

**TECHNICAL INFORMATION SHEET****605 ZINC RICH EPOXY PRIMER**

November 2024

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**Description and uses:**

605 Zinc Rich is a two-pack reinforced phenalkamine, high performance epoxy primer which provides cathodic protection to steel.

**The main features are:**

- Premium primer for most industrial applications
- Resists topcoat pin-holing
- Easy application by brush, roll or spray.
- Resistant to dry spray, mudcracking and topcoat bubbling
- Good low temperature cure
- Dry heat resistance to 200°C (Intermittent)
- Good solvent resistance.
- Provides excellent corrosion protection in a variety of environments.

**Typical areas of application are:**

- Bridges and steel fabrications.
- Chemical process industries and refineries.
- Fertilizer plants.

**Technical Specifications:**

FINISH: Matt Grey

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

THINNERS: T180

POT LIFE: 8.0 hours @ 25°C.

VOLUME SOLIDS: 64 % Mixed.

VOC: 415 gms/ltr.

COVERAGE: 8 - 9 Square metres per litre. (DFT of 75 microns)

RECOMMENDED FILM THICKNESS: 50 - 100 microns dry.

APPLICATION: Conventional or Airless Spray, Brush or Roller.

DRYING AT 25°C / 50% Humidity: Touch dry: 60 minutes

Recoat Minimum: 1 - 2 hours

Hard dry: 2 - 3 Hours

**Note:** Not to be overcoated with Alkyd based coatings.

Not suitable for chemical, solvent, or salt/freshwater immersion.

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<b>APPLICATION DETAILS – PAINTING SYSTEMS</b>			
D.F.T. um			
System 1	1 <sup>st</sup> Coat	50 - 100	605 Zinc Rich Primer (Thinner T180)
	2 <sup>nd</sup> Coat	25 - 30	260 Key-Coat (Thinner T166)
	3 <sup>rd</sup> Coat	50 - 75	Any Lacnam single or two-pack finishes

D.F.T. um			
System 2	1 <sup>st</sup> Coat	50 - 100	605 Zinc Rich Primer (Thinner T180)
	2 <sup>nd</sup> Coat	50 - 75 or 120 - 160 or 50 - 75	284 Epoxy Primer (Thinner T180)  285 ST Epoxy (Thinner T180)
		3 <sup>rd</sup> Coat	50-75

<b>APPLICATION DETAILS – SURFACE PREPARATION</b>		
SUBSTRATE	DETAILS	RECOMMENDED SYSTEM
Steel	Power tool clean to AS1627.2 class 2 Or abrasive blast clean to AS1627.4 Class 2.5.	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.
- 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 dew point.

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## **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

## **Application:**

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

Mix 605 “Part A” 4 parts with 1 Part 605 “Part B” (Ratio 4:1). Allow to stand for 15 minutes, then stir again before using.

**Brush or Roller** - Suitable for small areas only. Thinners (T180) may be required to improve brushability. Thin initially 5%, then increase to suit.

**Conventional Spray** - Thin approximately 10 -15% and apply.

**Airless Spray** - Thin approximately 5 - 10% and apply.

**Clean Up** - T180 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](http://www.lacnam.com.au) for copy SDS)

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