

# DUBOND'S ZINC PHOSPHATE

## Epoxy Zinc-Phosphate Primer for Iron Substrate

### Product Description

Dubond's Zinc Phosphate is a 2-component, highly pigmented Zinc-Phosphate Primer of low solvent content, based on epoxy resin.

#### Fields of Application

Dubond's Zinc-Phosphate offers a wide range of applications and is especially suitable for objects subjected to heavy mechanical wear, e.g. weirs, interiors of pressure pipe lines, gates, penstocks, etc.

With upto 20 microns film thickness Dubond's Zinc-Phosphate may also be employed as weldable shop coating. An approval is available upon request.

#### Properties

Dubond's Zinc-Phosphate cures very quickly, is resistant to water and weathering, abrasion and barnacles, mechanical wear.

### Product Data

Colour Shades	:	Zinc Grey.
Packaging	:	15 kg and 7 kg net.
Shelf Life	:	In originally sealed containers in cool and dry environment. (Min. 1 year )

### Systems

#### Surface Preparation

Steel	:	Blast cleaning to Sa 2½ according to EN ISO 12944, part 4, free from dirt, oil and grease.
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### Technical Data

#### Material Consumption

Specific Gravity Liquid Approx. kg/L	Solids Content Approx. %		Theoretical thickness with 100 g/m <sup>2</sup> consumption		Material consumption for medium dry film thickness of	
	By Volume	By Weight	Wet Microns	Dry Microns	Microns	Approx. kg/m <sup>2</sup>
2.8	67	89	36	24	20	0.083
					60	0.250
					80*)	0.335

\*) For spray application

A part from small areas the dry film thickness should not exceed 150 microns per layer



### Mixing Ratio in Parts by Weights

Components A : B - 94 : 6

### Resistance

The fully cured material is resistant to weathering, water and mechanical wear.

### Temperature

- Dry heat upto approx. +150 °C, short term upto maximum +180 °C
- Damp heat upto approx. +50 °C

## Hints on Application

### Preparation of Material

Stir component a very thoroughly using an electric stirrer. Add component B and mix both components very thoroughly (including sides and bottom of the container)

### Application Method

The method of application has a major effect on achieving uniform thickness and appearance. Spray application will give the best results. The indicated dry film thickness is easily achieved by airless spray and by brush. Adding solvents reduces the sag resistance and the dry film thickness. In case of application by roller or brush, additional applications may become necessary to achieve the required coating thickness, depending on type of construction, site conditions, colour shade etc. Prior to major coating operations a test applications on site may be useful to ensure the selected application method will provide the requested results.

### By Brush

#### Conventional High Pressure Spraying

Nozzle size 1.7 - 2.5 mm, pressure 3-4 bar.

#### Airless Spraying

With a spray pressure in gun of min. 180 bar

Nozzle size 0.38 - 0.53 mm (0.015-0.021 inch); spraying angle 40° - 80°

### Application Temperature

Surface : min. +5 °C

Material : min. +5 °C

### Potlife

At 20 °C approx. 8 hours

## Drying Degree 6 (DIN 53150)

### Material Consumption

Material Thickness	+5 °C After	+23 °C After	+40 °C After	+80 °C After
20 microns	1 hour	45 min.	30 min.	20 min.
60 microns	3 hours	2½ hour	1½ hours	45 min.

### Final Drying Time

Depending on film thickness and temperature full hardness is achieved after 1-2 days.

### Cleaning of Implements

Dubond's Epoxy Thinner

## ■ Important Notice

### **Detective 2004 / 42 / CE**

For product category IIA / J, Type SB, the maximum permissible content of VOC as per Directive 2004 / 42 / CE is 500 g/ltr. (Limit 2010)

The maximum content of Dubond's Zinc-Phosphate remains below 500 g/ltr. VOC

## ■ Value Base

All technical data stated in this product data sheet are based on laboratory tests. Actual measured data may vary due to circumstances beyond our control.

## ■ Local Restrictions

Please note that as a result of specific local regulations the performance of this product may vary from country to country. Please consult the local product data sheet for the exact description of the application fields.

## ■ Health & Safety Information

For information and advice on the safe handling, storage and disposal of chemical products, users should refer to the most recent Material Safety Data Sheet containing physical, eco-logical, toxicological and other safety-related data.

**DISCLAIMER** The product information & application details given by the company & its agents has been provided in good faith & meant to serve only as a general guideline during usage. Users are advised to carry out tests & take trials to ensure on the suitability of products meeting their requirement prior to full scale usage of our products. Since the correct identification of the problems, quality of other materials used and the on-site workmanship are factors beyond our control, there are no expressed or implied guarantee / warranty as to the results obtained. The company does not assume any liability or consequential damage for unsatisfactory results, arising from the use of our products.

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