



# Epoxy Primer

## Use Above & Below Waterline

FEATURES	RECOMMENDED USES
<ul style="list-style-type: none"> <li>• Excellent adhesion to a wide variety of substrates</li> <li>• Mild Steel, Corten steel</li> <li>• Aluminium</li> <li>• Stainless Steel, Brass, Bronze and Lead</li> <li>• Sealed timber, Fibreglass, Epoxy resin</li> <li>• Gelcoat, Carbon fibre</li> <li>• Sealed ferro-cement</li> <li>• Formulated for use above and below water - simplifies full hull painting projects</li> <li>• Very long mixed pot life</li> <li>• Excellent long term re-coat and overcoating properties</li> <li>• Lead and chromate free</li> <li>• Very rapid dust-free and touch dry times</li> <li>• Iso-cyanate free</li> <li>• Excellent anti-corrosive properties</li> <li>• Ideal for fairing systems – to apply fairing compound onto and for the sealing of completed, sanded fairing systems</li> </ul>	<p><b>Altex Yacht &amp; Boat Epoxy Primer provides the foundation for all high performance marine systems. Altex Epoxy Primer is suitable for as vast range of substrates, and ensures exceptional adhesion for all coating systems to build on.</b></p> <p>Altex Epoxy Primer is recommended for use as:</p> <ul style="list-style-type: none"> <li>• Primer on suitably prepared steel, alloy, GRP and wooden substrates</li> <li>• Multi-coat primer and self-build system</li> <li>• Primer and seal coat for Altex Epoxy fairing systems</li> </ul> <p>Altex Epoxy Primer may also be used to seal off prepared, aged coatings prior to repainting - refer also to Altex Epoxy Barrier Undercoat.</p> <p>Altex Epoxy Primer is ideal for use below the water-line as a tie coat between aged epoxies and Altex Yacht &amp; Boat Antifouling-</p> <ul style="list-style-type: none"> <li>• No.5 Ablative</li> <li>• Sea-Zone 60</li> <li>• Pettit Vivid®</li> <li>• Pettit Hydrocoat®</li> </ul> <p><i><b>Limitations.</b> Epoxy Primer is a thin film adhesion primer. It is not designed for thick film application-apply at 50-75µm maximum (sufficient to hide the substrate only).</i></p> <p><i>Further, it is not designed to be sanded-refer to Altex High Build Sanding Surfacer and Altex Epoxy Barrier Undercoat.</i></p> <p><i>Not recommended for sealing aged antifouling</i></p>

### SPECIFICATION DATA

<p><b>Generic Type:</b> Polyamide Epoxy</p> <p><b>Colour:</b> Grey</p> <p><b>Packaging:</b> 1.25 litre and 5 litre (10 Litre-Aust Only) Two component kits</p> <p><b>Mix Ratio:</b> 4 to 1 by volume</p> <p><b>Gloss:</b> Flat</p> <p><b>Flash Point:</b> 27°C</p> <p><b>Thinner:</b>Spray: Altex Thinning Solvent #12 Brush/Roller: Altex Thinning Solvent #22</p> <p><b>Pot Life:</b>12 hours at 25°C</p> <p><b>Induction Time:</b> 15 minutes</p> <p><b>Storage:</b> Store under cool, dry conditions</p>	<p><b>Density:</b> 1.33 kg per mixed litre</p> <p><b>Volume Solids (Mixed):</b> 45%</p> <p><b>Theoretical Coverage Rate:</b> 9.0 sq metres per litre at 50 microns dry</p> <p><b>Recommended Film Thickness Per Coat:</b> 111 microns wet to obtain 50 microns dry</p> <p><b>Application:</b> Spray, brush or roller</p> <p><b>Dry Times (50 µm DFT / 25°C / 50% RH):</b></p> <table style="margin-left: 20px;"> <tr> <td>Touch Dry</td> <td>1 Hour</td> </tr> <tr> <td>Hard Dry</td> <td>8 Hours</td> </tr> </table> <p><b>Recoat Times (50 µm DFT / 25°C / 50% RH):</b></p> <p><b>Minimum Recoat:</b></p> <table style="margin-left: 20px;"> <tr> <td>Self Recoat</td> <td>2 Hours</td> </tr> <tr> <td>Overcoat with other epoxies &amp; Antifouling</td> <td>2 Hours</td> </tr> </table> <p><b>Maximum:</b></p> <table style="margin-left: 20px;"> <tr> <td>Antifouling</td> <td>24 Hours</td> <td>(see above)</td> </tr> <tr> <td>Self &amp; other epoxies</td> <td></td> <td>3 Months</td> </tr> </table> <p>For recoating aged Epoxy Primer (greater than 3 months), please contact AY&amp;B Technical Services</p>	Touch Dry	1 Hour	Hard Dry	8 Hours	Self Recoat	2 Hours	Overcoat with other epoxies & Antifouling	2 Hours	Antifouling	24 Hours	(see above)	Self & other epoxies		3 Months
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Hard Dry	8 Hours														
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## SURFACE PREPARATION

