



RUSTFIGHTER 215

Quick Dry Zinc Phosphate Primer

Data Sheet: 215
Supersedes: 09/07
Revised: 03/08

Composition	RUSTFIGHTER 215 is a fast dry alkyd zinc phosphate primer, based on tough alkyd resins which impart good anti-corrosive properties on steel.			
Uses and Properties	<ul style="list-style-type: none"> ◆ Excellent for use as a shop primer in prefabrication work. ◆ May be left uncoated for up to 6 months. (Mild exposure conditions) ◆ Zinc chromate free. ◆ Very fast drying. ◆ Suitable for top coating with a variety of single pack products. 			
Typical Applications	As a shop primer with appropriate top coat for use on steel substrates such as structural steel, mild steel, piping and equipment and tank exterior surfaces, to provide good corrosion protection in mild or moderate environments. Not recommended for direct application to galvanised steel or zinc dust primers unless an appropriate barrier coat is used such as MULTI ETCH 302.			
Typical Systems	Substrate	Surface Preparation	Typical Systems	dft µm
	Structural steel	Abrasive blast clean to AS 1627.4 Class 2 ½.	1 st Coat: RUSTFIGHTER 215 2 nd Coat: STYRALUX 220 ❶	40-50 40-50
	Mild steel	Remove rust, clean and degrease.	1 st Coat: RUSTFIGHTER 215 2 nd Coat: STYRALUX 220 ❶	40-50 40-50
	Galvanised steel	Solvent degrease and abrade and clean.	1 st Coat: MULTI ETCH 302 2 nd Coat: RUSTFIGHTER 215 3 Rd Coat: STYRALUX 220 ❶	6-12 40-50 40-50
❶ Other top coats such as QD600 SPRAYING ENAMEL, AMERCOAT 5401, may be suitable. Refer overleaf.				

RUSTFIGHTER 215

General Data	
Weathering	May be left uncoated for up to 6 months (Mild exposure conditions)
Finish	Low lustre
Chemical Resistance	Not normally recommended.
Abrasion Resistance	Good
Immersion	Not recommended
Temperature Range	Up to 120 ⁰ C dry heat.
Colour	Red oxide, Grey, Black and Blue. Other colours batch quantities only.
Topcoating	Usually top coated with STYRALUX 220, QD 600 SPRAYING ENAMEL.
Shelf Life	12 Months
Application Data	
Theoretical Coverage	9.2 Sq Metres per litre at 40 µm dry film thickness. (Wet film thickness 110 µm).
Volume Solids	37%
Drying Time (@ 25°C, 50% R.H.)	Dust free: 3-5 Minutes. Touch Dry: 8-10 Minutes. Hard dry: 2 Hrs. May be topcoated with single pack enamels after 3-4 Hrs drying. <i>NOTE: The figures quoted for drying and recoating times are not definitive. They are dependent on site conditions, ambient and surface temperatures, weather and ventilation.</i>
Mixing	Stir thoroughly until uniform.
Thinning	Conventional spray application: Use up to 20% THINNER 445. Thinner 054 may be used for hot windy conditions.
Equipment	Conventional spray: DeVilbiss JGA 502 gun with "E" needle and fluid tip, 704 air cap or equivalent. Use 200-270 kPa pot pressure and 400 kPa atomising pressure. Airless spray: Thinning not required. Use tip orifice 0.325-0375 mm, (0.013"-0.015"). Apply at 14-17 MPa atomising pressure.
Safety Precautions	Contents are flammable. Keep away from fire or naked flame or sparks. Keep away from children. Read Material Safety Data Sheet. When mixing or applying wear goggles and gloves and ensure good ventilation. When spraying, wear appropriate protective clothing and air supply. If splashed on skin, wash with soap and water. Adequate forced ventilation must be provided in confined spaces.

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