

Sabre Ferrum Prime Industrial Zinc Phosphate Primer



Key Features

- Fast drying general purpose primer
- Overcoatable with a range of QD finishes
- Excellent protection of bare steel and fabrications
- Quality blast primer

Typical Uses

- Metal Fabrications
- Structural Steel
- Application through most types of spray equipment

Technical Information

Gloss Level	Matt
Volume Solids	43 ± 2% (dependent on shade)
Solids by Weight	56 ± 2% (dependent on shade)
Flash Point	25°C (BS EN ISO 3679 Closed Cup)
V.O.C.	500 g/l ± 5% (dependent on shade)
Drying Times @ 20 °C.	Touch dry = 15 minutes Through dry = 1-2 hours Hard dry = 4-6 hours Full Cure = 7 days (times are quoted at 20 °C and will vary with film thickness, air movement, temperature and humidity)
Colours	Available in Red Oxide (0120), Light Grey (0651), Dark Grey (1606), Buff (0414), White (0001) and Black (0002), plus special colours by arrangement.
Packaging	5 & 20 Litre
Shelf Life	12 months in unopened containers when stored under cover within the temperature range 10-35°C.

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Application Guide

	Airless	Conventional/ (H.V.L.P)	Brush/roller
Thinning	Ready for use	003:000 Thinner	Ready for use
Tip Sizes	15-17 thou	2.0mm	N/A
Spray Pressure	140 bar 2000 psi	2 bar 30 psi	N/A
Pot Life	Unlimited	Unlimited	Unlimited
Spray Viscosity	N/A	N/A	N/A
Number of Coats	1	1	Small areas only
WFT. Per coat	175-230 microns	175 microns	Small areas only
DFT applied at above WFT	75-100 microns	75 microns	N/A
Theoretical Coverage at above WFT	5.5 m ² /l	5.5 m ² /l	Small areas only
Time between coats	30 mins	30 mins	6 hours or overnight

(practical coverage will be affected by surface profile, uneven application, overspray and losses in containers and equipment). Spray equipment details given are intended as a guide only. Fluid hose length and diameter, paint temperature and job shape and size all have an effect on the spray tip and operating pressure chosen.

Application Process

Do not apply or dry when the air or substrate temperature is below 5 °C or in excess of 30 °C otherwise film appearance and coating properties may be adversely affected. Surface temperature must also be a minimum of 3°C above dew point. Outdoors preparation, painting and drying should only be undertaken during good weather conditions and never when rain is imminent or on days when a drop in temperature could result in condensation forming on the paint during the initial drying period or overnight. Mix thoroughly before use. Best results will be achieved using a power mixer.

Airless, Heated Airless or Airmix spray systems- Flush all lines with a compatible solvent before application to avoid 'throw out' and blocking of the filters. Using a brush to provide a 'stripe coat' on difficult to reach areas such as internal welds, rough spots, bolts or corners before application of the spray coat is a good method of ensuring adequate build is achieved. One even coat applied in parallel passes, overlapping 50% on each pass to avoid bare areas, pinholes or holidays. A single coat at the recommended W.F.T is satisfactory for most purposes. However, should additional coats be required for higher film builds or blast cleaned profiles these should be applied wet on wet after the solvent has flashed off.

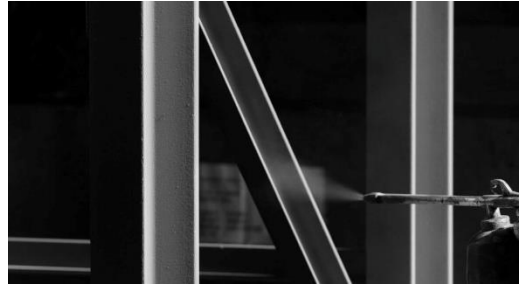
Conventional / H.V.L.P. - Add thinner as required to achieve the correct atomisation but care should be taken not to over thin as this will greatly affect the performance and build of the material resulting in additional coats to achieve the required build. Using a brush to provide a 'stripe coat' on difficult to reach areas such as internal welds, rough spots, bolts or corners before application of the spray coats is a good method of ensuring adequate build is achieved. Even coats should be applied, wet on wet after the solvent has flashed off, in parallel passes, overlapping 50% on each pass to avoid bare areas, pinholes or holidays to attain recommended or required W.F.T.

Brush or Roller- This material has limited capabilities when coating large areas of panels due to the speed of drying and is therefore recommended for small areas only. Subsequent coats of this material are not recommended by brush or roller application. However, should they be necessary allow the first coat to dry overnight to prevent possible reaction.

Overcoating- 200:026 can be overcoated with most xylene-based topcoats anytime after through dry. However, due to its chemical nature, white spirit-based topcoats should **not** be applied directly onto this primer.

Cleaning- Clean all equipment immediately after use with the above solvent. Ensure all lines, tips, etc. are thoroughly flushed out. It is not sufficient to leave equipment filled up with solvent/thinners.

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Substrates

Steel Fabrications- Once the surfaces to be coated are clean, dry and free all contamination, grind down any sharp edges and shot blast to Sa2½ (as defined in ISO 8501-1) with an average surface profile of at least 50 microns. As an alternative to shot blasting, mechanically prepare the surfaces to St3-C or St3-D (as defined in ISO 8501-1). Painting should then be carries out within four hours.

Existing primer or finish- Remove loose flaky paintwork back to a firm edge. Ensure all surfaces are clean, dry and free from all contamination before lightly flatting to give a smooth surface with an adequate key. Apply the material to a small test area to ensure there are no adverse reactions with the existing coating before painting.

Health and Safety

See packaging label for relevant MSDS reference. Copies can be obtained by telephoning 01246 857777.

Test Results

When used at an overall D.F.T. of 140 microns

Salt Spray

Pass- 500 hours (test carried out in accordance with ASTM B117)

Conformity

Defra Process Guidance Note 6/23(11) suitable for users under 5 tonnes solvent a year

ISO 12944 – 5 2018 – System specific. Categories C2, C3 and C4 for Alkyd Based (AK) Zinc Phosphate (Misc) primers when used as part of a system

Contact to confirm specification.

The foregoing information is given in good faith on the basis of practical experience and extensive laboratory tests. Quoted figures are either theoretical values or typical of production batches. However, as we have no control over the conditions of application or the quality and standard of preparation of the substrate and the many other factors affecting the use and application of the product, the customer must determine the suitability of the delivered product for the intended application. Therefore, unless we specifically agree in writing to do so, we do not accept any liability whatsoever or howsoever arising for the performance of this product or for any loss or damage arising out of the use of the product, or its use in conjunction with other manufacturer's product(s). Stir the paint well before use and always check the shade as no responsibility for a colour complaint is accepted after application. The information in this data sheet is liable to modification from time to time in the light of experience and our policy of continuous improvement. For professional use only. 200:026 October 2020.