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280 EPOXY ZINC PHOSPHATE

Two-Pack Primer

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 primer 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 normal temperatures.
- Ready to use as soon as components are mixed.
- Good solvent resistance and gloss hold out.
- Ideal tie-coat over inorganic zincs.

Typical areas of application are:

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

Technical Specifications

FINISH: Matt grey colour

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

THINNERS: T180 epoxy thinner.

POT LIFE: 12 hours @ 25°C.

VOLUME SOLIDS: 55% (when mixed).

COVERAGE: 11 Square metres per litre at 50 microns dry.

RECOMMENDED FILM THICKNESS: 50-75 microns dry.

APPLICATION: Brush, roller and spray.

DRYING AT 25°C: Touch dry 1.5 hours.

Minimum recoat- 2 hours.

Maximum recoat- Dependant on topcoat to be used.

(Consult Lacnam Technical Service for advice)

Hard dry- Overnight.

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APPLICATION DETAILS – PAINTING SYSTEMS			
D.F.T. um			
System 1	1 st Coat	50-75	280 Epoxy Primer (Thinner T180)
	2 nd Coat	50-75	720 Iso-Free (Thinner T154 or slow T156 or T159)
	3 rd Coat		Optional

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

D.F.T. um			
System 3	1 st Coat	50-75	280 Epoxy Primer (Thinner T180)
	2 nd Coat	50-75	390 enamel with 298 enamel additive (Thinner T102 or T104)
	3 rd Coat		Optional

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	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

Note: All surfaces to be painted should be clean and free from dust, dirt, oil, grease etc.
 All surfaces must be free of moisture and topcoat not applied when the substrate temperature is below 5°C.



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Application

280 primer can be applied by brush, roller, and conventional or airless spray. Mix part A and part B together and let stand 15 minutes before using. Thinning is not normally required or desired, however up to 5% of thinner T180 may be added if necessary.

Brush or Roller: Thin as above if necessary and apply to substrate. Care should be taken that proper and uniform film thickness is obtained.

Conventional Spray: For air spray application a fluid tip .070" to .086" (E or D DeVilbiss) and an air cap with good break up such as DeVilbiss 704 and 765 will give good results. The fluid pressure should be kept low, about 15 PSI, with just enough air pressure to get good break up of the coating. Excessive air pressure can cause overspray problems.

Airless Spray: Where airless spray equipment is used, use heavy duty 30 to 1 airless pump, tip size .019" to .023" will provide a good spray pattern. Ideally, fluid hose should be 3/8" ID and maximum length 16 metres, not including short 1/4" ID whips. Larger diameter hoses should be used for long fluid lines. Long fluid lines with narrow hoses will greatly reduce fluid pressure at the gun, causing poor spray patterns.

Clean Up: Clean equipment with T180 thinner.

Safety Instructions

Flammability: Highly flammable, avoid heat and sources of ignition. Container should be earthed when pouring.

Personal Protection: Avoid contact with skin or eyes, wear suitable clothing such as impervious overalls, PVC or neoprene gloves, and safety goggles. Wear an approved half-face respirator suitable for organic vapor, meeting AS1715/1716.

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.

Although this information is presented in good faith and compiled from sources believed to be accurate, Lacnam Paints make no representations or warranty as to the completeness or accuracy thereof. As the product's performance and suitability depends on various factors, the purchasers of our products should determine for themselves whether the product is suitable for their particular use.