

## Stokes Low Bake ZP Primer

Product Description	Modified alkyd/amino resin zinc phosphate anticorrosive primer for steel or zinc metal spray.			
Features & Use	<ul style="list-style-type: none"><li>• Low temperature curing system</li><li>• For use on a range of ferrous and zinc metal sprayed substrates</li><li>• Excellent anticorrosive performance with good salt spray resistance</li><li>• Excellent adhesion and good flow</li><li>• Designed for use with Stokes Low Bake Stoving Finish to produce a hard wearing system</li></ul>			
Approvals/ Certification	Please consult Axalta Coating Systems			
Finish	Slight sheen			
Volume Solids	46 ± 2% (varies with colour)			
VOC Content	459 ± 20 g/litre (varies with colour)			
Film Thickness Range And Coverage		Dry Film Thickness	Wet Film Thickness	Theoretical Coverage
	Minimum	30 µm	65 µm	15.3 m²/litre
	Maximum	40 µm	87 µm	11.5 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 30 microns DFT			
	Stoving schedule		20 min @ 100°C metal temperature	
	For other stoving schedules, please consult Axalta Coating Systems			
	Drying and recoating times are related to the film thickness, temperature, the relative humidity of the air and ventilation			
Colours	Grey (IP081) and other shades to order			
Product Code	20ZPP-081			
SG	1.31 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			

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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>Blast clean to Sa2½ (ISO 8501-1:2007), surface profile 50-75 microns</li> <li>Where blast cleaning is impractical the surface should be prepared to St2 (ISO 8501-1:2007) taking care to avoid 'polishing' the surface</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.4 or TH035 Thinners <b>Equipment Cleaner</b> No.4 or TH035 Thinners				
<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	No	No
	<ul style="list-style-type: none"> <li>Conventional and Airless spray: thinning may be required</li> <li>Dipping: thin as required</li> <li>Brush: not recommended other than for small areas of touch-up</li> </ul>				
<b>Product Notes</b>	<ul style="list-style-type: none"> <li>Designed to be overcoated with Stokes Low Bake Stoving Finish</li> <li>Good resistance to most hot and cold lubricating oils. Tests for suitability for any particular oil should be carried out before application</li> <li>Heat resistant up to 150°C</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.				

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