

CONGARD®

Single Pack Alkyd Primer-Finish

PC 640

- FEATURES**
- SELF PRIMING TOPCOAT
 - GLOSS FINISH
 - CONTAINS ZINC PHOSPHATE
 - RAPID DRYING
 - TINTABLE – AVAILABLE IN OVER 5,000 COLOURS

USES CONGARD® is a single pack, air drying, high build coating based on a modified alkyd resin. The incorporation of rust inhibitive zinc phosphate pigment enables direct application to blast or chemically cleaned steel, providing both corrosion protection and a decorative finish in the one product.

CONGARD® is ideal as a fast, economical primer finish in sheltered or mild environments or for simple refurbishing after repair. Typical areas of application include structural frames and trusses for factories and warehouses, farm or heavy engineering equipment and shipping containers.

CONGARD® is tintable to almost any colour in the Dulux® and AS2700 colour ranges.

SPECIFICATIONS

RESISTANCE GUIDE

WEATHERABILITY	Will chalk on exterior exposure. Neither yellowing nor chalking detracts from the protective properties of the coating.	SOLVENTS	Resists alcohol, mineral turpentine and similar solvents. Esters, ketones, ethers, chlorinated solvents or similar strong solvents are liable to attack the coating.
HEAT RESISTANCE	Up to 65°C dry heat	WATER	Resists rain and condensation. Not suitable for permanently damp or immersed exposure.
SALTS	Unaffected by splash and spillage of neutral salt solutions	ALKALIS	Not recommended where fumes, splash or spillage may occur.
ACIDS	Not recommended where fumes, splash or spillage may occur	ABRASION	Good when fully cured

TYPICAL PROPERTIES AND APPLICATION DATA

CLASSIFICATION	Modified alkyd primer-finish	APPLICATION CONDITIONS			
FINISH	Gloss		Min	Max	
COLOUR	White, Golden Yellow and a full range of tinted colours and MTO factory made colours.	Air Temp.	10°C	40°C	
		Substrate Temp.	10°C	40°C	
		Relative Humidity		85%	
COMPONENTS	One	COATING THICKNESS (MICRONS)			
VOLUME SOLIDS	38% (White)		Min	Max	Recommended
VOC LEVEL	<540 g/L (White, untinted)	Wet film per coat (µm)	160	240	200
FLASH POINT	4°C	Dry film per coat (µm)	60	90	75
POT LIFE	Not applicable	SUITABLE SUBSTRATES	Abrasive blast cleaned, hand cleaned or power tool cleaned steel.		
MIXING RATIO V/V	Single pack	PRIMERS	Not required		
THINNER – BRUSH	965-63020 Dulux® CR Reducer	APPLICATION METHODS	Conventional, airless spray or air assisted spray		
PRODUCT CODE	878-63001 White/Light Base 878-63002 Deep Base 878-63003 Clear Base 878-39141 Golden Yellow				

DRYING CHARACTERISTICS AT 75 µm DRY FILM THICKNESS*

Temperature	Humidity	Touch	Handle	Full Cure	OVERCOAT	
					Min ¹	Max ¹
25° C	50%	15 Minutes	2 Hours	7 Days	4 Hours	8 Hours

* These figures are a guide only, as ventilation, film thickness, humidity, thinning and other factors will influence the rate of drying.

¹ Overcoating can occur 4 hours after the initial application or before 8 hours. Failing to observe these limits may result in "frying" or wrinkling. If in doubt, test a small inconspicuous area first.

SPREADING RATE ASSUMING NO LOSSES

5.0 square metres per litre equals 75 µm dry film thickness

NOTE: Practical spreading rates will vary depending on such factors as application method, ambient conditions, surface porosity and roughness.

CONGARD®

TYPICAL SYSTEMS

This is a guide only and not to be used as a specification. Your specific project needs must be discussed with a Dulux Protective Coatings Consultant.

SURFACE	ENVIRONMENT	PREPARATION GUIDE	SYSTEM	DFT (µm)
STEEL	Mild corrosivity (AS2312.1 Cat C1-2)	Power tool clean AS1627.2 St 3 or Abrasive blast AS1627.4 Class 2	1 st Coat Congard® 2 nd Coat Congard®	75 µm 75 µm
STEEL	Mild corrosivity (AS2312.1 Cat C1)	Power tool clean AS1627.2 St 3 or Abrasive blast AS1627.4 Class 2	1 st Coat Congard®	75 µm

NOTE: If application is by brush or roller, additional coats will be necessary to achieve the minimum DFT and full opacity

