

## Dulux Powder Coatings E-Prime™

AU\_DP01831

<b>Product Code</b>	953 line
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### Description

E-Prime™ is an epoxy based powder primer formulated to give additional protection to sharp profile/edges or complex metal shapes. E-Prime™ can be used a sandable filler for small surface imperfections and/or to provide additional film thickness for improved corrosion protection. E-Prime™ shows easy application properties and gives a film very resistant to wear and damage.

### Features And Benefits

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| <ul style="list-style-type: none"> <li>▪ Very good adhesion</li> <li>▪ Very good corrosion protection</li> <li>▪ Very good surface hardness</li> <li>▪ No solvents or emissions</li> <li>▪ Good chemical resistance</li> </ul> | <ul style="list-style-type: none"> <li>▪ Excellent for use as a primer</li> <li>▪ Long intact life of coating (with topcoat over the primer)</li> <li>▪ Hard wearing/serviceable finish</li> <li>▪ Less waste and pollution to the environment</li> <li>▪ Resists oil and general chemical spills</li> </ul> |
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### Uses

E-Prime™ can be used as a primer over a variety of substrates including steel and aluminium but is especially suited to aluminium castings, hot dipped galvanised or other porous metals.

### Precautions And Limitations

As a result of possible wide application variations and stoving conditions, E-Prime® may show variation between Dulux Powder Coatings prepared samples and production applied material. Therefore, it is the applicator and/or their customer's responsibility to ensure the product conforms to their requirements.

### Performance Guide

<b>Exterior Durability</b>	Not recommended for exterior use without the use of an exterior durable topcoat. Contains an epoxy component which will chalk on exterior exposure.	<b>Salt</b>	Very good salt spray resistance. < 3mm adhesion loss at scribe after 250 hours salt spray on steel.
<b>Heat Resistance</b>	Excellent resistance to 120°C continuous service conditions.	<b>Water</b>	Excellent resistance to 38°C/100% humidity for 250 hours on steel.
<b>Solvent</b>	Resistant to alcohol and white spirits.	<b>Abrasion</b>	Excellent resistance to abrasion.
<b>Acid</b>	Resistant to spills of dilute acid.	<b>Alkali</b>	Resistant to spills of dilute alkali.

Typical Properties															
<b>Gloss Level</b>	10-20% at 60°	<b>Coverage</b>	8 - 10m <sup>2</sup> /kg is commonly experienced. Practical spreading rates will vary due to such factors as method and conditions of application and surface profile and texture.												
<b>Shelf Life</b>	12 months when stored below 25°C/dry conditions	<b>V.O.C Level</b>	N/A												
<b>Colour</b>	Light Grey														
<b>Meets GBCA VOC Requirement?</b>	Yes. Dulux Powder Coatings: <ul style="list-style-type: none"> <li>▪ Contain no harmful volatile organic solvents</li> <li>▪ Free of heavy metal pigments such as lead, cadmium, arsenic &amp; mercury</li> <li>▪ Proven low temperature curing technology</li> <li>▪ Produced with stringent Safety, Health &amp; Environmental policies and standards</li> <li>▪ Developed with consideration of life cycle analysis, to guide our suppliers and the materials we use</li> <li>▪ Manufactured in facilities where significant energy and resources employed in production, are measured with aggressive reduction targets in place</li> <li>▪ Produced and used with minimal waste</li> </ul> Consequently, Dulux® Powder Coatings are a prime consideration for projects where air quality standards have been set, such as 4, 5 & 6 Green Star Rating Projects.														
<b>Sanding Properties</b>	Sandable	<b>Film Build (microns)</b>	Minimum 50 microns, Maximum 110 microns												
<b>Clean Up</b>	Dust or vacuum up loose powder. Avoid use of compressed air.	<b>Application Method</b>	Electrostatic Spray												
<b>Specific Gravity</b>	1.536	<b>Flexibility</b>	Pass 40 inch/lb												
<b>Pencil Hardness</b>	Min H	<b>Cross Hatch Adhesion</b>	No Removal												
<b>Chemical Resistance</b>	<table border="0"> <tr> <td><b>White Spirits</b></td> <td>Resistant</td> </tr> <tr> <td><b>Ethanol</b></td> <td>Resistant</td> </tr> <tr> <td><b>Xylene</b></td> <td>Slight softening/limit contact</td> </tr> <tr> <td><b>Ethyl Acetate</b></td> <td>Softens after prolonged contact</td> </tr> <tr> <td><b>Methyl Ethyl Ketone</b></td> <td>Softens after prolonged contact</td> </tr> </table>			<b>White Spirits</b>	Resistant	<b>Ethanol</b>	Resistant	<b>Xylene</b>	Slight softening/limit contact	<b>Ethyl Acetate</b>	Softens after prolonged contact	<b>Methyl Ethyl Ketone</b>	Softens after prolonged contact		
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### Application Guide

