

TECHNICAL DATA SHEET TDS: TMQ113
2 PACK ZINC PHOSPHATE PRIMER **514/Q113/224, 24**

DESCRIPTION:

Teamac 2 Pack Zinc Phosphate Primer is a two-pack epoxy zinc phosphate primer for application to steel which is clean and free from scale and/or rust.

RECOMMENDED USE:

Teamac 2 Pack Zinc Phosphate Primer is used for application to blast cleaned and other suitably prepared steel surfaces. It is not suitable for use as a weld through blast primer. Provided the steel has been cleaned effectively an outstanding bond is formed between primer and metal.

AVAILABILITY:

5 litre units comprising of two packs

FINISH:

Eggshell

COLOUR:

Grey, Red

TYPICAL S.G. (SPECIFIC GRAVITY):

1.25 @ 20 °C

VOLUME SOLIDS:

42

WET FILM THICKNESS W.F.T

85 to 180 microns

DRY FILM THICKNESS D.F.T

35 to 75 microns

EXPECTED SPREADING RATE:

12 sq.m / litre

@ 35 microns D.F.T

5.5 sq.m / litre

@ 75 microns D.F.T

The practical spreading rate may be lower as this depends on factors such as the porosity and roughness of the surface to be painted and material losses during application.

TYPICAL VISCOSITY:

N/A

FLASH POINT:

25 °C (closed cup)

CURE TIME: @ RECOMMENDED D.F.T

Initial cure: 20 to 30 mins @ 20 °C

Hard dry: 2 to 4 hours @ 20 °C

Full cure: 3 - 5 days @ 20 °C

Low temperature and high humidity will adversely affect application, curing and performance of any coating.

POTLIFE:

24 hours @ 20 °C

Pot Life - Once the parts are mixed together the material has to be used within the time stated.

MINIMUM OVERCOATING TIME:

2 to 4 hours

APPLICATION SPECIAL CONDITIONS:

Do not apply below 5°C or at humidity levels above 80 to 90%

VOC CONTENT:

500 g / litre

VOC's (Volatile Organic Compounds) contribute to atmospheric pollution

APPLICATION DETAILS:

Application N/A
restrictions

Method: Airless Spray Brush

Thinner Do not thin Do not thin
(Max vol):

For further advice contact Teamac Technical Services on +44(0)1482 320194

The physical constants are subject to normal manufacturing tolerances.

"COVERING OUR CUSTOMERS' NEEDS SINCE 1908"

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Nozzle size: .021" - .027"

Nozzle pressure: 1800 - 2300 psi

Cleaning solvent: THINNERS TH4

Recoat interval: 2 to 4 hours

PRECEDING COAT:

Can be applied over 2 pack zinc phosphate blast primers which are free from contamination.

SUBSEQUENT COAT:

Most one-pack and two-pack materials.

REMARKS:

Ensure mixing instructions are followed.

SURFACE PREPARATION:

Ensure all surfaces are clean, dry and free from grease, oil and any other contaminants. Bare steel should be free from dust, rust and scale. Blast cleaning to SA 2½ is recommended. If blast cleaning is impractical, mechanical cleaning should be employed as hand cleaning does not clean the steel to the required degree. Any oil or grease should be removed with solvent before de-rusting. Where blast cleaning is carried out after assembly, special attention must be paid to edges, corners, nuts, bolts welds, etc. Welds should, if necessary be ground and all weld spatter, slag etc. must be removed.

MIXING INSTRUCTIONS:

By volume, mix 4 parts of the base with 1 part of the activator, as the ratio supplied. These should be thoroughly mixed together, preferably by slow speed electric mixer and allow to stand for 20 minutes before use. Ensuring the material is thoroughly mixed is very important - poorly mixed product can lead to soft spots and uncured coatings. Thinning is not normally required for airless spray systems. Use within 24 hours. Clean and flush equipment immediately after use to prevent the paint solidifying in guns, pots and lines.

APPLICATION CONDITIONS:

Should not be carried out when the ambient temperature is below 5 °C (Please note drying will be retarded below 10 °C but will stop below 5 °C) or the relative humidity is above 80 to 90%. As dictated by normal good painting practice. In confined spaces, provide adequate ventilation during application and drying.

HEALTH AND SAFETY:

See safety data sheet - Base - SDS 10844
Activator - SDS 10845

ISSUED:

06 March 2013

REVISION:

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The information given in this data sheet is based on experience and is accurate to the best of our knowledge. No guarantee should be implied, however, as the conditions of use are beyond our control. This data sheet does not constitute a specification. In case of doubt as to the suitability of the product please contact our Technical Service Department on 01482 320194.

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