

## Stokes HB Zinc Phosphate Primer

Product Description	An economical, fast drying, alkyd zinc phosphate primer for steelwork.				
Features & Use	<ul style="list-style-type: none"><li>• Excellent drying and enamel hold-out</li><li>• Good adhesion and corrosion resistance</li><li>• Extended wet-edge time for ease of brush application</li><li>• Use as a primer for metal fabrications, process equipment, machine tools and other surfaces where fast drying properties are required</li></ul>				
Approvals/ Certification	Please consult Axalta Coating Systems				
Finish	Matt				
Volume Solids	44 ± 2% (varies with colour)				
VOC Content	475 ± 20 g/litre (varies with colour)				
Film Thickness Range And Coverage		Dry Film Thickness	Wet Film Thickness	Theoretical Coverage	
	Minimum	40 µm	91 µm	11.0 m²/litre	
	Maximum	75 µm	170 µm	5.8 m²/litre	
	Practical coverage depends on the application method, painting conditions and the shape and roughness of the surface to be coated				
Drying Times	Applied to 50 microns DFT		+10°C	+23°C	+35°C
	Dust Free		1½ hr	40 min	20 min
	Hard Dry		3 hr	1½ hr	1 hr
	Overcoating	Minimum	3 hr	2 hr	1 hr
		Maximum	Indefinite if surface is clean and sound		
	Drying and recoating times are related to the film thickness, temperature, the relative humidity of the air and ventilation				
Colours	Red Oxide (IP001), Grey (IP002), Black (IP004)				
Product Code	20QDP-REO, 20QDP-GRY, 20QDP-BLA				
SG	1.42 kg/ltr (varies with colour)				
Storage Conditions	Store in dry, cool conditions and protect from frost				
Shelf Life	Minimum 12 months if stored as above in unopened containers				
Flash Point	23-60°C				

# Stokes HB Zinc Phosphate Primer

Issue Date: Apr 2018  
Page 2 of 2

<b>Surface Preparation</b>	<ul style="list-style-type: none"> <li>All surfaces to be coated should be dry and cleaned as necessary to remove all oil, grease, salts, weld flux or other contamination. Where necessary, remove weld spatter and grind smooth all sharp edges and weld seams</li> <li><b>Steel:</b> blast clean ideally to Sa2½ (ISO 8501-1:2007), minimum of Sa2, surface profile 50-75 microns; alternatively hand prepare to St2 standard, taking care to avoid 'polishing' the surface. Performance will depend on the degree of surface preparation achieved</li> <li><b>Non-ferrous surfaces:</b> consult Axalta Coating Systems for advice on appropriate adhesion primer</li> </ul>				
<b>Mixing</b>	Must be mixed thoroughly by using a mechanical agitator before use. Agitate periodically to ensure paint remains homogeneous.				
<b>Thinner</b>	No.7 Thinner <b>Equipment Cleaner</b> No.7 Thinner				
<b>Application Conditions</b>	Only apply in conditions of good ventilation which must be maintained during drying and curing. Do not apply when rain, mist, sleet or snow are imminent. During application and drying time of the paint coating, the surface should be dry, the Relative Humidity should not exceed 85% and the steel temperature should remain at least 3°C above the dew point. Paint temperature should ideally be at a minimum of 15°C.				
<b>Application Methods</b>	<b>Method</b>	<b>Airless Spray</b>	<b>Conventional Spray</b>	<b>Brush</b>	<b>Roller</b>
		Yes*	Yes	Yes	Yes
	<ul style="list-style-type: none"> <li>This product is primarily designed for brush application as supplied. Roller application may also be used but film thicknesses may be lower</li> <li>*For airless spray application, Speedspray QDH or Speedspray CM5 are recommended</li> <li>Thin the coating for conventional spray if required (up to 5-10% typical) but hold-up properties will be considerably reduced</li> </ul>				
<b>Product Notes</b>	<ul style="list-style-type: none"> <li>Apply two coats of primer in more severe environments or where a topcoat is not to be used</li> <li>In common with most alkyd primers, this product is not recommended for extended exterior exposure, exposure in aggressive or coastal locations, or for immersion. Epoxy primers are preferred for these conditions, please consult Axalta Coating Systems for specification advice</li> </ul>				
<b>Health &amp; Safety</b>	Containers are provided with safety labels which should be observed. Further information about hazardous influences and protection are detailed in individual Product Safety Data Sheets. A Safety Data Sheet for this product is available on request from Axalta Coating Systems.				

The information provided herein corresponds to our knowledge on the subject at the date of its publication. This information may be subject to revision as new knowledge and experience becomes available. The data provided fall within the normal range of product properties and relate only to the specific material designated; these data may not be valid for such material used in combination with any other materials or additives or in any process, unless expressly indicated otherwise. The data provided should not be used to establish specification limits or used alone as the basis of design; they are not intended to substitute for any testing you may need to conduct to determine for yourself the suitability of a specific material for your particular purposes. Since Axalta cannot anticipate all variations in actual end-use conditions Axalta makes no warranties and assumes no liability in connection with any of this information. Nothing in this publication is to be considered as a license to operate under or a recommendation to infringe any patent rights. This product is for professional use only.