



BICHOLUX QD HB ZINC PHOSPHATE PRIMER

Fast drying 1C high build zinc phosphate primer based on alkyd resins

Description

Bicholux QD HB Zinc Phosphate Primer [1242] is a solvent based very fast-drying 1C high build zinc phosphate primer based on short oil alkyd resins.

Properties

- Very fast drying
- Excellent anticorrosive properties
- High build; can be applied easily in thick layers
- Good filling power
- Bicholux QD products are lead- and chromate-free
- Available in all colours by the BC-S 8200 CMS

Typical Applications

Suitable for various industrial applications such as machinery, containers, steel and other constructions.

Substrates

- Steel
- Grit blasted steel
- Intact old paint layers

(Please note: NOT suitable for non-ferrous metals)

Technical Specifications

(ready mixed product at 20°C)

Finish	: matt
Gloss level (°)	: not measured
Colour	: all colours by BICCS CMS BCS-8200
Theoretical consumption	: approx. 7,2 m ² /ltr. at 70 µm DFT
Specific gravity	: 1,35 g/ml (depending on colour)
Solids content	: 68% by weight / 50% by volume
Flashpoint	: 21°C
Application conditions	: min. 10°C / 80% R.H.
VOC content	: 438 g/l
Shelf life in can	: 12 months in original unopened packaging, stored at 5 – 30°C. Frostproof storage.

APPLICATION INSTRUCTIONS



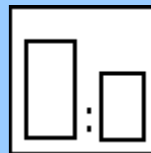
Pre-treatment

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. Please contact our Technical Department for further enquiries.

Application

Spray



Mixing ratio BC-S Colourants, 8200 series:

Add 15% BC-S Colourants (by volume)

All available colours Bicholux QD HB Zinc Phosphate Primer [1242] are lead- and chromate free.

Thinner :

(standard) BICCS Thinner 0102 [9162] or (slow) BICCS Thinner 0103 [9163], ca. 5 – 20%.



Airspray

Nozzle : 1,8 – 2,5
Pressure : 3 to 5 bar
Viscosity : 20 – 40 sec., DIN cup 4

Airless

Nozzle : 0.011" - 0.013"
Pressure : 130 – 150 bar
Viscosity : 40 – 60 sec. DIN cup 4



Spraying instructions

If necessary, multiple cross-coats

Recommended film thickness

Min. 150-215 µm WFT < > 70-100 µm DFT

Tool cleaning:

Washing thinner or BICCS Thinner 0102 [9162]



Drying times

Dust-free : approx. 30 minutes
Tack-free : approx. 60 minutes
For re-spraying : after initial drying
(see also: 'Additional information')
For sanding : after 24 hours
Hard drying time : after 7 days

Data at 20°C and 65% RH



Additional information

Bicholux QD HB Zinc Phosphate Primer[1242] can also serve as an alternative for a two component primer. In this case, Bichodur 2C Projecthardener [9086] must be added in the proportions 6 : 1 (base:hardener) by volume. Potlife is approx. 4 hours.

This results in (also):

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

(¹) 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.

Clarification re-spraying

Re-sprayability depends on several factors such as temperature, humidity and layer thickness. In order to exclude chances of wrinkling or smouldering we advise to re-spray 'wet-in-wet', within 4 hours or after 24 hours (including abrading in between!). Please contact your BICCS account manager or the BICCS Technical Department in Almere, for further technical advice on this subject.

N.B. Data in all our publications are based on the compatibility of our BICCS products.

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%. The 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 about this product please contact our laboratory by phone or email.

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 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 using or referring to this data sheet, except where otherwise agreed in writing.

The information in this data sheet is subject to amendment, and is the result of practical experience and continuous product development. This data sheet replaces all earlier publications, and it is therefore the responsibility of the user to make certain that this sheet is the correct version for the product, before starting to use the product.