

Firwood 76

Two Pack Zinc Phosphate HB Primer

Description	A two pack epoxy anticorrosive primer for steelwork.
Finish	Matt.
Features	<ul style="list-style-type: none"> • Contains zinc phosphate anticorrosive pigment for excellent protection. • Designed as a primer/finish for steelwork, chassis and similar items. • For use in exterior exposure applications in industrial atmospheres.
Complies With	2004/42/EC (2012) sub-category A(j) - VOC level below 500 g/l.
Product Code	76- .
Volume Solids	50% ± 2%.
VOC's	Below 435 g/l.
Colour Range	Steel White.

Film Thickness & Coverage		<u>Dry</u>	<u>Wet</u>	<u>Theo. Coverage</u>
	Rec. Min:	50 µm	100 µm	10.0 m ² /l
Rec. Max:		100 µm	200 µm	5.0 m ² /l

Actual coverage varies considerably with factors including surface porosity, roughness, application methods and conditions.

Drying & Overcoating Times at Typical DFT		<u>10°C</u>	<u>20°C</u>	<u>30°C</u>
	Surface Dry:	8 h	3 h	1½ h
	Hard Dry:	24 h	12 h	8 h
	Overcoat Min:	12 h	6 h	4 h
	Overcoat Max:	7 days	7 days	7 days

Drying and overcoating times can be greatly affected by method and conditions of application such as thickness applied, temperature, ventilation etc. Data above are given as a guide.

TECHNICAL DATA SHEET**Firwood 76****Two Pack Zinc Phosphate HB Primer**

Surface Preparation	<ul style="list-style-type: none">• All steel surfaces to be coated should be dry and cleaned as necessary to remove all rust, mill scale, grease and other contamination. Where necessary, remove weld spatter and grind smooth all sharp metal edges and weld seams.• Ideally, abrasive blast clean to standard Sa2½ (ISO 8501-1:2007), with a surface profile of 50-75 microns.• For areas where abrasive blast cleaning is not possible, the surface should be prepared by hand or mechanical means to standard St2 (ISO 8501-1:2007), with care required to avoid 'polishing' the metal surface. Coating lifetime will be significantly reduced if not blast cleaning.
Mixing	Mix each component separately, and then thoroughly mix together in the mix ratio stated, using a power mixer. Stir occasionally during use to maintain an homogenous mix.
Pot Life at 20°C	8 hours (do not use after this time, even though material may still look fluid).
Mix Ratio	Base 4 volumes Activator 1 volume.
Application Conditions	Throughout the application and the drying/curing time of coatings: (a) good ventilation is required; (b) do not apply when damp weather conditions are likely; (c) the substrate temperature should be at least 3°C above the Dew Point; and (d) the RH (Relative Humidity) should be below 85%. It is advisable not to apply the product when the ambient temperature falls below 5°C. The paint temperature at the time of application should ideally be 15° - 20°C.
Application Details	<ul style="list-style-type: none">• Designed for application by airless spray. For conventional spray, thinning would be required and film build would not be achieved. Brush should be used only for small areas of touch-up.
Thinner/Cleaner	Firwood 67 Thinner.
SG	1.46 ± 0.15 kg/l mixed.
Flash Point	23° – 60°C.
Shelf Life	Min. 1 year from date of delivery when correctly stored in unopened containers.
Storage	The product should be stored in cool, dry, frost-free conditions, in sealed containers. Most paint materials will apply optimally when at 15° - 20°C.
Health & Safety	Refer to the product's Safety Data Sheet and safety advice on the product label before use.
Date of Issue	Sep 2023.

Information provided in this leaflet is given in good faith but without warranty or assumed liability, as the conditions of application and use are beyond our control. Data are accurate to the best of our knowledge at the time of issue but may be revised in the light of new knowledge and the user should check that data are current before use. The user must satisfy themselves about the product's suitability for their own purpose and refer to the Safety Data Sheet for this product before use. For industrial use only unless specifically stated otherwise.