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TECHNICAL INFORMATION SHEET

280 EPOXY ZINC PHOSPHATE

TWO-PACK PRIMER

May 2009

TDS 280 Page 1 of 4

Description and uses:

280 Epoxy Zinc Phosphate is a two-pack epoxy primer which provides superior corrosion resistance and excellent adhesion to suitably prepared surfaces. It can be overcoated with Lacnam two-pack coatings, used as a primer for steel, aluminum and galvanized iron. 280 Epoxy Zinc Phosphate has outstanding aged recoatability and is recommended for use with high performance painting systems. 280 Epoxy Zinc Phosphate has the following features:

- Fast cure at ambient temperatures
- Ready to use immediately after "Components A & B" are mixed
- Good solvent/chemical resistance and gloss hold out
- Can be top-coated with a number of industrial coatings
- Ideal tie-coat over inorganic zinc primers

Typical areas of application:

- Implements, cranes and material handling industry
- Marine coatings
- Chemical and petroleum industry
- Power stations and mining equipment

Note: Some chalking, yellowing and bleaching will occur with exterior exposure and contact with various chemicals i.e. (acids, alkalis and hydrocarbons), if not topcoated. This will not detract from the protective / performance properties of this product.

Technical Specifications:

FINISH: Matt Grey.

MIXING RATIO: Part A / Part B 4/1 (Volume).

THINNERS: T180 Epoxy Thinner

VOC: 423gms/ltr mixed components.

POT LIFE: 12 hours @ 25°C.

VOLUME SOLIDS: 55.0% when mixed.

COVERAGE: 10 - 12 Square metres per litre @ 50 microns DFT.

RECOMMENDED FILM THICKNESS: 90 - 125 microns wet / 50 - 75 microns dry.

APPLICATION: Brush, Roller and Spray.

280 Epoxy Zinc Phosphate

May 2009

TDS 280 Page 2 of 4

Technical Specifications:

Cure: (25°C & 50% Humidity) at 50 - 75 micron DFT.

Touch
2 Hours

Handle
16 Hours

Full Cure
7 Days

Recoat: (25°C & 50% Humidity).

Enamel
Min 2 Hours
Max 36 Hours

2 Pack (A & B)
2 Hours
5 Days

Itself
2 Hours
28 Days

The above recoat times are a guide only as factors such as thinners used, film thickness, ventilation, substrate temperature etc need to be taken into account. Ensure 280 Epoxy Zinc Phosphate is free of contaminants before overcoating, clean with T192 (Wax & Grease Remover).

Overcoating after the suggested maximum time could reduce intercoat adhesion between coats. Abrade and clean 280 Epoxy Zinc Phosphate surface with T192 (Wax & Grease Remover) before overcoating.

APPLICATION DETAILS – PAINTING SYSTEMS

D.F.T. um			
System 1	1 st Coat	50 - 75	280 Epoxy Zinc Phosphate (Thinner T180)
	2 nd Coat	50 - 75	720 Iso-Free (Thinner T154, T156 or T159)
	3 rd Coat		Optional

D.F.T. um			
System 2	1 st Coat	120 - 160	280 Epoxy Zinc Phosphate (Thinner T180)
	2 nd Coat	50-75	540 Polyurethane (Thinner T154, T156 or T159)
	3 rd Coat		Optional

D.F.T. um			
System 3	1 st Coat	50-100	280 Epoxy Zinc Phosphate (Thinner T180)
	2 nd Coat	120 - 160	390 or 480 Enamel with 298 Enamel Additive (Thinner T102 or T104)
	3 rd Coat	50-75	Optional

280 Epoxy Zinc Phosphate

May 2009

TDS 280 Page 3 of 4

APPLICATION DETAILS – SURFACE PREPARATION		
SUBSTRATE	DETAILS	RECOMMENDED SYSTEM
Steel	Power tool clean to AS1627.2 class 2 Or abrasive blast clean to AS1627.4 Class 2.5 or treat with 212 Metal Clean	1, 2 or 3
Aluminum, Galvanized Steel or Zinc Anneal	Light abrasive blast or treat with 212 Metal Clean	1,2 or 3
Concrete and Masonry	New concrete must be fully cured. Light abrasive blast or acid etch	1,2 or 3
Fibreglass	Light sand and wash down with thinner or cleaning solvent	1, 2 or 3
Previously Painted Surfaces	Lightly sand glossy areas, wash down with cleaning solvent	1,2 or 3

Surface Preparation:

- When overcoating; Aged paint coatings should be tested for adhesion using Crosshatch or Crosscut methods. If aged paint coating lifts remove it.
- Remove all rust, oxides, millscale and loose paint from metal surface.
- Round off all sharp edges, welding joints and weld spatter.
- All surfaces to be painted should be clean and free from dust, dirt, oil, grease and moisture.
- All abrasive blast clean ferrous surfaces should be coated within 4 hours to avoid flash rusting.
- Do not apply at temperatures below 10' Celsius. Do not apply at relative humidity above 85%, or when the substrate surface is less than 3' Celsius above dewpoint.
- Applied 280 Epoxy Zinc Phosphate to exterior exposure for extended period of time should be accessed for "Chalking" before applying suitable topcoat to achieve optimum intercoat adhesion.

Application:

For use by experienced industrial applicators. For best results mechanical mixing of Part A (base) and Part B (hardener) is recommended.

Mix 280 Part A, 4 parts with 1 Part 280 part B. Allow to stand for 10 minutes (not required during summer), and then stir again before using.

Brush or Roller – Thinning not normally required.

Conventional Spray – Thin approximately 5-10% and apply 2 coats wet on wet.

Airless Spray - Thinning not normally required.

Clean Up – T180 or T134 All Purpose Thinner.

280 Epoxy Zinc Phosphate

May 2009

TDS 280 Page 4 of 4

Equipment Application:

Brush or Roller – Apply evenly over prepared surface, more than one coat may required to achieve desired film thickness.

Conventional Spray – 1.8 -2.8 mm tip (or equivalent). Pressure pot set at 55 -100kpa (8 -15psi) and maintain gun air pressure 275 - 385kpa (40 -55psi).

Airless Spray – Use heavy-duty airless spray with 17 - 21” (0.43 - 0.53mm) plus tip and pump ratio 45:1.

Safety Instructions:

Storage: Store in a cool, dry bunded area out of direct sunlight as required for Flammable liquids DG Class 3, PG II, Hazchem 3(Y)E.

Flammability: Highly flammable, all sources of ignition must be eliminated in or near area of use, on burning fumes emitted are toxic. Do not smoke in immediate area.

Handling: Adopt adequate Occupational Work Practices to avoid personal contamination with product. Always wash hands before smoking, eating, drinking or using toilet. Food and Drink should be to stored and consumed in separate area.

Personal Protection: Avoid contact with skin or eyes; wear suitable clothing such as impervious overalls, PVC or neoprene gloves, safety goggles and face mask.

Using: Avoid inhalation of spray mist and vapours – use with adequate ventilation and suitable Personal Protection Equipment (PPE).

Engineering controls: Ensure ventilation is adequate. When spraying, ensure product is applied in a fully functional spray-booth. Keep containers closed when not in use. Do not use near ignition sources.

REFER MSDS BEFORE USE

(Phone 02 9688 1999 or refer to www.lacnam.com.au for copy MSDS)

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