

The Multi-Gard GP (general purpose) products are formulated to protect steel substrates in a variety of service exposures typical of industrial OEM equipment destinations. The Multi-Gard line tends toward rapid cure to handle and re-coat to facilitate through-put in shop painting applications.

Selection & Specification Data

Generic Type	Formerly Altra~Prime [®] 514-ZP Multi-Gard [®] GP 22 ^{AU} is a polyamide epoxy
Description	Corrosion resistant high performance, chemically cured epoxy primer, primarily for use on all steel, galvanised metal or aluminium surfaces.
Features	<ul style="list-style-type: none"> • Versatile primer over a variety of substrates • Fast dry and recoat times • Formulated with Zinc Phosphate • Very good aged recoatability • Good abrasion resistance • Long pot-life • Excellent adhesion
Gloss	Flat
Colour	Grey
Topcoats	Multi-Gard [®] GP 33 ^{AU} , GP 48 ^{AU} & GP 88 DTM ^{AU}
Dry Film Thickness	50-75µm
Solids Content	50%
Theoretical Coverage Rate	50µm dry covers 10 sq. metres per litre 75µm dry covers 6.7 sq. metres per litre
Mix Ratio	4:1 by volume
VOC Values	As supplied: 432g/L
Dry Temp. Resistance	121°C – maximum non-continuous
Limitations	Not suitable for exposure to strong solvents.

Substrates & Surface Preparation

General	Remove any oil or grease from surface to be coated by the two rag method with clean rags soaked in Thinning Solvent #2.
Steel	Minimum abrasive blast to AS 1627.4 Class 2. Power tool cleaning to AS 1627.2 St3 are suitable cleaning methods for mild environments.
Galvanized Steel & Aluminium	Sweep abrasive blast to a matter finish with non-metallic blast media.
Previously Painted Surfaces	Lightly sand or abrade to roughen and degloss the surface. Existing paint must attain a minimum 3B rating in accordance with ASTM D3359 "X-Scratch" adhesion test.

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Multi-Gard® GP 22^{AU}

Application Equipment

Listed below are general equipment guidelines for the application of this product. Job site conditions may require modifications to these guidelines to achieve the desired results. **General Guidelines:**

Conventional Spray Pressure pot equipped with dual regulators, 9mm (3/8") I.D. minimum material hose, 1.2mm – 1.4mm fluid tip and appropriate air cap.

Airless Spray Pump Ratio: 30:1 (min.)*
Output: 10 lt/min (min.)
Material Hose: 9mm (3/8") I.D. (min.)
Tip Size: 0.015-0.017"
Output PSI: 2100-2400
Filter Size: 60 mesh
*Teflon packings are recommended and available from the pump manufacturer.

Brush & Roller (General) The desired film thickness is easily achieved in a single brush or roller coat; however due to the initial lacquer dry characteristic of this coating additional thinning with Thinning Solvent #12 may be required for a smooth finish; in warm or windy conditions use of slower solvent such as Thinning Solvent #25 may be advantageous. Avoid excessive rebrushing or re-rolling. For best results, tie-in within 10 minutes at 24°C.

Mixing & Thinning

Mixing Multi-Gard® GP 22^{AU} is a two component product supplied in 5 litre and 10 litre kits which contain the correct ratio of ingredients. Power mix Part A separately, then combine and power mix. DO NOT MIX PARTIAL KITS.

Ratio 4:1 by volume (Part A : Part B)

Thinning Thinning requirement will vary depending upon conditions. Thin with Thinning Solvent #12 as required for good atomisation; typically between 5% - 20%.

Pot Life 12 hours at 25°C

Cleanup & Safety

Cleanup Use Thinning Solvent #12 or #2 or Acetone. In case of spillage, absorb and dispose of in accordance with local applicable regulations.

Safety Read and follow all caution statements on this product data sheet and on the SDS for this product. Employ normal workmanlike safety precautions. Hypersensitive persons should wear protective clothing, gloves and use protective cream on face, hands and all exposed areas.

Ventilation When sprayed may be harmful by inhalation - do not breath vapour or spray. Wear suitable clothing, gloves, eye and face protection.

Application Conditions

Condition	Material	Surface	Ambient	Humidity
Normal	16°-24°C	18°-24°C	18°-24°C	30-70%
Minimum	5°C	5°C	5°C	0%
Maximum	32°C	50°C	50°C	95%

Industry standards are for substrate temperatures to be 3°C above the dew point.

Curing Schedule

Surface Temp. & 50% Relative Humidity	Dry to Recoat / Topcoat	Dry to handle	Hard dry
5°C	6 hours	12 hours	15 hours
15°C	2½ hours	6 hours	8 hours
25°C	1½ hours	2 hours	3 hours
30°C	1 hours	1½ hours	2 hours

Packaging, Handling & Storage

Pack Sizes 5 litre and 10 litre kits

Flash Point (Setaflash) Multi-Gard® GP 22^{AU} Part A: 23°C
Multi-Gard® GP 22^{AU} Part B: 41°C

Storage Temperature & Humidity Store under cover in dry conditions.
4°-38°C
0-95% RH

Shelf Life Part A: Minimum 24 months
Part B: Minimum 24 months

***Shelf Life: (actual stated shelf life) when kept at recommended storage conditions and in original unopened containers**



Manufactured / supplied by:-
Resene Paints (Australia) Limited
7 Production Ave
Queensland 4214
Australia
Phone: +61 7 5512 6600

350 Hanley Industrial Court, St. Louis, MO 63144-1599
314/644-1000 314/644-4617 (fax) www.carboline.com

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