



THE MAINTENANCE SOLUTOR  
http://www.alspec.com

## 414 ANTI-CORROSIVE ZINC PHOSPHATE PRIMER

### PRODUCT DATA:

- ◆ *Excellent Anti-Corrosive Property*
- ◆ *Good resistance to moisture*
- ◆ *Moderate resistance to aliphatic solvents*
- ◆ *Good resistance to abrasion and weather*

### PRODUCT INFORMATION

Designed to use a post fabrication primer in new construction for either conventional or chlorinated rubber systems.

Suitable as a primer for both interior or exterior conditions in moderately aggressive environments.

Can be applied as surface tolerant alkyd primer to most surfaces.

Capable of withstanding dry heat up to 175°C.

### APPLICATION:

#### PRACTICAL APPLICATION RATES

| Micron Per Coat | Airless Spray | Conventional Spray | Brush | Roller |
|-----------------|---------------|--------------------|-------|--------|
| Dry             | 75            | 75                 | 30    | 30     |
| Wet             | 160           | 160                | 64    | 64     |

#### AVERAGE DRYING TIME

| Ambient Temperature | Touch Dry | Hard Dry | Overcoating Interval |            |
|---------------------|-----------|----------|----------------------|------------|
|                     |           |          | Minimum              | Maximum    |
| 15°C                | 2 hours   | 24 hours | 24 hours             | Indefinite |
| 25°C                | 1 hours   | 12 hours | 16 hours             | Indefinite |
| 35°C                | 1/2 hours | 6 hours  | 8 hours              | Indefinite |

|                                 |   |
|---------------------------------|---|
| <b>Application Method</b>       | Brush/Roller, Conventional Spray and Airless Spray.   |
| <b>Mixing Ratio (by volume)</b> | None.   |
| <b>Thinner</b>                  | Thinner No. 1.  |
| <b>Thinner Consumption</b>      | Brush – 0-5%<br>Conventional Spray – 5-10%<br>Airless Spray – 0-5%  |
| <b>Airless Spray</b>            | Nozzle Size : 0.43-0.54mm (17-21 thou)<br>Fan Angle : 40°<br>Operating Pressure : 110-150 kg/cm <sup>2</sup> (1600-2100 psi)                      |
| <b>Conventional Spray</b>       | Nozzle Size : 1.27mm (50 thou)<br>Atomising Pressure : 3.5 kg/cm <sup>2</sup> (50 psi)<br>Fluid Pressure : 0.7-1.0 kg/cm <sup>2</sup> (10-15 psi) |
| <b>Brush</b>                    | This product is suitable for brush application..  |
| <b>Roller</b>                   | This product is suitable for roller application.  |



Application Method



65° Spraying Tip



Pratice Proper Cleaning





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### APPLICATION CONDITIONS AND OVERCOATING

This product should preferably be applied at temperature in excess of 10°C, In conditions of high relative humidity i.e. 80-85%, good ventilation conditions are essential. Substrate temperature should be at least 3°C above the dew point.

At application temperature below 10°C, drying and curing time will be significantly impaired.

**Application at temperature below 5°C is not recommended.**

If it is desired to overcoat outside the times stated on the data sheet, please seek advice from **Alspec** representative.

### PHYSICAL DATA:

|                              |  |
|------------------------------|--|
| <b>Volume Solid</b>          | 47%  |
| <b>Theoretical Coverage</b>  | 6.3 m <sup>2</sup> /litre @ 75 microns DFT |
| <b>Type</b>                  | One components                             |
| <b>Packing Ratio</b>         | None                                       |
| <b>Colour Availability</b>   | natural Red Oxide or Green                 |
| <b>Flash Point</b>           | 36°C                                       |
| <b>Recommended Thickness</b> | 75 microns DFT                             |
| <b>Recommended Thinner</b>   | Thinner No. 1                              |

### SURFACE PREPARATION:

**Steel :** Remove all wax, oil and grease by solvent cleaning in accordance with the guideline given by SSPC-SP1.

Soluble salt, dirt and dust must be removed prior to coating, Dry brushing should be sufficient. A fresh water wash must be followed to remove all soluble salts.

Mechanically clean the surface using hand and power tools to a minimum standard of St.2 (ISO8501-1:1988) or SSPC-SP2 to avoid polishing the surface.



GOLDEN ASIA AWARD FOR EXCELLENCE