

TECHNICAL INFORMATION SHEET

221 HI-BUILD PRIMER

Zinc Phosphate Anticorrosive Primer

February 2023

TDS 221 Page 1 of 3

Description and uses:

221 High-build primer is a zinc phosphate, high build anticorrosive alkyd primer (rheology modified), with the following features:

- Paint for Steel Structures: Specification AS/NZS 3750.19 Type 1
- Non-toxic anticorrosive pigments.
- Quick drying.
- High film build with no sagging.
- Suitable primer for all Lacnam Enamels.

Typical areas of application are:

- Structural steel, trusses etc.
- Cranes, earthmoving and mining equipment.
- Transportation and materials handling industries.

Technical Specifications:

- **Finish:** Various Colours.
- **Thinners:** T102 or T104.
- **Volume Solids:** 40 - 42%, Light Grey.
- **Coverage:** 6.5 - 7.5 m² per litre (at a D.F.T. of 60 microns).
- **Recommended Film Build:** 60-90 microns.
- **Application:** Brush, roller, and spray.
- **Drying @ 25°C / 50% Humidity:** Touch dry - 30 minutes
Recoat - 2 hours
Hard dry - Over night

Resistance Properties:

- **Abrasion:** Moderate when fully cured.
- **Heat:** 120°C dry heat.
- **Immersion:** Not Recommended.
- **Solvents:** Fair, resists alcohol and mineral based solvents. Ester, Ketone, Ether, or similar type solvents are likely to attack coating in constant contact.
- **Chemical:** Fair. Not recommended where Acid/Alkali fumes, splash or spillage may occur
- **Weatherability:** Will chalk on exterior exposure. Chalking will not detract from the protective properties of the coating. Not recommended for permanently damp areas.

221 HI-BUILD PRIMER

Zinc Phosphate Anticorrosive Primer

February 2023

TDS 221 Page 2 of 3

APPLICATION DETAILS – PAINTING SYSTEMS				
D.F.T.um				
System 1	Environmental Corrosivity AS/NZS 2312 C1-2	1st Coat	60-90	221 High-build primer (Thinner T102 or T104)
		2nd Coat Optional	60-90	221 High-build primer (Thinner T102 or T104)

APPLICATION DETAILS – PAINTING SYSTEMS				
D.F.T.um				
System 2	Environmental Corrosivity AS/NZS 2312 C1-3	1st Coat	60-90	221 High-build primer (Thinner T102 or T104)
		2nd Coat	25-45	390 or 480 enamel (Thinner T102 or T104)

APPLICATION DETAILS – PAINTING SYSTEMS				
D.F.T.um				
System 3	Environmental Corrosivity AS/NZS 2312 C1-3	1st Coat	60-90	221 High-build primer (Thinner T102 or T104)
		2nd Coat	25-45	300 RD enamel (Thinner T102 or T104)

APPLICATION DETAILS – SURFACE PREPARATION		
SUBSTRATE	DETAILS	RECOMMENED SYSTEM
Steel	Power tool clean to AS1627.2 class 2 Or abrasive blast clean to AS1627.4 Class 2	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 5° Celsius. Do not apply at relative humidity above 85%, or when the substrate surface is less than 3° Celsius above dewpoint.
- Applied 221 Hi Build Primer Coat subjected to exterior exposure for extended period of time should be accessed for “Chalking” before applying suitable topcoat to achieve optimum intercoat adhesion. Chalking will not detract from the protective properties of the coating.

Equipment Application:	(Conventional or Airless Spray Recommended).
As a Guide Use:	
• Brush or Roller:	Suitable for small areas only.
• Conventional Spray:	1.5 -2.0mm tip (or equivalent). Pressure pot set at 55 - 100kpa (8 - 15psi) and maintain gun air pressure 275 - 380kpa (40 -55psi).
• Airless Spray:	Use heavy-duty airless spray with 10 -15 “(0.25 – 0.38mm) plus tip and pump ratio 30:1

221 HI-BUILD PRIMER

Zinc Phosphate Anticorrosive Primer

February 2023

TDS 221 Page 3 of 3

Application Thinning:

- Brush or Roller: Suitable for small areas only; May require Slow or Retarding Thinners (T195 / T122), to improve brushability. Thin initially 5%, then increase to suit.
- Conventional Spray: Thin approximately 15 - 20% and apply.
- Airless Spray: Thin approximately 5 - 10% and apply.
- Clean Up: T102, T104 or T134 All Purpose Thinner.

Safety Instructions:

- Storage: Store in a cool, dry banded 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 SDS BEFORE USE

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

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.