE® 202	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.

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 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 50 ml/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

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: 70-105 kPa (10-15 p.s.i.)
 Pressure at Gun: 380-415 kPa (55-60 p.s.i.)

AIRLESS SPRAY

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.

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 Dulux® CR Reducer (965-63020). Topcoats of a saponifiable nature such as alkyls must never be applied directly to ZINCANODE®202.

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 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 4 litre packs
 TRANSPORTATION WEIGHT 2.5 kg/litre (Average of components)
 DANGEROUS GOODS Part A: Class 3 UN 1263
 Part B: Class 3 UN 1263

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