

## Dulux Durepon® FRX Semi Gloss

NZDI0891

### Description

DUREPON® FRX Primer is a two pack epoxy cold cure/fast recoat high performance anticorrosive primer. DUREPON® FRX provides such properties as excellent adhesion on blast cleaned steel, excellent corrosion resistance properties and rapid dry times, with the ability to cure at temperatures down to 0°C.

### Features And Benefits

- Low temperature cure
- Fast to recoat
- Contains High Levels Zinc Phosphate
- Easy application
- Faster turnaround at low temperatures
- Top coats can be applied within a few hours even at low temperatures
- Provides excellent, non-toxic corrosion protection
- Recommended for maintenance painting





### Uses

DUREPON® FRX Primer is a suitable primer for all kinds of steel fabrication in industries that require heavy duty coatings, particularly when cure temperatures are low. It is useful as a tie-coat over inorganic zinc primers and will accept a wide range of topcoats (also self recoatable) even after long weathering periods. DUREPON® FRX Primer is normally overcoated with epoxy, polyurethane or acrylic finishes depending upon end requirements.

### Performance Guide

<b>Weatherability</b>	Withstands exterior exposure when suitably topcoated.	<b>Salts</b>	Unaffected by splash and spillage of neutral and alkaline salt solutions.
<b>Heat Resistance</b>	Up to 120°C dry heat	<b>Water</b>	Suitable for immersion in fresh and salt water when suitably topcoated.
<b>Solvents</b>	Resists splash/spillage of most hydrocarbon solvents, ref.petroleum products and common alcohols.	<b>Abrasion</b>	Good when fully cured.
<b>Acids</b>	Suitable for splash and spillage exposure to weak inorganic acids.	<b>Alkalis</b>	Excellent resistance to splash and spillage of most common alkalies.

### Typical Properties

<b>Classification</b>	Epoxy zinc phosphate primer	<b>Finish</b>	Semi-gloss
<b>Colour</b>	Grey (410-82619)	<b>Components</b>	2
<b>Flash Point</b>	Pt A -7 C, Pt B 27 C	<b>Pot Life</b>	6 Hours @ 25°C
<b>Shelf Life</b>	12 months @ 25°C	<b>Mixing Ratio (V/V)</b>	6 pt A : 1 pt B by volume
<b>Thinner</b>	Use only Dulux Prothinner 400 (965-63021)	<b>Suitable Substrates</b>	Abrasive blast cleaned steel.
<b>Line/Shade</b>	<ul style="list-style-type: none"> <li>• 410-82619 (Part A)</li> <li>• 976-82623 (Part B)</li> </ul>	<b>Topcoats</b>	Single and two pack products
<b>Application Methods</b>	 Air Spray  Airless Spray  Brush  Roller		
<b>Application Conditions</b>		<b>Min</b>	<b>Max</b>
	<b>Air Temperature</b>	0	45
	<b>Substrate Surface Temperature</b>	0	45
	<b>Relative Humidity</b>	0	85
<b>Solids By Volume</b>	62		
	<b>Min</b>	<b>Max</b>	<b>Recommended</b>
<b>Wet Film Per Coat (microns)</b>			125
<b>Dry Film Per Coat (microns)</b>			75
<b>Recoat Time (min)</b>	1.5 Hours	Indefinite*	
<b>Theoretical Spread Rate (m<sup>2</sup>/L)</b>			8.3

Hardener Details						
Hardener Title						
Wet Film per Coat	Coating Thickness (microns)		Recommended	Application Conditions (°C)		
	Min	Max		Min	Max	Air Temp. Substrate Surface Temp. Relative Humidity Concrete Moisture Content
Dry Film per Coat	V.O.C. Level		Pot Life			
# Drying characteristics at 125 microns dry film thickness						
Temperature	Humidity	Touch	Handle	Full Cure	Recoat Min	Recoat Max
5 C	50%	2 Hours	8 Hours	5 Days	3 Hours	Indefinite
10 C	50%	1 Hour	7 Hours	4 Days	2 Hours	Indefinite
25 C	50%	1 Hour	4 - 6 Hours	4 Days	1.5 Hours	Indefinite
# TYPICAL SPREADING RATE AT RECOMMENDED DRY FILM BUILD			# A spreading rate of 8.3sq. meters per litre corresponds to 75 microns dry film thickness assuming no losses. Practical spreading rates will vary depending on such factors as method and condition of application and surface roughness			
<b>Hardener Section Footer</b>	# These figures are given as a guide only, as ventilation, film thickness, humidity, thinning and other factors will influence the rate of drying. To overcoat after the maximum time has elapsed, either with itself or with another product, may require the surface to be abraded in order to ensure adequate adhesion. * When used for immersion conditions the maximum overcoat interval is 3 days.					

Surface Preparation
Round off all rough welds, sharp edges and remove weld spatter. Remove grease, oil and other contaminants in accordance with AS1627.1. Rust, millscale, oxide deposits and old paint films on metal surfaces must be removed by abrasive blast cleaning to AS1627.4 Class 2.5. Immersed steel must be prepared to AS1627.4 Class 3. Remove all dust by brushing or vacuum cleaning.

