

## Hi-Dur ZP Primer

<b>Product Description</b>	<b>An alkyd zinc phosphate primer</b> for metal, white spirit based.				
<b>Features &amp; Use</b>	<ul style="list-style-type: none"> <li>• Excellent protection and adhesion to steelwork</li> <li>• For use as a primer for structural steelwork and metal fabrications</li> <li>• Suitable for agricultural, marine and industrial environments</li> <li>• Can be top-coated with most air-drying finishes</li> </ul>				
<b>Approvals/ Certification</b>	Conforms to Category (i) of Directive 2004/42/EC which carries a VOC limit of 500g/l				
<b>Finish</b>	Matt				
<b>Volume Solids</b>	52 ± 2% (varies with colour)				
<b>VOC Content</b>	376 ± 20 g/litre (varies with colour)				
<b>Film Thickness Range And Coverage</b>		<b>Dry Film Thickness</b>	<b>Wet Film Thickness</b>	<b>Theoretical Coverage</b>	
	<b>Minimum</b>	40 µm	77 µm	13 m <sup>2</sup> /litre	
	<b>Maximum</b>	80 µm	154 µm	6.5 m <sup>2</sup> /litre	
	Practical coverage depends on the application method, painting conditions and the shape and roughness of the surface to be coated				
<b>Drying Times</b>	Applied to 60 microns DFT	<b>+10°C</b>	<b>+23°C</b>	<b>+35°C</b>	
	<b>Dust Free</b>		3 hr	1 hr	40 min
	<b>Hard Dry</b>		9 hr	6 hr	5 hr
	<b>Overcoating</b>	Minimum	36 hr	24 hr	16 hr
		Maximum	Indefinite if clean and sound		
	Drying and recoating times are related to the film thickness, temperature, the relative humidity of the air and ventilation				
<b>Colours</b>	Red Oxide, Grey and limited range				
<b>Product Code</b>	<b>04HZP</b>				
<b>SG</b>	1.36 kg/lit (varies with colour)				
<b>Storage Conditions</b>	Store in dry, cool conditions and protect from frost				
<b>Shelf Life</b>	Minimum 12 months if stored as above in unopened containers				
<b>Flash Point</b>	23-60°C				

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<p><b>Surface Preparation</b></p>	<ul style="list-style-type: none"> <li>All surfaces to be coated should be dry and cleaned as necessary to remove all oil, grease, salts, weld flux or other contamination. Where necessary, remove weld spatter and grind smooth all sharp edges and weld seams</li> <li>Ideally blast clean to Sa2½ (ISO 8501-1:2007), surface profile 50-75 microns</li> <li>Where blast cleaning is not possible, hand prepare to St2 standard (ISO 8501-1:2007) taking care to not 'polish' the metal surface</li> <li>On non-ferrous surfaces use a suitable etch primer – please consult Axalta Coating Systems for advice</li> </ul>														
<p><b>Mixing</b></p>	<p>Must be mixed thoroughly by using a mechanical agitator before use. Agitate periodically to ensure paint remains homogeneous.</p>														
<p><b>Thinner</b></p>	<p>No.3 Thinner</p>		<p><b>Equipment Cleaner</b> No.3 Thinner</p>												
<p><b>Application Conditions</b></p>	<p>Only apply in conditions of good ventilation which must be maintained during drying and curing. Do not apply when rain, mist, sleet or snow are imminent. During application and drying time of the paint coating, the surface should be dry, the Relative Humidity should not exceed 85% and the steel temperature should remain at least 3°C above the dew point. Paint temperature should ideally be at a minimum of 15°C.</p>														
<p><b>Application Methods</b></p>	<table border="1"> <thead> <tr> <th data-bbox="419 958 675 1032">Method</th> <th data-bbox="675 958 922 1032">Airless Spray</th> <th data-bbox="922 958 1169 1032">Conventional Spray</th> <th data-bbox="1169 958 1342 1032">Brush</th> <th data-bbox="1342 958 1495 1032">Roller</th> </tr> </thead> <tbody> <tr> <td data-bbox="419 1032 675 1088"></td> <td data-bbox="675 1032 922 1088">Yes</td> <td data-bbox="922 1032 1169 1088">Yes</td> <td data-bbox="1169 1032 1342 1088">Yes</td> <td data-bbox="1342 1032 1495 1088">Yes</td> </tr> </tbody> </table>	Method	Airless Spray	Conventional Spray	Brush	Roller		Yes	Yes	Yes	Yes				
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<ul style="list-style-type: none"> <li>Airless Spray: Output fluid pressure at tip 2000-2500 psi, Tip Size 15-21 thou (0.38-0.53 mm)</li> <li>Conventional spray: use 50-60 psi with 1.4-1.8mm nozzle. Up to 10% thinning may be required</li> <li>Brush/roller – use as supplied, do not thin</li> </ul>															
<p><b>Product Notes</b></p>	<ul style="list-style-type: none"> <li>May be overcoated with itself or other white spirit based products. The compatibility and suitability of overcoating should be confirmed prior to application</li> <li>Two coats are recommended for best anticorrosive protection with a minimum total dft of 80 µm. This primer is usually top-coated with a protective finish, please consult Axalta Coating Systems for systems advice</li> <li>In common with most alkyd primers, this product is not recommended for extended exterior exposure, exposure in aggressive or coastal locations, or for immersion. Epoxy primers are preferred for these conditions, please consult Axalta Coating Systems for advice</li> </ul>														
<p><b>Health &amp; Safety</b></p>	<p>Containers are provided with safety labels which should be observed. Further information about hazardous influences and protection are detailed in individual Product Safety Data Sheets. A Safety Data Sheet for this product is available on request from Axalta Coating Systems.</p>														

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