BIPOX 2C HB ZINC PHOSPHATE PRIMER RM 1013

2C high build zinc phosphate primer based on epoxy resin

Description

Bipox 2C HB Zinc Phosphate Primer RM 1013 [6146] 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
- Lead and chromate free
- Suitable for spraying
- Available in standard colour RAL 1013
  (Note: if desired limited tintable to a shade of grey)

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)
- Galvanized steel
- Aluminium
- Several non-ferrous metals
- Intact old paint layers

Technical Specifications

(ready mixed product at 20°C)

Finish	:	mat
Gloss level (¹)	:	not measured
Colour	:	RAL1013 (limited tintable)
Theoretical consumption	:	approx. 5,5 m²/ltr. at 100 µm DFT
Specific gravity	:	1,42 g/ml (depending on colour)
Solids content	:	72% by weight / 54% by volume
Flashpoint	:	25°C
Application conditions	:	min. 10°C / 80% R.V.
VOC content	:	403 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 abrabed/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 Hardener

Hardener	:	Bipox 2C Hardener for ZPH RM1013 [6146b]
Mixing ratio	:	4:1 by volume (base:hardener) 6,5:1 by weight (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.***

Application
Airless, airmix, HVLP, airspray

Viscosity and thinning
BICCS Thinner 0104 [9164]
Max. 15 – 20% - Airspray / Max. 0 – 5% - Airless

Airspray/HVLP

Nozzle	:	1.5 – 2.5
Pressure	:	3 to 5 bar
Viscosity	:	20 – 30 sec., DIN cup 4

Airless/airmix

Nozzle	:	0.011”- 0.013”/60
Pressure	:	140 – 160 bar
Viscosity	:	35 – 45 sec., DIN cup 4

Spraying instructions
If necessary, multiple cross-coats

Recommended film thickness
Min. 190 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]

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 4 days

Data at 20°C and 65% RH

Additional information

Because of its excellent adhesion characteristics, Bipox 2C HB Zinc Phosphate Primer RM 1013 [6146] is very suitable to be applied on non-ferrous metals. Furthermore, this product [6146] has excellent flow characteristics and is therefore extremely suitable for 'wet-in-wet' application; chances of need to respray is null. After drying very suitable for sandpapering.

Example paint system	1st layer:	Bipox 2C HB Zinc Phosphate Primer RM1013 [6146]	dft 100 µm
	2nd layer:	Bipox 2C HB Midcoat [6145]	dft 60 µm
	3rd layer:	Bichodur 2C (DTM) enamels	dft 60 µm

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.

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). 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.

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

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