# RUSTFIGHTER 215

## *Quick Dry Zinc Phosphate Primer*

**Data Sheet: 215**
**Supersedes: 09/07**
**Revised: 03/08**

**Composition**

RUSTFIGHTER 215 is a fast dry alkyd zinc phosphate primer, based on tough alkyd resins which impart good anti-corrosive properties on steel.

**Uses and Properties**

- Excellent for use as a shop primer in prefabrication work.
- May be left uncoated for up to 6 months. (Mild exposure conditions)
- Zinc chromate free.
- Very fast drying.
- Suitable for top coating with a variety of single pack products.

**Typical Applications**

As a shop primer with appropriate top coat for use on steel substrates such as structural steel, mild steel, piping and equipment and tank exterior surfaces, to provide good corrosion protection in mild or moderate environments. Not recommended for direct application to galvanised steel or zinc dust primers unless an appropriate barrier coat is used such as MULTI ETCH 302.

**Typical Systems**

| Substrate | Surface Preparation | Typical Systems | dft µm |
|---|---|---|---|
| Structural steel | Abrasive blast clean to AS 1627.4 Class 2 ½. | 1st Coat: RUSTFIGHTER 215 | 40-50 |
| | | 2nd Coat: STYRALUX 220❶ | 40-50 |
| Mild steel | Remove rust, clean and degrease. | 1st Coat: RUSTFIGHTER 215 | 40-50 |
| | | 2nd Coat: STYRALUX 220 ❶ | 40-50 |
| Galvanised steel | Solvent degrease and abrade and clean. | 1st Coat: MULTI ETCH 302 | 6-12 |
| | | 2nd Coat: RUSTFIGHTER 215 | 40-50 |
| | | 3Rd Coat: STYRALUX 220 ❶ | 40-50 |

❶ Other top coats such as QD600 SPRAYING ENAMEL, AMERCOAT 5401, may be suitable. Refer overleaf.

# RUSTFIGHTER 215

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|---|---|
| **General Data** | |
| **Weathering** | May be left uncoated for up to 6 months (Mild exposure conditions) |
| **Finish** | Low lustre |
| **Chemical Resistance** | Not normally recommended. |
| **Abrasion Resistance** | Good |
| **Immersion** | Not recommended |
| **Temperature Range** | Up to $120^0$ C dry heat. |
| **Colour** | Red oxide, Grey, Black and Blue. Other colours batch quantities only. |
| **Topcoating** | Usually top coated with STYRALUX 220, QD 600 SPRAYING ENAMEL. |
| **Shelf Life** | 12 Months |
| **Application Data** | |
| **Theoretical Coverage** | 9.2 Sq Metres per litre at 40 µm dry film thickness. (Wet film thickness 110 µm). |
| **Volume Solids** | 37% |
| **Drying Time (@ 25ºC, 50% R.H.)** | Dust free: 3-5 Minutes. Touch Dry: 8-10 Minutes. Hard dry: 2 Hrs.<br>May be topcoated with single pack enamels after 3-4 Hrs drying.<br><br>NOTE*: The figures quoted for drying and recoating times are not definitive. They are dependent on site conditions, ambient and surface temperatures, weather and ventilation.* |
| **Mixing** | Stir thoroughly until uniform. |
| **Thinning** | Conventional spray application: Use up to 20% THINNER 445. Thinner 054 may be used for hot windy conditions. |
| **Equipment** | Conventional spray: DeVilbiss JGA 502 gun with "E" needle and fluid tip, 704 air cap or equivalent. Use 200-270 kPa pot pressure and 400 kPa atomising pressure.<br>Airless spray: Thinning not required. Use tip orifice 0.325-0375 mm, (0.013"-0.015"). Apply at 14-17 MPa atomising pressure. |
| **Safety Precautions** | Contents are flammable. Keep away from fire or naked flame or sparks. Keep away from children. Read Material Safety Data Sheet. When mixing or applying wear goggles and gloves and ensure good ventilation. When spraying, wear appropriate protective clothing and air supply. If splashed on skin, wash with soap and water. Adequate forced ventilation must be provided in confined spaces. |

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