BIPOX 2C HB ZINC PHOSPHATE COATING SILK GLOSS

2C high build zinc phosphate coating based on epoxy resin

Description

Bipox 2C HB Zinc Phosphate Coat ZGL [6143] is a solvent-based 2-component anti-corrosion zinc phosphate coating based on epoxy resin and a polyamide hardener.

Properties

- Very strong 2 component high build adhesion primer
- Excellent active anti-corrosive properties
- Suitable for both steel and non-ferrous metals.
- Easy to apply in high film thickness
- Filling capacity
- Chemical-resistant
- Lead and chromate free
- Suitable for spray application
- Available in all colours via the BC-S 8200 KMS

Applications

For a range of heavier industrial applications with the highest demands on corrosion protection and durability under severe conditions.

For example:
chassis, rolling stock, containers, machinery, steel structures, etc.

Not suitable for continuous exposure underwater.

Substrates

- Steel
- Blasted steel (SA 2.5 blasted or surface preparation grade ST 3)
- Galvanized steel
- Aluminium
- Miscellaneous non-ferrous metals
- Old, intact paint layers

Technical data

(mixed product at 20°C)

Finish	: silk gloss
Gloss level (60°)	: approx. 60 GU (depending on colour)
Colour	: all colours by BICCS ICS BC-S (8200 series)
Theoretical consumption	: approx. 5.5 m²/ltr. at 100 µm dry film thickness
Specific gravity	: 1.40 g/ml (mixed product)
Solids content	: 70% by weight / 53% by volume
Flash point	: 25°C
Application conditions	: min. 10°C / 80% RH
VOC content	: 410 g/l
Shelf life in can	: 24 months in original unopened packaging (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 sanded well. Pre-treatment depends in part on the substrate but should always be done in such a way (cleaning, degreasing, blasting/mechanical sanding, etc.) that a solid and suitable substrate is obtained that is suitable to be painted. See also 'Pre-treatment'

Mixing ratio hardener

Hardener	: Hardener for Bipox 2C HB Zinc phosphate coating ZGL [6143]
Mixing ratio	: 4:1 (base:hardener) by volume 6.5:1 (base:hardener) by weight
Pot life	: approx. 6 hours at 20°C

Note! Carefully mix basecoat and hardener mechanically in the correct ratio to reach a homogeneous mixture. Due to quality loss, do not use product after the pot life has expired.

Processing method

Airless, airmix, HVLP, airspray

Viscosity and thinning

BICCS Thinner 0104 [9164]
Max. 15-20% - airspray / Max. 0-5% - airless

Airspray/HVLP

Nozzle: 1.5-2.5
Pressure: 3 to 5 bar
Viscosity: 20-30 sec, DIN cup 4

Airless/Airmix

Nozzle: 0.011"- 0.013"/60
Pressure: 140-160 bar
Viscosity: 35-45 sec, DIN cup 4

Spray instructions

If necessary, multiple cross coats.

Recommended layer thickness

Minimum 190 µm wet < > 100 µm dry

Indicative layer thickness per layer. For system layer thicknesses in accordance with ISO 12944, see "BICCS Paint Systems" (www.biccs.nl) or contact your account manager or the Technical Support Department for project-specific advice.

Tool cleaning

Washing thinner or BICCS Thinner 0104 [9164]

Drying times

Data at 20°C and 65% RH

Dust dry: approx. 30 minutes
Tack-free: approx. 60 minutes
For re-spraying: 'wet-on-wet' after initial drying.
After 2 days, sanding is first required.
For sanding: after approx. 24 hours
Cured: after approx. 4 days

Additional Information

Bipox 2C HB Zinc Phosphate Coat ZGL [6143] also has excellent adhesion to non-ferrous metals. The product also has very good flow properties and is ideally suited for 'wet-on-wet' application where there is no chance of overspray.
Highly sandable after drying.

Example of paint system	1st coat:	Bipox 2C HB Zinc Phosphate Coat ZGL [6143]	dft 100 µm
	2nd coat:	Bipox 2C HB Midcoat [6145]	dft 60 µm
	3rdcoat:	Bichodur 2C (DTM) lacquers	dft 60 µm

Warning restricted applicability
Given the diversity of aluminium alloys made available in the market depending on material requirements, it is impossible for us to recommend one single coating system that will apply to all aluminium. Our product data is generally based on pure, unalloyed aluminium, also known as the 1000 series.

Pre-treatment

To prevent new contamination/rust formation, the object should be coated immediately after blasting/sanding/degreasing. If in doubt about the substrate and/or pre-treatment, always prepare a test in advance to assess adhesion.

Application conditions

The data in this publication are based on a temperature of 20°C and 65% RH. For higher layer thicknesses and/or lower temperatures, longer drying times apply. During application and drying avoid temperatures lower than 10°C and RH higher than 80%. For safety reasons, application of the lacquer should be carried out at a substrate temperature at least 3°C above the dew point. See the dew point table on the download page of our website (www.biccs.nl). Good ventilation is necessary during application and drying.

Safety

Suitable for professional use only. See also the corresponding safety data sheet (via download at www.biccs.nl).

For more information, please contact your BICCS account manager or the Technical Support department.

PEARLPAINTGROUP

PearlPaint Group | P.O. Box 2365, NL-8203 AH Lelystad, Netherlands
: +31 (0)320 - 285 353 | : info@pearlpaintgroup.com | pearlpaintgroup.com