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## TECHNICAL INFORMATION SHEET

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# 260 KEY-COAT

## Zinc Phosphate Etch Primer

### Description and uses:

260 Key-Coat is an epoxy-vinyl zinc phosphate etch primer which promotes adhesion of various topcoats. 260 Key-Coat has the following features:

- Suitable for coating mild steel, aluminum, galvanized iron, copper, brass etc.
- Contains zinc phosphate protection for ferrous metals.
- Can be top coated with most finishes.
- Acts as a barrier coat over unknown paints when repainting.

Typical areas of application are:

- Painting of office furniture and metal fabrications.
- Plant and machinery.
- Electronic equipment housing.
- Earthmoving and materials handling industries.

### Technical Specifications:

FINISH: Matt Grey, Black, Green, Yellow and White colours.

THINNERS: T166

VOLUME SOLIDS: Approximately 25% depending on colour.

COVERAGE: Approximately; 16-18 Square metres per litre (at a D.F.T. of 10 microns).

Approximately; 8-10 Square metres per litre (at a D.F.T. of 30 microns).

RECOMMENDED FILM THICKNESS:

(1) 5-10 microns when used as an etch primer over non-ferrous metals.

(2) 25-30 microns when used as an anticorrosive primer on steel.

APPLICATION: Conventional or airless spray.

DRYING AT 25°C / 50% Humidity:

Etch: Touch dry - 5 minutes  
Handle - 20 minutes  
Recoat - minimum 30 minutes, maximum 8 hours

Primer: Touch dry - 10 minutes  
Handle - 30 minutes  
Recoat - minimum 2 hours, maximum 3 months

**Note:** With extended exposure, ensure primer surface is free of chalk and contamination. Detergent wash, or degrease with cleaning solvents, (T191 or T192).

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APPLICATION DETAILS – PAINTING SYSTEMS			
D.F.T. um			
System 1 (used as an etch primer)	1 <sup>st</sup> Coat	5-10	260 Key-Coat (Thinner T166)
	2 <sup>nd</sup> Coat	50-75	Any Lacnam single or two-pack finishes

D.F.T. um			
System 2	1 <sup>st</sup> Coat	25-30	260 Key-Coat (Thinner T166)
	2 <sup>nd</sup> Coat	50-75	Any Lacnam single or two-pack finishes

APPLICATION DETAILS – SURFACE PREPARATION		
SUBSTRATE	DETAILS	RECOMMENDED SYSTEM
Steel	Power tool clean to AS1627.2 class 2 Or abrasive blast clean to AS1627.4 Class 2	2
Aluminum and non-ferrous metals	Light abrasive blast or treat with 212 metal clean.	1
Fiberglass	Light sand and wash down with thinner or cleaning solvent.	1 or 2
Previously painted surfaces	Lightly sand glossy areas wash down with cleaning solvent.	1 or 2

## Surface Preparation:

- When overcoating; Aged paint coatings should be tested for adhesion using Crosshatch or Crosscut methods. If aged paint coating lifts remove it.
- Remove all rust, oxides, mill-scale and loose paint from metal surface.
- Round off all sharp edges, welding joints and weld spatter.
- All surfaces to be painted should be clean and free from dust, dirt, oil, grease and moisture.
- All abrasive blast clean ferrous surfaces should be coated within 4 hours to avoid flash rusting.
- Do not apply at temperatures below 5° Celsius. Do not apply at relative humidity above 85%, or when the substrate surface is less than 3° Celsius above dewpoint.
- Applied 260 Keycoat subjected to exterior exposure for extended period of time should be accessed for “Chalking” before applying suitable topcoat to achieve optimum intercoat adhesion.

## Equipment Application: (Conventional or Airless Spray Recommended).

As a Guide Use:

Brush or Roller - Suitable for small areas only. May require Retarder Thinner T132.

Conventional Spray - 1.3 -2.0mm tip (or equivalent). Pressure pot set at 55 - 100kpa (8 - 15psi) and maintain gun air pressure 275 - 380kpa (40 -55psi).

Airless Spray – Use heavy-duty airless spray with 10 -15 “(0.25 – 0.38mm) plus tip and pump ratio 30:1

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## **Application Thinning:**

Thinning (as Etch): When film thickness of 5-10 microns is required, thin 50-100% with T166 thinner.

Thinning (as Primer): When film thickness of 25-30 microns is required, thin 25-50% with T166 thinner.

Conventional or airless spray: Thin as suggested and apply a smooth wet film.

**Note:** Poor adhesion may result if:

- (1) Etch is applied over damp surfaces.
- (2) Recoating times are not adhered to.
- (3) A dry coat is applied instead of a wet smooth coat.
- (4) Film thickness is greater than 5-10 microns on non-ferrous metals.

## **Safety Instructions:**

Storage: Store in a cool, dry banded area out of direct sunlight as required for Flammable liquids DG Class 3, PG II, Hazchem 3(Y)E.

Flammability: Highly flammable, all sources of ignition must be eliminated in or near area of use, on burning fumes emitted are toxic. Do not smoke in immediate area.

Handling: Adopt adequate Occupational Work Practices to avoid personal contamination with product. Always wash hands before smoking, eating, drinking or using toilet. Food and Drink should be to stored and consumed in separate area.

Personal Protection: Avoid contact with skin or eyes; wear suitable clothing such as impervious overalls, PVC or neoprene gloves, safety goggles and face mask.

Using: Avoid inhalation of spray mist and vapours – use with adequate ventilation and suitable Personal Protection Equipment (PPE).

Engineering controls: Ensure ventilation is adequate. When spraying, ensure product is applied in a fully functional spray-booth. Keep containers closed when not in use. Do not use near ignition sources.

### **REFER MSDS BEFORE USE**

(Phone 02 9688 1999 or refer to [www.lacnam.com.au](http://www.lacnam.com.au) for copy MSDS)

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