



320SP Structural Primer

Fast-Drying Zinc Phosphate Primer

Product Description

320SP Structural Primer is a fast-drying, single-pack zinc phosphate primer designed for use on correctly prepared steel substrates. It provides short-term corrosion protection and an effective base coat for compatible air-drying enamel topcoats.

Product Details

- **Product Code:** 320SP Series
 - **Product Type:** Single Pack Structural Primer
 - **Finish:** Low Sheen
 - **Standard Colours:** Mid Grey, Black, White (custom tints subject to minimum order quantities)
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Key Properties

- **Thinning:** Up to 20% with recommended Enamel Thinner only
 - **Touch Dry:** 5–10 minutes (at 25°C)
 - **Recoat Time:** Minimum 2 hours
 - **Corrosion Resistance:** Good (temporary protection)
 - **Exterior Exposure:** 3–6 months (untopcoated, depending on conditions)
 - **Theoretical Coverage:** 10–15 m²/L
 - **Practical Coverage:** 7–10 m²/L
 - **Specific Gravity:** 1.00 – 1.20
 - **Weight Solids:** 40 – 50%
 - **Volume Solids:** 20 – 30%
 - **VOC Content:** Approx. 40%
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Packaging

- 4 Litre
 - 20 Litre
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Recommended Topcoats

- Can be recoated with most conventional single-pack solvent-based and water-based coatings. (Pre-test small area for adhesion and suitability.)
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Typical Uses

Suitable for use on correctly prepared:

- Structural steel
 - Steel tubing
 - Angles and flat bar
 - RSJ channeling
 - Racking systems
 - Metal furniture and fabricated steel components
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Substrate Limitations

- **Not suitable** for galvanised steel or aluminium substrates. For these surfaces, use **120PE Etch Primer**.
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Application Equipment

- HVLP Spray Gun
- Conventional Spray Gun

Note: Not recommended for brush or roller application except for minor touch-ups.

Application Conditions

- **Substrate & Air Temperature:** Above 10°C and below 40°C
 - **Relative Humidity:** Below 80%
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Surface Preparation

Correct surface preparation is critical to performance.

1. Ensure surfaces are free from dirt, grease, oil, and contaminants in accordance with **AS 1627.1**.
 2. Remove weld spatter and sharp edges. Round off welds where possible.
 3. Abrasive blast clean to a minimum of **AS 1627.4 Class 2.5**, achieving a surface profile of **40–70 microns**.
 4. Remove all dust and residues by vacuuming or wipe clean, ensure to wear appropriate dust mask.
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Application Procedure

1. Apply one uniform coat of **320SP Structural Primer** to achieve a dry film thickness (DFT) of **20–30 microns**.
 2. Allow to cure for **1–2 hours** before topcoating.
 3. Apply compatible enamel topcoat (e.g. 320DE Durenamel) to a DFT of **40–60 microns**.
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Recoating Guidelines

- May be used as a self-priming system when applied as **a minimum of two coats**.
 - Avoid excessive film build.
 - Heavy coats may require extended recoat times.
 - Do **not** use strong thinners such as GP Thinners or Lacquer Thinners, particularly during recoating.
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Storage & Handling

- Store in original sealed containers in a cool, dry, well-ventilated area.
 - Protect from extreme temperatures and direct sunlight.
 - Stir thoroughly before use.
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Disclaimer & Limitation of Liability

All information, recommendations, and advice provided by **Intec Coatings Pty Ltd** regarding the use of this product are given in good faith and are based on current knowledge and experience. As conditions of use, surface preparation, application methods, and environmental factors are beyond the control of Intec Coatings, no guarantee or warranty—express or implied—is given as to product performance in any specific application.

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Product performance is dependent on strict adherence to the recommended surface preparation and application procedures outlined in this Technical Data Sheet.

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