<b>Surface Preparation</b>	<ul style="list-style-type: none"> <li>All surfaces should be degreased and pre-treated for optimal performance.</li> </ul> <p>Suitable pre-treatment includes: Aluminium - Yellow chromate or green chromate/phosphate (refer AS3715-2002 and/or BS6496)</p> <p>Mild Steel- Mild steel contains less than 0.25% carbon. New mild steel surfaces should be inspected for millscale, rust, sharp edges, burr marks and welding flux, forming or machine oils, salts, chemical contamination or mortar splashes on them, all of which which must be removed.</p> <p>Sa 2½ Very thorough blast cleaning. When viewed without magnification, the surface shall be free from visible oil, grease and dirt, and shall be free from mill scale, rust, paint coatings and foreign matter. Any remaining contamination shall show only as slight stains in the form of spots or stripes and correspond to the prints designated Sa 2½ in AS 1627.9.</p>
<b>Application Procedure And Equipment</b>	<ul style="list-style-type: none"> <li>1a) For fluidised bed, ensure uniform fluidisation of powder. Fluidised powder should resemble "simmering liquid". Aged or compacted powder may require pre-conditioning for several minutes to fluidise evenly.</li> <li>1b) For box feeders, ensure probe is fully inserted in powder and operated as per manufacturer's recommendations.</li> </ul> <p>2. Apply by electrostatic spray.</p> <p>3. Cure as per recommendations outlined above.</p> <p>4. Test for cure of the coating by contact with a drop of Corsol PGMA (available from Dulux Powder Coatings) for 30 seconds. Surface should be wiped dry and immediately checked for softening. Only slight surface softening should occur.</p> <ul style="list-style-type: none"> <li>Curing below metal temperatures of 180°C, or above metal temperatures of 210°C are not recommended.</li> </ul> <p>Theoretical spreading rate at recommended film thickness: A coverage rate of 8 - 10m<sup>2</sup>/kg is commonly experienced. Practical spreading rates will vary due to such factors as method and conditions of application and surface profile and texture.</p> <ul style="list-style-type: none"> <li>Electrostatic spray.</li> </ul>

### Care And Maintenance

As a general rule, cleaning of externally located powder coating surfaces must take place every six months. Where salts/pollutants are more prevalent such as seaside and industrial areas, a cleaning program should be carried out more frequently.

#### THREE STEPS TO CLEANING POWDER COATED SURFACES

1. Remove loose deposits with a wet sponge (avoid scratching the surface by dry dusting).
2. Using a soft clean cloth and a mild detergent in warm water, clean the powder coating to remove dust, salt or other deposits.
3. Always rinse after cleaning with fresh water to remove any remaining detergent.

#### WARNING:

In some cases, strong solvents recommended for thinning various types of paints and also for cleaning up mastics/sealants are harmful to the extended life of the powder coated surface. These solvents should not be used for cleaning purposes. If paint splashes or sealants/mastics need to be removed then the following solvents can be used safely: Methylated Spirits, White Spirits, Ethyl Alcohol, Isopropanol.

### Health And Safety

<b>MSDS Number</b>	10955	<b>Safety Precautions</b>	The MSDS is an integral part of using this product as it contains information on the potential health effect of exposure, personal protective equipment needed and other relevant SH&E information. For detailed information, refer to product label and the current Chemical Data Sheet (No. 10955) available through Sales and Customer Service Offices. Phone: Australia:- 13 24 99
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In the case of emergency, please call 1800 033 111

### Transport And Storage

<b>Package Weight</b>	20 Kg	<b>Shipment Name</b>	Not dangerous goods. No special transport requirements.
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