



## ZPH - 1K ZINC PHOSPHATE HIGH SOLIDS PRIMER

### PRODUCT DESCRIPTION

CPC 1K Zinc Phosphate High Solids Primer is a high build, anti-corrosive, alkyd resin based primer for use with alkyd enamels and 2-pack topcoats. It is relatively fast drying with excellent durability and can be re-coated after 1 hour as a "Wet on Wet" application and does not need to be sanded to give excellent topcoat adhesion and gloss holdout.

CPC 1K Zinc Phosphate High Solids Primer has its own colour range to choose from, other corporate colours can be formulated on request.

### PRODUCTS

1K High Solids Primer Mixed Colour		ZPH Mixed Colour
Reducers	<i>Normal Conditions</i> <i>Hot Conditions</i>	AER20 Alkyd Enamel Reducer Normal AER30 Alkyd Enamel Reducer Slow
Cleaners		971-9119 PROTEC® Metal Conditioner AA-6822 <i>Protec</i> Heavy Duty Wax & Grease Remover

### SUBSTRATES & PREPARATION



CPC 1K High Solids Primer can be applied over the following substrates once they have been prepared as follows:

#### SUBSTRATE

#### PREPARATION

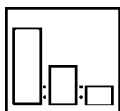


Bare Steel		STARTLINE® P150 - dry
Phosphated Steel		<i>Startline</i> Scourer
Galvanized Steel	Startline P280-P320 - dry - Apply EPS Etch Pro or VIN Vinyl Etch Primer	
Stainless Steel	Startline P280-P320 - dry - Apply EPS Etch Pro or VIN Vinyl Etch Primer	
Brass	Startline P280-P320 - dry - Apply EPS Etch Pro or VIN Vinyl Etch Primer	
Aluminium	Startline P280-P320 - dry - Apply EPS Etch Pro or VIN Vinyl Etch Primer	
Blasted Steel	Apply ZPH within 4 hours of blast cleaning	

Before and after any sanding operation, the substrate must be thoroughly degreased using AA-6822 *Protec* Heavy Duty Wax & Grease Remover to remove all traces of dirt, oil, grease, silicone, wax etc.

*Substrates other than those stated above should be tested before use, to ensure that the performance of this product is suitable for its intended use.*

## MIXING RATIO BY VOLUME



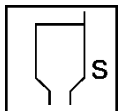
### PRODUCT

CPC 1K High Solids Primer  
Mixed Colour  
Reducer

### PARTS

100  
25

## SPRAY VISCOSITY



20 - 25 seconds (DIN 4) at 25°C

## SPRAYGUN



### CONVENTIONAL, HVLP

#### SETUP

- GRAVITY 1.8 mm - 2.0 mm
- SUCTION 1.8 mm - 2.0 mm

#### SPRAY PRESSURE

- CONVENTIONAL 3.5 - 4.5 bar (350 - 450 kPa, 45 - 65 psi)
- HVLP / RP 2 - 3 bar

## APPLICATION & FLASH OFF



Apply 2-3 wet, even coats

Allow 5-10 minutes flash off between coats at 25°C

Note: Do not apply at temperatures less than 10°C, when the relative humidity exceeds 80% or if the surface temperature is within 3°C of the dew point.

## DRYING TIMES



### AIR DRY (25°C)

- DUST FREE: 5 minutes
- DRY TO HANDLE: 4 hours

Note: Drying times can vary dependent on temperature, flash off between coats, film builds and number of coats applied, Recommendations are based on 25°C ambient temperature.

## RECOAT



Allow 60 minutes drying time before recoating, a light sand is recommended after overnight dry, maximum recoat time is 4 weeks.

## TOTAL DRY FILM BUILD

50 - 100 µm

## TECHNICAL PARAMETERS

### VOLUME SOLIDS

45-54%

### COVERAGE

7-8 metres squared per litre (m<sup>2</sup>/L)

## EQUIPMENT CLEANING

After use, clean all equipment thoroughly with cleaning solvent or thinner.

## HEALTH AND SAFETY

**Please refer to Safety Data Sheets (SDS) for full Health and Safety details, as well as product can labels.**

This product is for professional use only.  
The information given in this sheet is for guidance only. Any person using the product without first making further inquiries as to the suitability of the product for the intended purpose does so at his or her own risk and we can accept no liability for the performance of the product or for any loss or damage (other than death or personal injury resulting from our negligence) arising out of such use. The information contained in this sheet is liable to modification from time to time in the light of experience and our policy of continuous product development.  
Drying times quoted are average times at 25°C/77°F. Film thickness, humidity and shop temperature can all affect drying times.

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