Commercial Performance Coatings

TECHNICAL DATA SHEET

402 ZINC PHOSPHATE PRIMER

PRODUCT DESCRIPTION

Commercial Performance Coatings 402 Zinc Phosphate Primer is a single pack alkyd resin based, general purpose industrial primer that contains zinc phosphate for corrosion inhibition. It is relatively fast drying with excellent adhesion to suitably prepared substrates and exhibits very good gloss hold-out when overcoated with enamel finishes.

It is designed for use on general structural steel, roofs, machinery and other equipment on good, clean and scale free surfaces.

PRODUCTS

		402 ZINC PHOSPHATE PRIMER
Reducer	*Normal Conditions*	AER20 Alkyd Enamel Reducer Normal
	Hot Conditions	AER30 Alkyd Enamel Reducer Slow
Cleaners		971-9119 PROTEC® Metal Conditioner
		AA-6822 *Protec* Heavy Duty Wax & Grease Remover

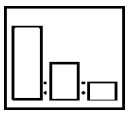
SUBSTRATES & PREPARATION

Surfaces showing heavy scale or surface rust should be treated with 971-9119 *Protec* Metal Conditioner. Heavily rusted surfaces should be abrasively blast cleaned.

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.

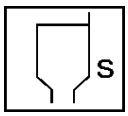
For other primer options please consult the PPG Commercial Performance Coatings Technical Team.

MIXING RATIO BY VOLUME



PRODUCT	PARTS
402 ZINC PHOSPHATE PRIMER	100
Reducer	Up to 25% can be added

SPRAY VISCOSITY



15 - 20 seconds (DIN 4) at 25°C

SPRAYGUN

CONVENTIONAL, HVLP

SETUP

• GRAVITY	1.4 mm - 1.6 mm
• SUCTION	1.4 mm - 1.8 mm

SPRAY PRESSURE

• CONVENTIONAL	3.0 - 4.0 bar (300 - 400 kPa, 45 - 60 psi)
• HVLP / RP	2 - 3 bar

APPLICATION & FLASH OFF

Apply 1 - 2 wet, even coats

Allow 3 - 10 minutes flash off between coats at 25°C

DRYING TIMES

AIR DRY (25°C)

• DUST FREE:	10-15 minutes
• TOUCH DRY:	30 minutes
• DRY TO HANDLE:	3-4 hours
• HARD DRY:	Overnight

Note: Drying times can vary dependent on temperature, flash off between coats, film builds and number of coats applied.

RECOAT

Topcoat with single pack enamels after 3-4 hours drying.

TOTAL DRY FILM BUILD

40 - 50 µm

TECHNICAL PARAMETERS

VOLUME SOLIDS (RFU)	37%
COVERAGE	9.2 metres squared per litre (m^2/L)
RESISTANCE PROPERTIES	
WEATHERING	May be left uncoated for up to 6 months
ABRASION	Good
SOLVENT	Poor
CHEMICAL	Not recommended
HEAT	Satisfactory up to 120ºC Dry Heat
IMMERSION	Not recommended

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.

PPG Industries Australia Pty Ltd, 14 McNaughton Rd
Clayton, VIC 3168 Australia

EMERGENCY RESPONSE NUMBER, Australia: 1800 883 254

PPG Industries New Zealand Pty Ltd, 5 Vestey Dr, Mt Wellington
Auckland, New Zealand

EMERGENCY RESPONSE NUMBER, New Zealand: 0800 000 096