Use Altex Epoxy Primer on suitably prepared mild & corten steel, aluminium & other non ferrous metals, GRP, wood (preferably sealed with Altex Epoxy TimberSealer), Gelcoat and freshly sanded epoxy fairing. Also use as the final coat under water before applying the anti-fouling.

All surfaces must be sound and free of oil, grease, dirt, form release agents, curing compounds, loose and flaking paint, moisture and other foreign substances prior to application of Altex Epoxy Primer.

### Aluminium

Degrease all alloy surfaces with either Altex C50 Surface Cleaner, using the two-rag method, one to apply the C50, the other to wipe the surface clean:

Or: wash the surface down with Altex P40 Prepainting Cleaner. (refer Product Data Sheet)

Abrade the surface using 80-120 grit, non-metallic discs or sandpaper, to achieve a roughened profile, similar to 80 - 100 grit sandpaper. Dedust with clean, dry air or clean broom.. Do NOT use rags to remove particles

Altex Epoxy Primer should be applied to the cleaned surface as soon as possible to prevent re-oxidation or contamination.

### Steel Surfaces:

Blast to near white metal, equivalent to Steel Structures Painting Council SP10 or AS1627.4 Class 2½. The steel profile after blasting should be 30 to 50 microns in depth and be of a jagged nature as opposed to a peen pattern.

SSPC SP3: Mechanical preparation/power tool cleaning. Degrease prior to grinding / abrading. Mechanically abrade the surface with 60-80 grit discs to remove all aged, failed coatings, mill scale, corrosion products, weld burn etc., and achieve a bright metal look with a pronounced texture/profile. Do not buff or polish the surface.

Degrease again to remove preparation residues.

### GRP/Epoxy Fairing.

Ensure all surfaces are freshly sanded, clean and free of dust residues..

## DIRECTIONS FOR USE

### Mixing:

Altex Epoxy Primer is a two component product supplied in kits which contain the correct ratio of ingredients. The entire contents of each container must be mixed together.

Power mix both Part A and Part B separately first to obtain a smooth, homogeneous condition. After mixing, add Part B slowly with continued agitation to the Part A. Allow an induction time of 15 minutes before application.

The pot life of the mixed material is 24 hours at 20°C. Higher temperatures will reduce the working life of the coating; lower temperatures will increase it.

### Thinning:

Thinning is required for spray application. Thin between 10% and 25% with Altex Thinning Solvent #12.

For brush/roller application, typically thin up to 20% with Altex Thinning Solvent #22.

It is important to thin to avoid overbuilding – evidenced by heavy brush marks or orange peel, slow cure and a soft film.

### Application:

Altex Epoxy Primer can be applied by spray, brush or roller. Application by either airless or conventional air spray equipment is the preferred method.

Suggested spray equipment is:

Air Spray            *Graco* - Delta Air Spray; 1.2 – 1.4mm Fluid Nozzle

*De Vilbiss* - JGA gun, E or D Fluid Nozzle, 704/765 or 64 Air Nozzle

Airless Spray      *Graco* - 30:1 pump, Contractor gun, 0.017-0.021" RAC IV tip

(Note: Other equipment equivalent to the above may be used.)

### Clean-up:

Use Altex Thinning Solvent #12

## PRECAUTIONS

For DIY & Professional Use: Read and follow all the caution statements on this Product Data Sheet, the product label and the Safety Data Sheet (SDS) for health and safety information prior to use.

**Altex Epoxy Primer** is flammable. Keep away from heat, sparks and open flame. Use with adequate ventilation. May cause eye and skin irritation. Do not breathe vapour or spray. Wear suitable protective clothing such as gloves and eye and face protection.

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### DISCLAIMER

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