



**LACNAM PAINTS AUSTRALIA**

ABN 48 125 092 482  
78-80 MANDOOK, ROAD, GIRRAWEE, SYDNEY  
NSW 2145 AUSTRALIA  
TELEPHONE: (02) 9688 1999

EMAIL: [sales@lacnam.com.au](mailto:sales@lacnam.com.au) WEBSITE: [www.lacnam.com.au](http://www.lacnam.com.au)

**TECHNICAL INFORMATION SHEET**

**284 GP EPOXY ZINC PHOSPHATE**  
**TWO-PACK EPOXY**

October 2024

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**Description and uses:**

284 GP Epoxy Zinc Phosphate is a two pack primer which provide superior corrosion resistance and excellent adhesion to suitably prepared surfaces. It can be overcoated with Lacnam two-pack coating, used as a primer for steel, stainless steel, aluminum and galvanized iron. 284 GP Epoxy Zinc Phosphate has outstanding aged Recoatability and is recommended for use with high performance coating systems. 284 GP Epoxy Zinc Phosphate following features:

- Fast cure at ambient temperatures
- Ready to use immediately after Components A & B are mixed
- Good solvent/chemical resistance
- Can be top coated with various industrial coatings
- Ideal tie-coat over inorganic zinc rich primers, galvanized steel, and zinc aneal

Typical areas of application are:

- Structural steel and sheet metal used in construction, transportation, industrial Industries
- Implements, crane and material handling industry
- Marine Coatings
- Chemical and petroleum industry
- Power station 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 White.

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

THINNERS: T180 Epoxy Thinner

POT LIFE: 12 hours @ 25°C (Depending mixed volume).

VOC: 420-440 gms/litre mixed components

VOLUME SOLIDS: 56-58% mixed components.

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

RECOMMENDED FILM THICKNESS: 90-135 microns wet / 50-80 microns dry.

APPLICATION: Brush, Roller and Spray.

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## Technical Specifications:

**Cure:** (25°C & 50% Humidity) at 160 micron DFT.

Touch	Handle	Full Cure
3 Hours	16 Hours	5 Days

**Recoat:** (25°C & 50% Humidity).

	Enamel	2 Pack (A & B)	Itself
Min	3 Hours	3 Hours	3 Hours
Max	36 Hours	5 Days	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 considered. Ensure 284 GP 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 284 GP Epoxy Zinc Phosphate surface with T192 (Wax & Grease Remover) before overcoating.

## APPLICATION DETAILS – PAINTING SYSTEMS

D.F.T. um			
System 1	1 <sup>st</sup> Coat	50 - 80	284 GP Epoxy Zinc Phosphate (Thinner T180)
	2 <sup>nd</sup> Coat	50 - 80	284 GP Epoxy Zinc Phosphate (Thinner T180)
	3 <sup>rd</sup> Coat		Optional

D.F.T. um			
System 2	1 <sup>st</sup> Coat	50 - 80	284 GP Epoxy Zinc Phosphate (Thinner T180)
	2 <sup>nd</sup> Coat	50 - 75	540, 720 Two-pack topcoat (Thinner T154 or slow T156 or T159)
	3 <sup>rd</sup> Coat		Optional

D.F.T. um			
System 3	1 <sup>st</sup> Coat	50 - 100	605 Zinc Rich Primer (Thinner T180)
	2 <sup>nd</sup> Coat	50 - 80	284 GP Epoxy Zinc Phosphate (Thinner T180)
	3 <sup>rd</sup> Coat	50 - 75	540, 720 Two-pack topcoat (Thinner T154 or slow T156 or T159)

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<b>APPLICATION DETAILS – SURFACE PREPARATION</b>		
SUBSTRATE	DETAILS	RECOMMENDED SYSTEM
Steel	Optimum Performance: Abrasive blast clean to AS1627.4 Class 2.5, uniform blast profile minimum 35 microns, up to 75 microns. Site repairs and where abrasive blasting is not practicable: Power tool clean to AS1627.2 Class 2	1, 2 or 3
Stainless Steel	Abrasive Blast to achieve a uniform blast profile of 25 - 50 microns. Use non-metallic blast media. Site repairs and where abrasive blasting is not practicable abrade (80 grit).	1 or 2
Galvanized Steel or Zinc Anneal	Sweep abrasive blast, or abrade (80 grit), or treat with 212 Metal Clean. Avoid aggressive preparation that may remove zinc coating.	1 or 2
Aluminum	Abrasive Blast to achieve a uniform blast profile of 25 - 50 microns. Use non-metallic blast media. Site repairs and where abrasive blasting is not practicable abrade (80 grit).	1 or 2
Concrete and Masonry	New concrete should be cured for 28 days. Light abrasive blast or acid etch followed by HP water wash, allow to dry.	1 or 2
Previously Painted Surfaces	Must not be less than 6 months old. Check existing coating for adhesion, solvent resistance, and compatibility before application. Lightly sand glossy areas, wash down with cleaning solvent	1 or 2

### 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.
- Galvanized Steel surfaces should be coated immediately after preparation. Do not allow White Rust (Zinc hydroxide) to form prior to coating.
- Porous surfaces such as concrete and masonry, or if being used as a tie coat over Inorganic Silicate primers. Thin first coat up to 30% to minimize pin holing and maximize substrate wetting.
- Do not apply at temperatures below 12° Celsius. Do not apply at relative humidity above 85%, or when the substrate surface is less than 3° Celsius above dew point.
- Applied 284 GP Epoxy Zinc Phosphate coat subjected to exterior exposure for extended period should be accessed for “Chalking” before applying suitable topcoat to achieve optimum intercoat adhesion.

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### **Application:**

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

Mix 284GP Part A, 4 parts with 1 Part 284GP part B.

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.

### **Equipment Application:**

Brush or Roller – Apply evenly over prepared surface, more than one coat may be required to achieve the 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 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 the immediate area.

Handling: Adopt adequate Occupational Work Practices to avoid personal contamination with product. Always wash hands before smoking, eating, drinking or using the toilet. Food and Drink should be 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](http://www.lacnam.com.au) for copy SDS)

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