



ZINC RICH PRIMER 311

Single Pack Epoxy Zinc Rich Primer

Data Sheet: 311
Supersedes 01/99
Revised 06/99

Composition	ZINC RICH PRIMER 311 is an epoxy based zinc rich primer designed to provide galvanic protection to steel surfaces.			
	Uses and Properties	ZINC RICH PRIMER 311 is used for the protection of steel against normal atmospheric corrosion and against splash and spillage of fresh and salt water. In non-aggressive environments, it may be left untopcoated if applied at a dry film build of 75 µm.		
Typical Applications		May be used to touch up damage or weld margins on galvanized steelwork.		
	Typical Systems	Offers the advantages of an epoxy zinc-rich paint in a one-pack form and in a condition allowing easy application by brush, roller or spray.		
		Suitable for repairing inorganic zinc silicates.		
		Weldable in thin coats.		
		High heat resistance.		
		Can be overcoated with a wide range of decorative and heavy duty coatings.		
		Touch up for galvanized steel - Food processing industries - Metal fabrication - Pharmaceutical plants - Mining industry - Industrial maintenance - Chemical industry - Abattoirs and stock transport.		
		Substrate	Surface Preparation	Typical Systems
	Mild steel	Surface must be free from oil and grease. Abrasive blast clean to A.S.1627 Part 4 Class 2½ minimum. Coat within 4 hours of blasting and never under damp conditions or threat of rain.	1 st Coat: ZINC RICH PRIMER 311 2 nd Coat: ZINC RICH PRIMER 311 (optional) ALTERNATIVELY 1 st Coat: ZINC RICH PRIMER 311 2 nd Coat: AMERCOAT 148K ❷ 3 rd Coat: AMERON QD 600 ❸	50-75 50-75 50-75 40-50 40-50
	Galvanized steel (touch up)	Solvent degrease if necessary. Power tool clean ensuring all loose or flaking rust, zinc or other contaminants are removed. Ensure that welds are properly ground and that all weld spatter has been removed ❶. It is essential that the surface is thoroughly dry.	1 st Coat: ZINC RICH PRIMER 311 2 nd Coat: AMERCOAT 148K 3 rd Coat: AMERON QD 600 ❸	40-50 40-50 40-50
❶ Abrasive blast cleaning is preferred where possible. ❷ Other primers such as, AMERON 783, MULTI ETCH 302, may be suitable. Refer Ameron coatings. ❸ Other top coats may be suitable. Refer overleaf.				

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<p>General Data</p> <p>Weathering</p> <p>Finish</p> <p>Chemical Resistance</p> <p>Solvent Resistance</p> <p>Abrasion Resistance</p> <p>Immersion</p> <p>Temperature Range</p> <p>Colour</p> <p>Topcoating</p> <p>Shelf Life</p>	<p>Very good.</p> <p>Flat.</p> <p>Very good for splash and spillage of crude oils, salt and fresh water. Not recommended for acidic or alkaline conditions.</p> <p>Good for splash or spillage conditions.</p> <p>Very Good.</p> <p>Not normally recommended.</p> <p>Up to 200°C (dry heat).</p> <p>Light Grey.</p> <p>If a topcoat is required, use non-saponifiable coatings, such as Acrylics or Epoxies. Alkyd paints, such as AMERCOAT 5401, AMERON QD 600, may be used if a barrier coat such as, AMERCOAT 148K, AMERON 783, MULTI ETCH 302, is first applied.</p> <p>12 months if stored in sealed containers away from heat or moisture.</p>
<p>Application Data</p> <p>Theoretical Coverage</p> <p>Volume Solids</p> <p>Drying Time (@ 25°C)</p> <p>Mixing</p> <p>Thinners</p> <p>Equipment</p> <p>Safety Precautions</p>	<p>10 sq.m. per litre at 50 µm dry film thickness. (Wet film thickness 100 µm). Material losses during mixing and application will vary and must be considered when estimating requirements.</p> <p>50% ± 2% (theoretical).</p> <p>Touch dry 25-30 minutes. Hard dry 16 hours. Recoat after overnight drying - less in hot conditions.</p> <p><i>NOTE: The figures quoted for pot life and drying/curing times are not definitive. They are dependent on site conditions, such as volume of material mixed, ambient and steel temperatures, weather and ventilation.</i></p> <p>Open with caution as pressure may have built up in container. Stir thoroughly before use, to produce a uniform product.</p> <p>Use THINNER 304 for spray application and for cleanup.</p> <p>Airless Spray: Airless Spray: Use a 0.456 mm (0.018") tip size and 14-17 MPa pressure. Product must be kept agitated or circulated during spraying. Conventional Spray: Thin 25%. DeVilbiss JGA 502 gun with "E" needle and fluid tip, 704 air cap, or equivalent. Use 200-270 kPa pot pressure on an agitated pot and 420-480 kPa atomising pressure. Brush and roller: Thinning is not normally required.</p> <p>ZINC RICH PRIMER 311 contains flammable solvents. Keep away from sparks and naked flames. When applying by brush or roller, provide adequate ventilation. When applying by spray, users must comply with relevant spray painting regulations and wear appropriate respirator to avoid inhaling vapours and spray mist. Material Safety Data Sheet is available and should be consulted.</p>

As Ameron Coatings follow the policy of continuous improvement, this leaflet is issued for general guidance only. It is based on tests and information believed to be accurate at the time of printing. All recommendations and suggestions issued by or on the behalf of the Company are however subject to the Company's conditions of sale.



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