



# BIPOX HB Zinc Phosphate Primer ready-mixed Ral 1013

**PRODUCT CODE: 6146**

## Description

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

In the colour RAL 1013. For grit-blasted and non blasted steel structures.

## Features

- high filling power
- good adhesion to steel and non-ferrous substrates
- spreads very smoothly
- active corrosion inhibition
- highly chemical-resistant
- high-build structure

## Uses

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

For containers, road tankers, chassis, steel structures and other industrial applications with stringent requirements for protection and finish. Not suitable for underwater applications.

## Specifications

(tinted mixed product at 20°C)

Finish	: matt
Gloss level (60°)	: n.a.
Colour	: RAL 1013 (RAL 7040 on request)
Theoretical coverage	: 5.5 m <sup>2</sup> /l at 100 µm dry film thickness
Specific gravity	: 1.42 g/ml (mixed)
Solids content	: 72% wt. / 54% vol.
Flash point	: 25°C
Application conditions	: min. 5°C / 80% R.H.
VOC content	: 403 g/l
Shelf life in can	: min. 1 year in original, unopened packaging (5 – 25°C)

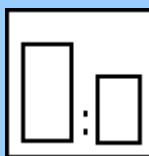
## APPLICATION INSTRUCTIONS



### Surface preparation

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

First de-grease and sand old and intact paint layers. Grit-blast steel to surface quality SA 2.5 or mechanically brush to surface quality ST3.



### Mixing ratio

4 : 1 by volume  
6.5 : 1 by weight

### Hardener

Bipox Ready-mixed hardener

### Potlife

6 hours at 20°C



### Method of application

Airless, airmix, HVLP, air spray

### Viscosity and thinning

BICCS Thinner 0104  
Max. 15 – 20% - Air spray  
Max. 0 – 5% - airless

### Air spray/HVLP

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

### Airless/Airmix

Nozzle 0.011" - 0.013"/60  
140 – 160 bar  
35 – 45 sec. DIN cup 4



### Spraying instructions

If necessary, multiple cross-coats.

### Recommended film thickness

Min. 190 µm wet  
Min. 100 µm dry.  
Depends on the method of applications.

### Tool cleaning

Washing thinner or BC 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. 4 days

Data at 20°C and 65% RH



## Substrates

Steel, grit-blasted steel and non-ferrous substrates.  
Old intact paint layers, clean, dry, free of grease, rust and contamination and adequately roughened if necessary. Grit-blast steel to surface quality SA 2.5 or mechanically brush to surface quality ST 3.

## Additional Information

BIPOX HB Zinc Phosphate Primer ready-mixed is ready-to-use for brush application to small areas. The thinner is BC Thinner 0110.

BIPOX HB Zinc Phosphate Primer ready-mixed has excellent adhesion to non-ferrous metals. Moreover, the product has very good spreading characteristics and is especially suitable for 'wet-in-wet' application, with the risk of overspray being practically nil. Very readily sanded when dry.

**Example paint system**

- 1<sup>st</sup> layer: BIPOX HB Zinc Phosphate Primer ready-mixed  
dft 100 µm
- 2<sup>nd</sup> layer: Bipox HB Midcoat  
dft 60 µm
- 3<sup>rd</sup> layer: Bichothane 2K PU 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 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

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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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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

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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.