



# BIPOX 2C HB ZINC PHOSPHATE PRIMER

*2C high build zinc phosphate primer based on epoxy resin*

## Description

Bipox 2C HB Zinc Phosphate Primer [6142] is a solvent based 2C high build zinc phosphate primer based on epoxy resins and a polyamide hardener.

## Properties

- Durable 2C high build epoxy zinc phosphate primer
- Excellent anticorrosive properties
- Suitable for both steel and non-ferrous.
- High build; can be applied easily in thick layers
- Filling power
- Highly chemical resistant
- Suitable for spraying
- Bipox 2C products are lead and chromate free
- Available in almost any colour of the BC-S 8200 CMS

## Typical Applications

Suitable for various heavy industrial applications structures having to meet stringent requirements on corrosion protection and on durable finishes.

For example: chassis, vehicles, containers, machinery, steel structures, etc.

**Not suitable for structures immersed in water.**

## Substrates

- Steel
- Blasted steel (SA 2,5 blasted or hand cleaned ST 3)
- Several non-ferrous metals
- Galvanised steel
- Aluminium
- Intact old paint layers

## Technical Specifications

(ready mixed product at 20°C)

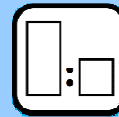
Finish	: mat
Gloss level (°)	: not measured
Colour	: almost any colour by BICCS CMS BCS-8200
Theoretical consumption:	approx. 5 m <sup>2</sup> /ltr. at 100 µm DFT
Specific gravity	: 1,35 g/ml (depending on colour)
Solids content	: 67% by weight / 50% by volume
Flashpoint	: 26°C
Application conditions	: min. 10°C / 80% R.V.
VOC content	: 433 g/l
Shelf life in can	: 24 months in original unopened packaging, stored at 5 – 30°C. Frostproof storage.

## APPLICATION INSTRUCTIONS



### Pre-treatment

The surface needs to be entirely clean, dry and degreased. Old, intact paint layers need to be abraded/sand papered. Pre-treatment (also) depends on the substrate, but in any way needs to be done in such a way that a solid and suitable substrate is obtained, suitable to be painted. See the additional info in this sheet.



### Mixing ratio BC-S Colourants, 8200 series:

Add 10% BC-S Colourants (by volume)

### Mixing ratio Hardener

Hardener : Bipox 2C Hardener for ZPH [6142b]  
Mixing ratio : 5:1 by volume (base:hardener)  
Potlife : ca. 6 hours at 20°C

**Pay attention!** *Basecoat and hardener have to be mixed carefully mechanically on the right scale. Because of quality loss, do not use products after expired potlife.*

### Viscosity and thinning

BICCS Thinner 0104 [9164]

Airspray, max.: 10 – 20% / Airless, max.: 5 – 10%



### Airspray

Nozzle : 1.8 – 2.0  
Pressure : 3 to 4 bar  
Viscosity : 20 – 30 sec., DIN cup 4

### Airless

Nozzle : 0.013" - 0.015"  
Pressure : 140 – 160 bar  
Viscosity : 30 – 50 sec., DIN cup 4

### Spraying instructions

If necessary, multiple cross-coats

### Recommended film thickness

Min. 200 µm WFT < > 100 µm DFT

Note: indicative layer thickness per layer. For system layer thicknesses in accordance with ISO 12944 (see 'BICCS Paint Systems', www.biccs.nl) or contact your account manager or the Technical Support department for project-based advice.

### Tool cleaning:

Washing thinner or BICCS Thinner 0104 [9164]



Data at 20°C  
and 65% RH

### Drying times

Dust-free : approx. 30 minutes  
Tack-free : approx. 60 minutes  
For re-spraying : 'wet-in-wet', after initial drying. (after 2 days, a little sanding is then required)  
For sanding : approx. 24 hours  
Hard drying time : after 7 days

## Additional information

Bipox 2C HB Zinc Phosphate Primer [6142] can also be applied by brush, in case of small surfaces and when flowing behaviour is no priority. The Bipox 2C Hardener for HB Zinc Phosphate Primer [6142b] cannot be replaced by other Bipox hardeners.

By using specific corrosion resistant pigments and fillers, the blanc base paint is somewhat grey coloured. This may result in colour deviation, especially in case of light and bright shades. The Bipox 2C Hardener for HB Zinc Phosphate Primer [6142b] causes a strong colour deviation when combined with colour paste L maroon red and K organic orange. Because of that the bright red and orange series cannot be produced, as well as some other colour series. The CMS (Colour Mixing System) software is conclusive.

<b>Example paint system</b>	1st layer	: Bipox 2C HB Zinc Phosphate Primer [6142]	dft 100 µm
	2nd layer	: Bipox 2C HB Midcoat [6145]	dft 60 µm
	3rd layer	: Bichodur 2C (DTM) enamels	dft 60 µm

Besides this conventional spray quality also available:

- Bipox 2C HB Zinc Phosphate Primer Ready Mixed 1013 [6146] in standard colour approx. RAL1013

### Warning/restricted applicability

Considering the great diversity of purpose-specific aluminium alloys available in the market, it is impossible for us to recommend one single coating system that will apply to all kinds of aluminium. Our product data is generally based on pure, unalloyed aluminium, also known as the 1000 series.

(<sup>1</sup>) Due to variable pigment content of/in the colour pastes, gloss degree of the end product may vary somewhat. Data in our datasheets are based on the average gloss degree of the RAL K7 colours, measured under an angle of 60° according to ISO 2813.

## Pre-treatment

To prevent recurrent corrosion, the object/item needs to be coated immediately after blasting/grinding/degreasing. If there is any doubt about what's beneath the surface and/or about the pre-treatment, you always must do a trial to judge adhesion.

## Application conditions

Data in this publication are based on a temperature of 20°C and a RH of 65%. In case of higher film thicknesses and/or lower temperatures, longer drying times apply. During application and drying, avoid temperatures lower than 10°C and an RH higher than 80%. Temperature of the object to be sprayed must be at least 3°C above dew point. See the dew point table on the download page of our website ([www.biccs.nl](http://www.biccs.nl)). Good ventilation is required during application and drying.

## Safety

Only for professional use. See the appropriate safety datasheet, downloadable from our website: [www.biccs.nl](http://www.biccs.nl).

*For more information, please contact your BICCS account manager or the Technical Support department.*

The information provided in this product data sheet is based on precision testing carried out in our laboratory, and is intended solely as a guideline. All recommendations and suggestions related to the use of products produced by PearlPaint Group, including but not limited to that provided in technical documentation or in response to a specific question, is based on data that we have compiled to the best of our knowledge. The products and information are intended for users in possession of the required specific knowledge and industrial skills, and the suitability of any product for any purpose whatsoever remains at all times the responsibility of the end user. PearlPaint Group has no knowledge of the quality or condition of the substrate, nor of the many factors that can influence the use and application of the product. PearlPaint Group therefore accepts no liability of any kind pertaining to loss or damage as a consequence of using or referring to this data sheet, except where otherwise agreed in writing.

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