Nason® Industrial 2K ZP Epoxy Primer

Product Description
2K Zinc Phosphate polyamide cured epoxy primer.

Gloss
Flat.

Product Features
- Wet on wet application
- Excellent over spray absorption
- Excellent surface filling properties
- Contains zinc phosphate
- High film build & sag resistance
- High chemical and abrasion resistance
- Excellent adhesion to prepared steel

Product Benefits
- Reduced time to topcoat, high productivity
- High productivity for spraying large items
- Sandable to achieve a high quality finish
- Excellent corrosion resistance over steel
- Excellent coverage & run free finish
- Wide range of industrial environments
- Long term film integrity & protection

Product Uses / Applications
For use in coastal, chemical or marine environments, where a higher level of corrosion protection and/or chemical resistance is required (e.g. on mild steel; galvanised steel, stainless steel, aluminium) than is provided by conventional alkyd ZP primers. Also suitable for use on fiberglass.
- Commercial transport & components;
- Mobile mining, earth moving, construction & agricultural equipment and attachments;
- Structural steel – industrial and commercial;
- Industrial plant equipment and machinery;
- Pipeline & tank exteriors.

Not Recommended for
Immersion service;
Application over QD Enamel and TPA Coatings.
Application over etch primers.

Physical Data

Volume Solids:	54.4% (mixed)
VOC:	383 g/L (mixed)
Specific Gravity:	1.30 g/mL (mixed)
Dry Film Thickness:	50 - 70 µm per coat
Theoretical Coverage:	8.7 m³/L (at 50 µm DFT)
Flash Point:	-1.6°C

Dry Time

Air Dry at 20°C & 50% RH at recommended film thickness:
Wet-on-wet: 30 – 60 minutes (max. 5 days)
Dry to Handle: 4 - 8 hours Hard Dry: 24 hours

Bake: 30 minutes @ 60°C after 20 minutes flash-off @ 20°C. Please see Table 1 for reducer selection.

Surface Preparation

Previously painted surfaces:
Clean using an Axalta recommended wax and grease remover.
Lightly sand or scour with 3M Scotch Brite Pad grey, and subsequently re-clean all the areas before the application of Nason® Industrial NI610/620 2K PU with ST tint based topcoats.
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Test suitability of the existing coating before application of 650-04 Nason® Industrial 2K ZP Epoxy Primer.
New work:

Cleaning:	Degrease using an approved wax and grease remover.
Sandblasting:	Class 2½, 40-50 µm profile (as per AS1627.4).

Application

Tintable up to 10% by weight with Nason Industrial ST tinters.

- Mixing Ratio: 4:1 with 750-82 Nason® Industrial 2K ZP Epoxy Primer Activator
- Reducer: Conventional: 20 – 30% 861-62 Nason® Industrial Epoxy Reducer/821-65 Nason Industrial Multi Thinner
- Airless: 10 – 20% 861-62 Nason® Industrial Epoxy Reducer/821-65 Nason Industrial Multi Thinner
- Pot Life: 6 hours @ 20°C

Gun Setup

• Pressure Pot:	1.3 – 1.6 mm	1 - 2 bar	35 – 50 psi
• Conventional:	1.8 – 2.0 mm	3 – 4 bar	45 – 60 psi
• Airless Spray:	0.33 – 0.36 mm	min. 2000 psi	
• HVLP:	1.6 – 1.8 mm	0.7 bar	10 psi

Refer to spray equipment documentation for setting recommendations.

- Number of coats: 1 - 2
- Flash-off between coats: 10 - 15 minutes

Application Condition

Do not apply if material, substrate or ambient temperature is less than 10°C or above 45°C. The substrate must be at least 3°C above the dew point. Relative humidity should be below 90%.

Table 1 – Reducer Selection Guide

Ambient Temperature			10°C 15°C 20°C 25°C 30°C 35°C 40°C
Nason® Industrial 2K ZP Epoxy Primer	Air Dry or Bake (30 min @ 60°C)	821-65	
		861-62	

Cleanup Solvents

Recommended gun cleaning thinner.

Dry Film Characteristics*

Maximum Service Temperature:	90ºC (continuous service)
Exterior Exposure:	VERY GOOD
Water Resistance:	VERY GOOD
Chemical Resistance:	VERY GOOD
Abrasion Resistance:	VERY GOOD

Overcoating

With NI600, or NI610/620 2K PU with ST tint based topcoats.

Wet-on-wet: 30 – 60 minutes (max. 5 days)
With sanding: (min. 8 hours @20C or overnight)
Dry: P320 – P400 (dry orbital sander with exhaust)
Wet: P600 – P800
Note: Light de-nibbing is possible after 4 – 6 hours

Shelf Life

24 months minimum in sealed original container.
Store at room temperature away from direct sunlight

Availability

Nason® Industrial 2K ZP Epoxy Primer off-white	16 L	650-04
Nason® Industrial 2K ZP Epoxy Primer off-white	3.2 L	650-04
Nason® Industrial 2K ZP Epoxy Primer Activator	4 L	750-82
Nason® Industrial 2K ZP Epoxy Primer Activator	0.8 L	750-82
Nason® Industrial Epoxy Reducer	20 L	861-62
Nason® Industrial Epoxy Reducer	4 L	861-62
Nason® Industrial Multi Thinner	20 L	821-65
Nason® Industrial Std High OH 2K PU binder	10 L	ST100-610
Nason® Industrial Std High OH 2K PU binder	20 L	ST100-610
Nason® Industrial Std 2K PU binder	10 L	ST100-620
Nason® Industrial Std 2K PU binder	20 L	ST100-620