Application Guide	
<b>Application Method</b>	Stir each can thoroughly until the contents are uniform. Use of a power mixer is recommended. Mix the contents of both packs together thoroughly using a power mixer and allow to stand for 10 minutes (15 minutes below 15°C). Remix thoroughly before using.
<b>Brush/Roller</b>	Apply even coats of the mixed material to the prepared surface. Thin if necessary with up to 100 ml/litre with Prothinner 400 to ease application. When brushing and rolling additional coats may be required to attain the specified thickness.
<b>Conventional Spray</b>	Thin up to 100 ml/litre with Prothinner 400 aid atomisation. At temperatures below 15°C, up to 150 ml/litre thinner may be required. Typical Set-up Graco Delta Gun: Iwata W70 Gun: Pressure at Pot: Pressure at Gun: 1.8mm (239543) 021 Air Cap, 021 Fluid Needle, 021 Fluid Nozzle 70-100 kPa (10-15 p.s.i.) 380-410 kPa (55-60 p.s.i.)
<b>Airless Spray</b>	Standard airless spray equipment such as a Graco 45:1 Xtreme with a fluid tip of 17-21 thou (0.43 -0.53mm) and an air supply capable of delivering 550-690 kPa (80 -100 psi) at the pump. Ideally fluid hoses should not be less than 3/8" ID and not longer than 50 feet to obtain optimum results. Thinning is not normally required but up to 100 ml/litre of Prothinner 400 may be added to ease application.
<b>Precautions</b>	This is an industrial product designed for use by experienced Protective Coating applicators. Where conditions may require variation from the recommendations on this Product Data Sheet contact your nearest Dulux® representative for advice prior to painting. Do not apply in conditions outside the parameters stated in this document without the express written consent of Dulux® Australia. Freshly mixed material must not be added to material that has been mixed for some time. The rate of cure is dependent upon temperature. Do not apply at relative humidity above 85% or when the surface is less than 3°C above the dewpoint. In hot conditions above 30°C Dulux Prothinner can be used to improve application. Do not use as a primer over galvanised steel as delamination can occur.
<b>Clean Up</b>	Cleanup immediately with Prothinner 400 (965-63021)

**Overcoating**

# Aged coating should be tested for lifting by a method suitable to the coating thickness, for example 'X' cut or crosshatch methods. If it lifts, remove it. The surface must be free of oil, grease and other contaminants.  
 If the coating has exceeded the maximum recoat interval then abrade the surface.  
 High-pressure water blast at 1,200 - 1,500 p.s.i. to remove loosely adhering chalk and dust.

**Health And Safety**

<b>Safety Precautions</b>	# Read Data Sheet, Material Safety Data Sheet and any precautionary labels on containers.
<b>Storage</b>	Store as required for a flammable liquid class 3a in a bunded area under cover. Store in well-ventilated area away from sources of heat or ignition. Keep containers close at all times. .
<b>Handling</b>	Part B: Cans may contain pressure. Before opening place cloth wholly over lid to prevent splashing. Hold hand firmly on lid to prevent lid releasing under pressure. Lever lid off gradually. Addition of moisture or solvents to cans of Part B may result in build up of pressure. Therefore keep airtight and observe opening instructions on each occasion
<b>Using</b>	For detailed information refer to the product label and the current Material Safety Data Sheet available through Dulux Sales and Customer Service offices.
<b>Flammability</b>	This product is flammable. All sources of ignition must be eliminated in, or near the working area. DO NOT SMOKE.
<b>Welding</b>	Avoid inhalation of fumes if welding surfaces coated with this paint. Grind off coating before welding.

**In the case of emergency, please call 0800 734 607**

**Resistance Guide**

Chemical	Permanent Exposure	Intermittent Exposure
----------	--------------------	-----------------------

**Transport And Storage**

Dangerous Goods Part A			
<b>Class</b>	3a	<b>UN Number</b>	1263
Dangerous Goods Part B			
<b>Class</b>	3b	<b>UN Number</b>	1263

**Disclaimer**

Dulux and Other marks followed by ® are registered trademarks. Marks followed by the symbol of ™ are trademarks.

The data provided within the Duspec system is correct at the time of publication, however it is the responsibility of those using this information to check that it is current prior to specifying or using any of these coating systems.

DISCLAIMER: Any advice, recommendation, information, assistance or service provided by any of the divisions of DuluxGroup (New Zealand) Pty Ltd or its related entities (collectively, DuluxGroup) in relation to goods manufactured by it or their use and application is given in good faith and is believed by DuluxGroup to be appropriate and reliable. However, any advice, recommendation, information, assistance or service provided by DuluxGroup is provided without liability or responsibility PROVIDED THAT the foregoing shall not exclude, limit, restrict or modify the right entitlements and remedies conferred upon any person or the liabilities imposed upon DuluxGroup by any condition or warranty implied by Commonwealth, State or Territory Act or ordinance void or prohibiting such exclusion limitation or modification. Coating systems can be expected to perform as indicated on the Duspec Spec Sheet so long as applications and application procedures of the individual products are followed as recommended on the appropriate Product data Sheet. "Orica" "Dulux" "Berger" "Berger Gold Label" "Hadrian" "Walpamur" "Levene" "Acratex" and Other marks followed by ® are registered trademarks. Marks followed by the symbol ™ are trademarks.

Please note that this document is only valid for 60 days from the date of issue.

DuluxGroup (New Zealand) Pty Ltd 150 Hutt Park Road NZ ACN 133 404 118