

Stokes HB Zinc Phosphate Primer

Product Description	An economical, fast drying, alkyd zinc phosphate primer for steelwork.				
Features & Use	<ul style="list-style-type: none"> • Excellent drying and enamel hold-out • Good adhesion and corrosion resistance • Extended wet-edge time for ease of brush application • Use as a primer for metal fabrications, process equipment, machine tools and other surfaces where fast drying properties are required 				
Approvals/ Certification	Please consult Spencer Coatings				
Finish	Matt				
Volume Solids	44 ± 2% (varies with colour)				
VOC Content	475 ± 20 g/litre (varies with colour)				
Film Thickness Range And Coverage		Dry Film Thickness	Wet Film Thickness	Theoretical Coverage	
	Minimum	40 µm	91 µm	11.0 m ² /litre	
	Maximum	75 µm	170 µm	5.8 m ² /litre	
Practical coverage depends on the application method, painting conditions and the shape and roughness of the surface to be coated					
Drying Times	Applied to 50 microns DFT	+10°C	+23°C	+35°C	
	Dust Free	1½ hr	40 min	20 min	
	Hard Dry	3 hr	1½ hr	1 hr	
	Overcoating	Minimum	3 hr	2 hr	1 hr
		Maximum	Indefinite if surface is clean and sound		
Drying and recoating times are related to the film thickness, temperature, the relative humidity of the air and ventilation					
Colours	Red Oxide (IP001), Grey (IP002), Black (IP004)				
Product Code	20QDP-REO, 20QDP-GRY, 20QDP-BLA				
SG	1.42 kg/lt (varies with colour)				
Storage Conditions	Store in dry, cool conditions and protect from frost				
Shelf Life	Minimum 12 months if stored as above in unopened containers				
Flash Point	23-60°C				

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<p>Surface Preparation</p>	<ul style="list-style-type: none"> All surfaces to be coated should be dry and cleaned as necessary to remove all oil, grease, salts, weld flux or other contamination. Where necessary, remove weld spatter and grind smooth all sharp edges and weld seams Steel: blast clean ideally to Sa2½ (ISO 8501-1:2007), minimum of Sa2, surface profile 50-75 microns; alternatively hand prepare to St2 standard, taking care to avoid 'polishing' the surface. Performance will depend on the degree of surface preparation achieved Non-ferrous surfaces: consult Spencer Coatings for advice on appropriate adhesion primer 														
<p>Mixing</p>	<p>Must be mixed thoroughly by using a mechanical agitator before use. Agitate periodically to ensure paint remains homogeneous.</p>														
<p>Thinner</p>	<p>No.7 Thinner</p>		<p>Equipment Cleaner No.7 Thinner</p>												
<p>Application Conditions</p>	<p>Only apply in conditions of good ventilation which must be maintained during drying and curing. Do not apply when rain, mist, sleet or snow are imminent. During application and drying time of the paint coating, the surface should be dry, the Relative Humidity should not exceed 85% and the steel temperature should remain at least 3°C above the dew point. Paint temperature should ideally be at a minimum of 15°C.</p>														
<p>Application Methods</p>	<table border="1"> <thead> <tr> <th data-bbox="432 949 687 1021">Method</th> <th data-bbox="687 949 935 1021">Airless Spray</th> <th data-bbox="935 949 1182 1021">Conventional Spray</th> <th data-bbox="1182 949 1353 1021">Brush</th> <th data-bbox="1353 949 1501 1021">Roller</th> </tr> </thead> <tbody> <tr> <td data-bbox="432 1021 687 1077"></td> <td data-bbox="687 1021 935 1077">Yes*</td> <td data-bbox="935 1021 1182 1077">Yes</td> <td data-bbox="1182 1021 1353 1077">Yes</td> <td data-bbox="1353 1021 1501 1077">Yes</td> </tr> </tbody> </table>	Method	Airless Spray	Conventional Spray	Brush	Roller		Yes*	Yes	Yes	Yes				
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<ul style="list-style-type: none"> This product is primarily designed for brush application as supplied. Roller application may also be used but film thicknesses may be lower *For airless spray application, Speedspray QDH or Speedspray CM5 are recommended Thin the coating for conventional spray if required (up to 5-10% typical) but hold-up properties will be considerably reduced 															
<p>Product Notes</p>	<ul style="list-style-type: none"> Apply two coats of primer in more severe environments or where a topcoat is not to be used In common with most alkyd primers, this product is not recommended for extended exterior exposure, exposure in aggressive or coastal locations, or for immersion. Epoxy primers are preferred for these conditions, please consult Spencer Coatings for specification advice 														
<p>Health & Safety</p>	<p>Containers are provided with safety labels which should be observed. Further information about hazardous influences and protection are detailed in individual Product Safety Data Sheets. A Safety Data Sheet for this product is available on request from Spencer Coatings.</p>														