



BIPOX HB Zinc Phosphate Primer

PRODUCT CODE: 6142

Description

BIPOX 2K HB Zinc Phosphate Primer is a high-build 2 component anticorrosive primer based on epoxy resins.

Features

- good adhesion to steel and non-ferrous substrates
- spreads very smoothly
- active corrosion inhibition
- highly chemical-resistant

Uses

In protective coating systems for steel and non-ferrous metals.

For containers, steel structures and other industrial applications where stringent demands apply to the finish.

Specifications

(tinted mixed product at 20°C)

Finish	: matt
Gloss level (60°)	: n.a.
Colour	: using BICCS colour mixing system
Theoretical coverage	: 5m ² /l at 100 µm dry film thickness
Specific gravity	: 1.35 g/ml
Solids content	: 67% wt. / 50% vol.
Flash point	: 26°C
Application conditions	: min. 5°C / 80% R.H.
VOC content	: 442 g/l
Shelf life in can	: min. 1 year in original, unopened packaging (5 – 25°C)

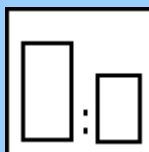
APPLICATION INSTRUCTIONS



Surface preparation

The surface must be completely clean, dry, and free of grease and rust.

First sand old and intact paint layers.



Mixing ratio

5 : 1 by volume

Hardener

Bipox Hardener for Zinc Phosphate Primer

Potlife

6 hours



Viscosity and thinning

BICCS Thinner 0104

Max. 10 – 20% - Air spray

max. 5 – 10% - Airless spray

Air spray

Nozzle 1.8 – 2.0, 3 to 4 bar

20 – 30 sec. DIN cup 4

Airless

Nozzle 0.013" - 0.015"

140 – 160 bar

30 – 50 sec. DIN cup 4



Spraying instructions

If necessary, multiple cross-coats.

Recommended film thickness

Min. 200 µm wet

Min. 100 µm dry.

Tool cleaning

Washing thinner or BICCS thinner 0104

Drying times

Touch-dry approx. 30 minutes

Tack free approx. 60 minutes

For re-spraying 'wet in wet' immediately after matting. After 2 days should first be sanded.

For sanding approx. 24 hours

Cured approx. 7 days



Data at 20°C and 65% RH



Substrates

Steel, grit-blasted steel and zinc-plated steel.
Old intact paint layers, clean, dry, free of grease, rust and contamination and adequately roughened if necessary.

Additional Information

Bipox HB Zinc Phosphate Primer is ready-to-use for brush application to small areas. The hardener for Bipox HB Zinc Phosphate Primer is not interchangeable with the hardener for Bipox HB Midcoat.

The use of specific anticorrosive pigments and fillers gives the semi-transparent base a drab colour. Colour deviance may take place with light and clear colours. The Bipox HB Zinc Phosphate hardener causes a strong colour deviance when used in combination with colour pastes L (maroon red) and K (organic orange). This means the red series cannot be made up.

Warning/restricted applicability

Considering the great diversity of purpose-specific aluminium alloys available in the market, it is impossible for us to recommend a 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.

Safety

See the appropriate safety sheet

Version : 2.0
Date of publication : January 2005

The information provided in this product information sheet is based on accurate 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 BICCS, 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. BICCS bv 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. BICCS therefore accepts no liability of any kind pertaining to loss or damage as a consequence of the use of or reference to this data sheet, except where otherwise agreed in writing.

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INDUSTRIAL COATING & COLOURANT SYSTEMS

N.B. De technische gegevens in deze publicatie steunen op onze huidige kennis. Zij gelden als aanduiding en leveren u vrijblijvend een beeld van de toepassingsmogelijkheden van onze producten. De gegevens kunnen door een recentere uitgave gewijzigd worden.

Please note: The technical data in this publication are based on our current knowledge. These should be regarded as indicative, providing an impression of possible applications of our products without obligations. The data may be updated or changed in future editions.