

# SIPKYD ZINCPHOS 420

## Alkyd Based Zinc Phosphate Primer

Product No. 6420

### Features

- Excellent protection at economic cost.
- One pack primer.
- Chromate free.
- Environmentally friendly alternative to Zinc Chromate

### Recommended Use

- As a primer or intermediate coat in an alkyd based system on steel surfaces in mild to moderately corrosive industrial and marine environments.

### Physical Data

**Finish** : Flat

**Colour** : Grey / Oxide Red

**Volume Solids** : 50%

**Recommended Film Thickness:**  
40 microns dry = 83 microns wet

**Theoretical Coverage:**  
12.5 m<sup>2</sup>/ltr. at 40 microns

**Density** : 1.3 kg/ltr.

#### Drying and Recoating Times (25°C/65% RH):

Dry to Recoat : 12 Hours  
Hard Dry : 16 Hours  
Maximum recoating time : 06 Months

**Heat Resistant** : 90°C

**Flash Point** : 42°C

### Specification Data

#### Preparation

The substrate should be thoroughly degreased in accordance with SSPC-SP1. All burrs should be removed and sharp edges or rough weld seams should be ground down.

Dry shot or grit blasting is recommended, the required standard of cleanliness being in accordance with ISO (1508501-2) Sa 2 or SSPC-SP6 or better.

All blasting equipment should be of an approved type and fitted with a suitable moisture trap and grease/oil filters. Ensure that all dust, loose abrasive particles and other foreign matter are removed from substrate prior to painting.

In case blast cleaning is not possible, substrates should be power tool cleaned according to Swedish Standard St3 or SSPC SP3.

## Application Data

<b>Thinning</b>	The paint is supplied ready for brush or airless spray application. If the paint is too thick, in cold weather for example, then add a small amount Thinner 710 to obtain the suitable viscosity. The amount of thinner that may be added is dependent on the application conditions and methods. Overthinning will lead to poor results.	
<b>Application Conditions</b>	Application temperature: 5 - 50°C. The minimum temperature required for satisfactory drying is 5°C. The surface temperature must be at least 3°C above the dew point to prevent condensation. Never apply paint under adverse weather conditions.	
<b>Mixing Advice</b>	Prior to application, mix paint thoroughly to obtain a homogeneous product. Use a mixer, which is powered by air or a flameproof electric motor.	
<b>Application Methods and Details</b>	Recommended Thinner	<u>Airless spray</u> Type 710
	Thinner Addition	Approx. 5% vol.
	Nozzle Orifice	0.015" - 0.019"
	Working Pressure	140 - 160 bar
	<u>Brush/Roller</u>	
	Recommended Thinner	Type 710
	Thinner addition	Approx. 5% vol.
	The recommended method of application is by airless spray. However, brush, roller or conventional spray may also be used. Where brush and roller are to be used it will be necessary to apply multi-coats in order to achieve the required film thickness.	
<b>Cleaning of Equipment</b>	Use Thinner 710.	

## Storage Information

<b>Pack Size</b>	5 and 20 ltr. (Single component material)
<b>Storage</b>	Store generally in original sealed container, indoors, at a temperature between 5 and 40°C and relative humidity below 70%.
<b>Shelf Life</b>	1 Year

## Safety Information

See the material safety data sheet and product label for complete safety and precaution requirements.

## Disclaimer

The information in this data sheet represent test results or experience under well defined conditions. Its accuracy or suitability under the actual conditions of any intended use is not guaranteed and must be determined by the user. All advice given about this product is given in good faith. Since as we have no control over conditions of substrate and application, manufacturer and seller can not accept any liability in connection with the use of the product relative to coverage, performance, injury or damage, unless we specifically agree in writing to do so. The information in this data sheet is subject to change without notice and it is the user's responsibility to ensure it is current. For further information and advice contact SIPCO Technical Services Department on Tel. (03) 847 2299, Fax (03) 847 3780.