



BICHOLUX QD HB Zinc Phosphate Primer

PRODUCT CODE: 1242

Description

Bicholux QD HB Zinc Phosphate Primer is a very fast-drying high build zinc phosphate primer based on short oil alkyd resins.

Features

- excellent anticorrosive properties against environmental and climatic factors
- can be applied in thick layers
- good filling power
- very fast-drying

Uses

For industrial applications, truck chassis, container manufacture and steel construction.

Specifications

(tinted product at 20°C)

Finish	: matt
Gloss level (60°)	: n.a.
Colour	: using BICCS colour mixing system
Theoretical coverage	: 7.2 m ² /l. at 70 µm dry film thickness
Specific gravity	: 1.35 g/ml
Solids content	: 68% wt. / 50% vol.
Flash point	: 21°C
Application conditions	: min. 5°C / 80% R.H.
VOC content	: 430 g/l
Shelf life in can	: min. 1 year in original, unopened packaging (5 – 25°C)

Substrates

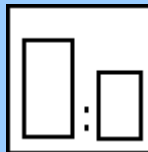
Intact existing paint layers
Steel
Blasted steel

APPLICATION INSTRUCTIONS



Surface preparation

The surface must be completely clean, dry, and free of grease and rust.
First sand old and intact paint layers.



Mixing ratio

See BICCS recipes for the addition of colour pastes.

Hardener

See also the additional information.

Viscosity and thinning

BICCS Thinner 0102
Max. 5 – 20%.



Air spray

Nozzle 1.8 – 2.5, 3 to 5 bar
20 – 40 sec. DIN cup 4

Airless

Nozzle 0.0011" - 0.013"
130 – 150 bar
40 – 60 sec. DIN cup 4

Spraying instructions

Spray a thin base layer, followed by 1 – 2 cross-coats.

Recommended film thickness

Min. 150-215 µm wet
Min. 70-100 µm dry.

Tool cleaning

Washing thinner or BICCS thinner 0102



Drying times

Touch-dry	approx. 30 minutes
Tack free	after approx. 60 minutes
For re-spraying	after initial drying
For sanding	approx. 24 hours
Cured	approx. 7 days



Data at 20°C and 65% RH



Additional Information

Bicholux QD HB Zinc Phosphate Primer can also serve as an alternative for a two component primer. In this case, Bichodur 2K Hardener must be added to the Bicholux QD HB Zinc Phosphate Primer in the proportions 6 : 1 by volume. The potlife is then approx. 4 hours.

Among the improvements this gives:

- better curing
- better sanding result
- a considerably better sag resistance when spraying additional layers

Re-spraying: May be re-sprayed after initial drying, but within max. 4 hours (after this period there is a risk of lifting) or after complete curing.

Safety

See the appropriate safety sheet

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Dukdalfweg 41 – 1332 BK Almere – Postall address: P.O. Box 30109 – 1303 AC Almere – The Netherlands
Telephone: +31 (0)36 – 5492066 – Fax: +31 (0)36 – 5370286 – www.biccs.nl – Email: info@biccs.nl

INDUSTRIAL COATING & COLOURANT SYSTEMS

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