SURFACE PREPARATION	<p>Steel: Round off all rough welds, sharp edges and remove weld spatter. Remove grease, oil and other contaminants in accordance with AS1627.1. Degrease with Gamlen CA No. 1 (a free-rinsing, alkaline detergent) according to the manufacturer's written instructions and all safety warnings. Abrasive blast clean to a minimum of AS1627.4 Class 2.5.</p> <p>Steel where abrasive blast cleaning is not viable: Rust, mill scale, oxide deposits and old paint films on metal surfaces must be removed by power tool cleaning (AS1627.2 St.3). Coating performance is proportional to the degree of surface preparation. Remove all dust by brushing or vacuum cleaning.</p>											
APPLICATION	<p>Mix can thoroughly with a power mixer until the contents are uniform. Ensure product has been tinted to the correct colour before use. DULUX® ASSUMES NO RESPONSIBILITY FOR THE APPLICATION OF INCORRECT COLOUR. Box all containers before use to ensure colour consistency. Remix before application.</p>											
BRUSH/ROLLER	<p>Recommended only for spot patching on rivets, seams, etc. When brushing and rolling additional coats may be required to attain the specified thickness.</p>											
CONVENTIONAL SPRAY	<p>Thin up to 50ml/litre with Dulux® CR Reducer (965-63020) to aid atomisation. Add only enough thinner to achieve atomisation. Apply in multiple wet coats overlapping each pass 50%.</p> <table border="0"> <tr> <td>Typical Set-up</td> <td>Graco AirPro</td> <td>1.8mm (239543)</td> </tr> <tr> <td></td> <td>Pressure at Triton 308:</td> <td>70-100 kPa (10-15 p.s.i.)</td> </tr> <tr> <td></td> <td>Pressure at Gun:</td> <td>380-410 kPa (55-60 p.s.i.)</td> </tr> </table>			Typical Set-up	Graco AirPro	1.8mm (239543)		Pressure at Triton 308:	70-100 kPa (10-15 p.s.i.)		Pressure at Gun:	380-410 kPa (55-60 p.s.i.)
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AIRLESS SPRAY	<p>Standard airless spray equipment such as a Graco Xtreme 30:1 with a fluid tip of 15-17 thou (0.38-0.43mm) and an air supply capable of delivering 550-690 kPa (80-100 p.s.i.) at the pump. Thinning is not normally required but up to 50 ml/litre of Dulux® CR Reducer (965-63020) may be added to ease application.</p>											
PRECAUTIONS	<p>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® Consultant 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. Do not apply at temperatures below 10°C. Do not apply at relative humidity above 85% or when the surface is less than 3°C above the dewpoint. Do not overcoat before the minimum overcoat interval or wrinkling may occur. Allow longer dry times under cold conditions. Overcoating can occur 4 hours after the initial application or before 8 hours. Failing to observe these limits may result in "frying" or wrinkling. If in doubt test a small inconspicuous area first. Check a small area before commencing recoat work. Do not apply over scale bearing steel. Do not apply on structures subject to sustained surface temperatures above 65°C or where spillage of strong solvent or oils may occur. Do not exceed a spreading rate of 5.0 sq. meters per litre. Abrasive blast cleaned surfaces must be primed within 4 hours. This product must not be topcoated with two pack heavy-duty coatings. Do not apply directly on galvanized iron or zinc rich coatings.</p>											
CLEAN UP	<p>Clean all equipment with Dulux® CR Reducer (965-63020) immediately after use.</p>											
OVERCOATING	<p>Degrease with Gamlen CA 1 according to the data sheet. Test adhesion of existing coating by standard cross hatch adhesion test. If the coating fails, remove it. High-pressure water wash at 8.3 to 10.3 MPa (1,200-1,500 p.s.i.) to remove chalk and dust. Abrade surface to provide a good key for the new coating.</p>											
SAFETY PRECAUTIONS	<p>Read Data Sheet, SAFETY DATA SHEET and any precautions on container labels. SAFETY DATA SHEET is available from Customer Service (13 23 77) or www.duluxprotectivecoatings.com.au</p>											
STORAGE	<p>Store as required for a flammable liquid Class 3 in a bunded area under cover. Store in well-ventilated area away from sources of heat or ignition. Keep containers closed at all times.</p>											
HANDLING	<p>As with any chemical, ingestion, inhalation and prolonged or repeated skin contact should be avoided by good occupational work practice. Eye protection approved to AS1337 should be worn where there is a risk of splashes entering the eyes. Always wash hands before smoking, eating, drinking or using the toilet.</p>											
USING	<p>Use with good ventilation and avoid inhalation of spray mists and fumes. If risk of inhalation of spray mists exists, wear combined organic vapour/particulate respirator. When spray painting, users must comply with their respective State Spray Painting Regulations.</p>											
FLAMMABILITY	<p>This product is flammable. All sources of ignition must be eliminated in, or near the working area. DO NOT SMOKE. Fight fire with foam, CO₂ or dry chemical powder. On burning will emit toxic fumes.</p>											
WELDING	<p>Avoid inhalation of fumes if welding surfaces coated with this paint. Grind off coating before welding.</p>											

COMPANY INFORMATION

Dulux Protective Coatings a division of

DuluxGroup (Australia) Pty Ltd
1956 Dandenong Road, Clayton 3168
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DuluxGroup (New Zealand) Pty Ltd
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PACKAGING, TRANSPORT AND STORAGE

PACKAGING Available in 15 litre packs

TRANSPORTATION WEIGHT 1.23 kg/litre

DAANGEROUS GOODS Class 3 UN 1263

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