



2 PACK ZINC PHOSPHATE PRIMER

514/Q113/224, 2

DESCRIPTION:

Teamac 2 Pack Zinc Phosphate Primer is a two-pack, non-toxic, 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:

Matt

COLOUR:

Grey, Red

TYPICAL S.G. (SPECIFIC GRAVITY):

1.5 - 1.6 @ 20 °C

VOLUME SOLIDS:

55%

WET FILM THICKNESS W.F.T

90 to 225 microns

DRY FILM THICKNESS D.F.T

50 to 125 microns

EXPECTED SPREADING RATE:

11 sq.m / litre

@ 50 microns D.F.T

4.4 sq.m / litre

@ 125 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:

0 deg °C (closed cup)

DRYING TIME: @ RECOMMENDED D.F.T

Touch dry: 45 mins @ 20 °C

Hard dry: 4 - 6 hours @ 20 °C

Full hardness: 3 - 5 days @ 20 °C

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

MINIMUM OVERCOATING TIME:

4 - 6 hours

APPLICATION SPECIAL CONDITIONS:

N/A

VOC CONTENT:

413 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):

Nozzle size: 15 -18 mils

Nozzle 1800 - 2300 psi
pressure:

Cleaning EPIDOX 2
solvent: THINNERS TH4

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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Recoat interval: 4 - 6 hours

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:

The product is supplied in two containers: one larger than the other and labelled Base. The other smaller one labelled Hardener. The contents of the pack marked Hardener should be stirred and poured (whilst stirring) into the larger pack marked Base. These should then be thoroughly mixed together, preferably by slow speed electric mixer. Ensuring the material is thoroughly mixed is very important, as poorly mixed product can lead to soft spots and uncured coatings.

APPLICATION CONDITIONS:

Should not be carried out when the ambient temperature is below 7 °C or the relative humidity above 90%.

As dictated by normal good painting practice. In confined spaces, provide adequate ventilation during application and drying.

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.

HEALTH AND SAFETY:

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

ISSUED:

23 March 2010

REVISION:

2

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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