



LACNAM PAINTS AUSTRALIA

ABN 48 125 092 482

78-80 MANDOOK, ROAD, GIRRAWEE, SYDNEY

NSW 2145 AUSTRALIA

TELEPHONE: (02) 9688 1999 FACSIMILE: (02) 9896 1606

EMAIL: sales@lacnam.com.au WEBSITE: www.lacnam.com.au

TECHNICAL INFORMATION SHEET

TDS 253 page 1 of 3

253 HOLDING PRIMER

Zinc Phosphate Etch Primer

May 2025

Description and uses:

253 Holding Primer is an epoxy-vinyl zinc phosphate etch primer that does not need to be removed prior to metal fabrication.

As a base primer, it offers superior adhesion for approved topcoats.

- Suitable for coating mild steel, aluminum, galvanized iron, copper, brass etc.
- Contains zinc phosphate for anti-corrosive protection of ferrous metals.
- Can be top coated with most finishes.
- Ready for use

Typical areas of application are:

- Metal fabrication and structural steel.
- Plant and machinery.
- Electronic equipment housing.
- Earthmoving and materials handling industries.

Technical Specifications:

FINISH: Matt Light Grey

THINNERS: T166

VOLUME SOLIDS: Approximately 15%.

COVERAGE: Approximately; 10 Square metres per litre (at a DFT. of 15 microns).

Approximately; 8 Square metres per litre (at a DFT. of 25 microns).

RECOMMENDED FILM THICKNESS:

- (1) 10-15 microns DFT over non-ferrous metals.
- (2) 15-25 microns DFT over ferrous metals.

APPLICATION: Conventional or airless spray.

DRYING AT 25°C / 50% Humidity:

100 microns wet/15 microns DFT: Touch dry - 5-10 minutes
Handle - 15-20 minutes
Recoat - 60 minutes

165 microns wet/25 microns DFT: Touch dry - 10-15 minutes
Handle - 20-30 minutes
Recoat - 2-3 hours,

Note: With extended exposure, ensure primer surface is free of chalk and contamination. Detergent wash, or degrease with cleaning solvents, (T191 or T192).

253 HOLDING PRIMER

TDS 253 page 2 of 3

May 2025

APPLICATION DETAILS – PAINTING SYSTEMS			
D.F.T. um			
System 1	1 st Coat	15-25	253 Holding Primer (Thinner T166)

D.F.T. um			
System 2	1 st Coat	15-25	253 Holding Primer (Thinner T166)
	2 nd Coat	50-75	Any Lacnam single or two-pack finishes

D.F.T. um			
System 3	1 st Coat	10-15	253 Holding Primer (Thinner T166)
	2 nd Coat	50-75	Any Lacnam single or two-pack finishes

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	1,2
Aluminum and non-ferrous metals	Light abrasive blast or treat with 212 metal clean.	3
Previously painted surfaces	Lightly sand glossy areas wash down with cleaning solvent.	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, mill-scale 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 253 Holding Primer subjected to exterior exposure for extended period should be accessed for “Chalking” before applying suitable topcoat to achieve optimum intercoat adhesion.

Equipment Application: (Conventional or Airless Spray Recommended).

As a Guide Use:

Brush or Roller - Suitable for small areas only. May require Retarder Thinner T132.

Conventional Spray - 1.3 -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

253 HOLDING PRIMER

TDS 253 page 3 of 3

May 2025

Application Thinning:

Thinning not normally required

Depending on method of application 5 to 15% T166 thinner can be added to achieve a smooth wet film.

Conventional or airless spray: Thin as suggested and apply a smooth wet film.

Note: Poor adhesion may result if:

- (1) Etch is applied over damp surfaces.
- (2) Recoating times are not adhered to.
- (3) A dry coat is applied instead of a wet smooth coat.
- (4) Film thickness per coat is greater than 10-15 microns on non-ferrous metals.

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 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 MSDS)

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.