



# Altra~Zinc® 605

## Reinforced Epoxy Zinc Primer

Data Sheet

### FEATURES

#### Advantages:

- Premium performance primer for most Industrial systems.
- Resists topcoat pinholing
- Resistant to dry spray, mudcracking and topcoat bubbling
- Easy to mix - zinc pre-mixed into base component
- Easy application by brush, roller or spray
- Fast Dry-to-Recoat
- Good low temperature cure
- Good solvent resistance
- Safe - contains no lead or chromate pigments
- Versatile - can be used as the primer under numerous coating systems

#### Performance Data (as part of a system):

- Salt Spray Resistance (Cyclic Prohesion Testing) 2500 hours - Excellent
- Immersion Resistance (5% Salt Solution) 2500 hours – Excellent

#### Approvals:

Conforms to the composition and performance requirements of SSPC Paint Specification 29; Level 2

### RECOMMENDED USES

Altra~Zinc® 605 is a high performance, two component, reinforced epoxy zinc-rich primer designed for use as a cathodic primer for protecting steel exposed to a variety of environments.

Altra~Zinc® 605 is an ideal, rapid dry zinc primer for use on most mild steel fabricated equipment including:

- Machinery
- Electrical Switchboards
- Light Industrial equipment, conveyors, compressors, Pipework etc
- Structural Steel
- Machinery & equipment repairs.
- Original Equipment Manufacturing (OEM)

Primer of choice for a durable, two-component coating system for a wide range of environments.

#### Limitations of Use:

- Do not topcoat with alkyd coatings
- Not suitable for solvent, chemical or fresh water immersion service
- A minimum of 8 hours of protected cure is required before exposure to condensation / dew / rainfall.
- Ponding on coated steelwork will result in discolouration & possible film issues.
- Only the stated solvent should be used for thinning

### SPECIFICATION DATA

<b>Coating Type:</b>	Reinforced Epoxy Zinc
<b>Colour:</b>	Grey & Green
<b>Packaging:</b>	10 litre only Two component kits
<b>Availability:</b>	Australia & MTO New Zealand
<b>Mix Ratio:</b>	4 to 1 by volume
<b>Gloss:</b>	Flat
<b>Flash Point:</b>	14°C
<b>Thinner:</b>	Altex Thinner #12 (Do Not use any alternative thinner)
<b>Pot Life:</b>	8 hours at 25°C
<b>Induction Time:</b>	15 minutes
<b>Storage:</b>	Store under cool, dry conditions

(storage at ambient temperatures (exterior bunker) may cause significant condensation to form within the tins. Avoid such cyclical temperature variations)

<b>Density:</b>	2.15 kg per litre		
<b>VOC:</b>	415 grams per mixed litre		
<b>Temperature Resistance:</b>	Max. 200°C Dry-intermittent		
<b>Theoretical Volume Solids (Mixed):</b>	64% Wet/Dry Method		
<b>Theoretical Coverage Rate:</b>	8.5 sq metres per litre at 75 microns dry		
<b>Recommended Film Thickness Per Coat:</b>	50-100 microns dry		
<b>Application:</b>	Spray, brush or roller		
<b>Dry Times (75 µm DFT / 50% RH):</b>			
	<u>5°C</u> <u>15°C</u> <u>25°C</u>		
Touch Dry	2 Hrs      1 Hr      ¾ Hr		
Hard Dry	4.5 Hrs      1.5 Hrs      1 Hr		
Minimum Recoat	2.5 Hrs      1.5 Hrs      1 Hr		
Maximum Recoat	<i>Dependant on topcoat to be used. Refer specification data.</i>		

## SURFACE PREPARATION

All surfaces must be free of oil, grease and moisture. Round off welds and sharp edges and remove weld splatter.

### New Steel Surfaces:

For optimum results, abrasive blast to near white metal equivalent to SSPC SP10/NACE No.2 (AS1627.4, Sa 2½)

Satisfactory results will be achieved by abrasive blasting to SSPC SP6/NACE No.3 (AS1627.4 Sa2)

For smaller areas, power tool cleaning to SSPC SP3 (AS1627.2 St3) will provide an acceptable surface for coating.

### Previously Painted Surfaces:

Remove old paint to bare metal. Prepare surface as for new steel. Achieve a minimum of SSPC SP6/NACE No.3 (AS1627.4 Sa2) on rough or pitted steel.

For smaller areas, power tool cleaning to SSPC SP3 (AS1627.2 St3) will provide an acceptable surface for coating.

### Galvanising Repair:

To repair weld or mechanical damage to galvanising, mechanically abrade all damaged areas to SSPC SP3 (AS1627.2 St3). Feather back edges to sound galvanising. Dedust and degrease with Altex C50 Surface Cleaner. Apply Altra-Zinc® 605 to all exposed mild steel surfaces, and slightly overlap onto the feathered galvanised edge.

Overcoat as required.

## DIRECTIONS FOR USE

### Mixing:

Altra-Zinc® 605 Primer is a two component product supplied in 10 litre kits which contain the correct ratio of ingredients. The entire contents of each container must be mixed together. We do not recommend mixing part kits.

The zinc metal is ready mixed in the base portion. Stir the base portion thoroughly to obtain a smooth, homogeneous condition. Whilst continuing to stir with a slow speed mixer, slowly add the liquid component. Continue to mix at slow speeds until an homogeneous condition.

Allow a 15 minute induction time before using.

The pot life of the mixed material is 8 hours at 25°C. Higher temperatures will reduce the working life of the coating; lower temperatures will increase it.

### Thinning:

Thinning in the range of 5% to 15% with Altex Thinning Solvent #12 may be required for optimum atomisation and wet film flow out.

Do NOT exceed 20% thinning.

Do NOT use any alternative thinners – this may adversely affect the film, cure rate and performance.

### Application:

Altra-Zinc® 605 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 gun, 1.6mm to 2.8mm tip.

*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.)

Apply Altra-Zinc® 605 to small areas by brush and roller.

### Clean-up:

Use Altex Thinning Solvent #12.

## PRECAUTIONS

For industrial use only: See the Altex Coatings General Safety Data Sheet, product label and Material Safety Data Sheet (MSDS) for health and safety information prior to use.

**Altra-Zinc 605® 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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