



# Altra~Etch<sup>®</sup>

## Single Pack Etch Primer

Data Sheet

### FEATURES

Altra~Etch<sup>®</sup> is a versatile etch primer suited to many light industrial and marine applications.

#### Advantages:

- Excellent adhesion to most common metals
- Versatile, convenient, stable, single pack primer
- Fast drying
- Good abrasion resistance
- Compatible with a wide variety of topcoats

#### Limitations of Use:

Altra~Etch<sup>®</sup> is not designed to give long term exterior protection without over coating.

Altra~Etch<sup>®</sup> is not normally used in an immersed environment.

### RECOMMENDED USES

Altra~Etch<sup>®</sup> is a single pack etch primer which conforms to AS3884 Type 1 and AS3750.17 Type 1.

Altra~Etch<sup>®</sup> may be over coated with most finish topcoats including enamel, chlorinated rubber, epoxy, vinyl acrylic and polyurethane.

#### Altra~Etch<sup>®</sup> is recommended:

- **As a high performance key coating**
- **As a prefabrication holding primer**
- **As a conventional etch over surfaces including**
  - Galvanised steel
  - Zinc sheet
  - Aluminium sheet and Extrusions
  - Mild steel
  - Zinc & Aluminium Spray

### SPECIFICATION DATA

<b>Coating Type:</b>	Single Pack Modified Epoxy Etch
<b>Colours:</b>	Grey and Red
<b>Packaging:</b>	1 and 4 litres Single component
<b>Gloss:</b>	Satin
<b>Flash Point:</b>	12°C Setaflash
<b>Thinner:</b>	Altex Thinning Solvent #155
<b>Pot Life:</b>	N/A
<b>Induction Time:</b>	N/A
<b>Shelf Life:</b>	12 months
<b>Storage:</b>	Store under cool, dry conditions

<b>Density:</b>	0.97 kg per litre
<b>Temperature Resistance:</b>	100°C Dry
<b>Volume Solids (Mixed):</b>	10% ± 1%
<b>Theoretical Coverage Rate:</b>	5.0 sq metres per litre at 20 microns dry
<b>Recommended Film Thickness Per Coat:</b>	150-200 microns wet to obtain 15-20 microns dry
<b>Application:</b>	Spray, Brush or Roller
<b>Dry Times (25°C / 20 µm DFT / 50% RH):</b>	
Touch Dry	5 minutes
Handle	15 minutes
<b>Recoat Minimum:</b>	
Self	1 hour
Alkyd	2 hours
Other	4 hours
<b>Recoat Maximum:</b>	Within 90 days, (unexposed)

Note: Ventilation, film thickness, temperature, humidity and other factors can influence the rate of drying.

## SURFACE PREPARATION

All surfaces must be sound and free of oil, grease, dirt, loose and flaking paint, moisture and other foreign substances prior to application of **Altra-Etch®**. Clean and/or degrease with either a suitable non-ionic detergent, (such as Altex P40 Cleaner), or solvent wipe with Altex C50 Surface Cleaner.

**Steel Surfaces:** For optimum results, abrasive blast to near white metal equivalent to AS1627.4, Class 2½ (SSPC SP-10). Satisfactory results will be achieved by abrasive blasting to AS1627.4 Class 2 (SSPC SP6). For smaller areas, power tool cleaning to AS1627.2, (SSPC SP3) will provide an acceptable surface for coating.

**Galvanized Steel and Electrodeposition Zinc Surfaces:** Degrease with either a suitable non-ionic detergent, (such as Altex P40 Prepainting Cleaner), or solvent wipe with Altex C50 Surface Cleaner.

For electrodeposition zincs, abrasion with a Scotchbrite® pad or P220-320 sandpaper is required to create a surface profile.

In the case of galvanising it is essential that all traces of dichromate passivation are removed. This is often best accomplished with a light sweep abrasive blast or very thorough scouring with a synthetic scour pad, or mechanical sander.

**Aluminium:**

Degrease as above. Typically surfaces are lightly abraded with either a Scotchbrite® pad or P220-320 sandpaper. Apply **Altra-Etch®** to the clean and dry surface.

*(Scotchbrite® is a registered trademark of the 3M Company)*

## DIRECTIONS FOR USE

**Mixing:**

Stir thoroughly to ensure a homogeneous condition. This product is supplied at application consistency however some thinning may be required depending upon the type of surface to be painted, and the prevailing weather conditions.

**Thinning:**

Thinning is not normally required; however up to 10% may be added without affecting the efficiency of the coating. Use only Altex Thinning Solvent #155.

**Application:**

The preferred method of application for Altra-Etch® is spray. Small areas may be brush or rolled if conditions are suitable, however, care must be taken to ensure the correct film build is applied.

**Clean-up:**

Use Altex Thinning Solvent #155.

**Application:**

Suggested spray equipment:

**Conventional Air Spray**

1.0mm to 1.4mm Fluid tip with appropriate air cap.

(Note: The above is a guide. Other equipment to the above may be used.)

**Airless Spray**

Not Recommended.

**Ventilation:**

It is very important for the safety of the applicator and the proper performance of Altra-Etch® that good ventilation be provided to all portions of the enclosed area. It is equally important to bring into the enclosed area dry fresh air to remove all solvent vapours. Since solvent vapours are heavier than air, ventilation ducts should reach to the lowest portions of the enclosed areas as well as into any structural pockets. Ventilation should be provided throughout the cure period to ensure all of the solvents are removed from the coating.

## PRECAUTIONS

For industrial use only: 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.

**Altra-Etch®** 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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