

DESCRIPTION

- a single pack fast air drying, high build modified alkyd zinc phosphate primer

PRINCIPAL CHARACTERISTICS

- excellent corrosion resistance
- quick drying
- high build achievable in one coat application
- excellent adhesion to suitably prepared steel surfaces
- suitable for top coating with Wattyl Industrial Enamels for both new and maintenance work
- may be overcoated with selected coloured two-pack products including Poly U400, Poly U750, Colourthane C-Series and Paracryl IF540 when applied direct to mild steel

COLOURS AND GLOSS

- Grey, Red Oxide, Blue, Mustard Yellow – flat

RECOMMENDED FILM THICKNESS (PER COAT)

	Minimum	Maximum	Typical
Dry film thickness microns	50	75	50
Wet film thickness microns	120	180	120
Theoretical spreading rate m ² /l	8.4	5.6	8.4

BASIC DATA AT 25 °C

- solids content approx.....42% by volume
- touch dry after15 minutes
- full cure5 days
- temperature resistance125 °C (dry)

SURFACE PREPARATION

- all surfaces to be coated must be clean, dry and free from chalking and contamination
- oil and grease should be removed from all surfaces in accordance with AS 1627.1 solvent cleaning

MILD STEEL

- blast clean in accordance with AS 1627.4 to Sa 2½ minimum (AS 1627.9), surface profile 35-50 microns
- if oxidation occurs between blasting and application, the surface should be reblasted to the specified visual standard
- surface defects revealed by the blast cleaning process should be ground, filled or treated in the appropriate manner
- power tool clean in accordance with AS 1627.2 to St 2 minimum (AS 1627.9)

PREVIOUS SUITABLE COAT

- dry and free from chalking and contamination and sufficiently roughened if necessary
- substrate temperature must be at least 3°C above dew point
- relative humidity should not exceed 85%

APPLICATION INSTRUCTIONS

- stir well before use with a flat bladed stirrer or mechanical mixer
- the temperature of the paint must be above 15°C, otherwise extra thinner may be required to obtain application viscosity
- too much thinner will result in lower sag resistance and slower cure
- adequate ventilation must be continuously maintained during application and curing
- Valspar recommends the use of coating inspection reports in compliance with AS/NZS 3894.10,11,12 refer to Information Sheet I-20 for more information
- for recommendations outside those contained in this data sheet, refer to Valspar

APPLICATION METHODS

- **AIRLESS SPRAY**
 - recommended thinnerL700 Industrial Enamel Thinner
 - volume of thinner0-3%
 - nozzle orifice approx.0.46mm (0.018 inch)
 - nozzle pressure15 MPa (2100 psi)
- **AIR SPRAY**
 - recommended thinnerL700 Industrial Enamel Thinner
 - volume of thinner0-10%
 - nozzle orifice approx.1.8- 2.0mm
 - nozzle pressure0.3-0.4 MPa (50-60 psi)
- **BRUSH/ROLLER**
For spot repair and stripe coating only
 - recommended thinnerMineral Turps
 - volume of thinner0-5%
 - The maximum dry film thickness that can be achieved when brushing/rolling is 40 microns
 - Multiple coats may be required to achieve the recommended dry film thickness
- **CLEANING SOLVENT**..... L700 Industrial Enamel Thinner

SAFETY PRECAUTIONS

- flammable. Avoid contact with heat and naked flame
- avoid contact with skin and eyes
- use gloves, mask and goggles during application.
- provide adequate ventilation when using in confined spaces
- this product is intended for use in industrial situations by professional applicators in accordance with the advice given on this sheet. All work involving the use and application of this product should be carried out in compliance with all relevant Health, Safety & Environmental standards and regulations and must not be used without reference to the Material Safety Data Sheet (MSDS)

ADDITIONAL DATA

Overcoating Table

Minimum and maximum overcoating intervals with Duranamel PR9, Duranamel BR22, All Purpose Enamel, Agricultural Enamel

Interval	5 °C	15 °C	25 °C	35 °C
Min	8 hrs	6 hrs	4 hrs	2 hrs
Max	Unlimited			

* ensure surface is dry and free of chalking and contamination

Minimum and maximum overcoating intervals with Poly U400, Poly U750, Paracryl IF540 and Colourthane C-Series

Interval	5 °C	15 °C	25 °C	35 °C
Min	16	10	6	3
Max	Unlimited			

* ensure surface is dry and free of chalking and contamination

Curing Table

Paint temperature	5 °C	15 °C	25 °C	35 °C
Dry to handle	5 hrs	3 hrs	2 hrs	1 hr
Full cure	10 days	7 days	5 days	3

* adequate ventilation must be continuously maintained during application and curing

PRECAUTIONS

- for recommendations outside those contained in this data sheet, refer to Valspar

PRODUCT COMPATIBILITY

Topcoats

- Duranamel BR22
- All Purpose Enamel
- Agricultural Enamel
- Poly U400 (colours)
- Poly U750 (colours)
- Paracryl IF540 (colours)
- Colourthane C-Series (colours)

STORAGE AND PACKAGING

- shelf life at least 12 months 25 °C
- all components shall be stored in a dry internal environment at between 5 °C and 35 °C
- packaging: 20 litres (all colours), 4 and 200 litres (grey only- made to order)
- product line: 2002

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