Epoxy Aluminium Primer

For Non-Immersed Surfaces

PRODUCT DATA SHEET

FEATURES

- Modified Epoxy Polyamide Anti-Corrosive Primer
- Extensively tested against prevailing performance standards for aluminium primers
- Meets the performance requirements of MIL P – 23377 (strontium chromate type) as follows:-
  - Filiform Corrosion Resistance (ASTM D 2803)
    - Required Result 1000 hours; Pass
    - Tested Result 2000 hours, Pass
  - Corrosion Resistance (Salt Spray – B117)
    - Required Result 1000 hours; Pass
    - Tested Result 3000 hours; Pass
- Rapid Dry-to-prime or topcoat
- Easy to use - 1:1:1 (base : converter : thinner) mix ratio
- Excellent adhesion to aluminium alloys and galvanising
- Excellent resistance to filiform corrosion on aluminium surfaces
- Cures well at low temperatures
- Proven case histories over many years

Limitations of Use:

- Not suitable for use on surfaces subject to continuous immersion.
- Do not overbuild – apply to achieve a semi-transparent yellow film
- Observe min/max recoat times strictly

RECOMMENDED USES

Altex Yacht & Boat Epoxy Aluminium Primer is a two component primer utilising high performance, anti-corrosive chromates designed for use on aluminium launches, dinghies & yachts.

It has been developed for use above the waterline (non-immersion) to provide the very best adhesion to aluminium substrates, and for optimum protection against filiform corrosion.

Epoxy Aluminium Primer is recommended for:

- Launches, dinghies, yachts – topsides, cabin tops, decks, internal areas, void spaces, masts & spars
- Superior adhesion to aluminium surfaces
- Superior resistance to filiform corrosion.
- All atmospheric exposures (topcoated)
- All aluminium surfaces to be coated with high performance epoxy and urethane systems
- Trailers, caravans, house trucks, horse floats and other vehicles fabricated in aluminium

Altex Epoxy Aluminium Primer may be intermediate / top coated with:-

- Altex Epoxy Primer
- Altex Epoxy High Build Surfacer
- Altex Epoxy Barrier Undercoat
- Altex Polyurethane Undercoat
- Altex Elite® Pro~Spray Linear Polyurethane
- Altex Elite® 321 Brushing Polyurethane

SPECIFICATION DATA

Coating Type: Modified Polyamide Epoxy Anti-Corrosive

Colour: Translucent Yellow

Packaging: 500 ml - Two component kits

Mix Ratio: 1 to 1 by volume

Gloss: Low Sheen

Flash Point: 12°C Setaflash

Thinner: Altex Thinning Solvent #12

Pot Life: 12 hours at 25°C

Induction Time: Not required

Storage: Store under cool, dry conditions

Density: 1.05 kg per litre / mixed

VOC: 585 grams per mixed litre

Temperature Resistance: 80°C Dry

Volume Solids (Mixed): 30±1%

Theoretical Coverage Rate:

15 square metres per litre at 20 microns dry

Recommended Film Thickness per Coat:

70 microns wet to obtain 20 microns dry

Application: Conventional pressure pot

Dry Times (25°C / 20 µm DFT / 50% RH):

Touch Dry	10-20 minutes
Optimum to Overcoat	3 hours
Maximum to Overcoat	24 hours

(Overcoat being any epoxy primer / undercoat or polyurethane undercoat / finish coat)

SURFACE PREPARATION

All aluminium surfaces must be sound and free of oil, grease, dirt, lubricants or other compounds, loose and flaking paint, moisture and other foreign substances prior to application of Epoxy Aluminium Primer.

All Aluminium Surfaces: - Degrease:
Aluminium surfaces must be degreased (either with Altex P40 Prepainting Cleaner, or Altex D30 Degreaser/Dewaxer), before being mechanically abraded or sandblasted. Wipe the surface with a clean, white cloth and check for any residual contaminants, and repeat cleaning process until all surfaces are thoroughly clean.

Note: Avoid contact between your skin and the prepared surface to eliminate contaminating the surface with oils.

Abrasion:
Increasingly higher surface profiles are required as the thickness of the coating system increases.
Incorporating any Epoxy Fairing Compound and / or Altex Epoxy High Build Surfacer in the coating system will require a higher surface profile than a thin film, non faired system.
Higher profiles are achieved by using a coarser sandpaper- typically 60 - 80 grit, or abrasive blasting.

For fairing systems or heavy duty exposures the recommended cleaning method is sweep abrasive blasting with fine, non-metallic garnet or similar media to attain a uniform matt finish. The surface profile should be 45-70 microns - similar in texture to 80 grit sandpaper.

For low film build systems (prime / undercoat / finish coat) finer sanding grades are acceptable (120 – 180 grit) For light duty non faired work (prime / finish coat), Epoxy Aluminium Primer provides good adhesion to degreased and Scotchbrite® abraded surfaces.

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

ALL PREPARED SURFACES MUST BE COATED AS SOON AS POSSIBLE AFTER SURFACE PREPARATION – WITHIN 2 HOURS MAXIMUM.

Larger projects will require staggered preparation and application techniques to avoid oxidation of the prepared surface.

(This product and method of priming aluminium surfaces does not require the use of acid treatment to prepare the surface. We do not recommend the practice of acid etching for priming with Epoxy Aluminium Primer)

DIRECTIONS FOR USE

Mixing:
Epoxy Aluminium Primer is a two component product supplied in 500ml kits which contain the correct ratio of ingredients. The entire contents of each container must be mixed together.

Stir the Epoxy Aluminium Primer Part A (base portion) first to obtain a smooth, homogeneous condition using a power stirrer. After mixing the base portion add the Part B slowly with continued stirring. After mixing is completed, proceed to Thinning as directed below.

The pot life of the mixed material is 12 hours at 25°C. Higher temperatures will reduce the working life of the coating; lower temperatures will increase it.

Thinning:

Thinning is required for optimum film thickness control. For spray application, thin 50% by volume with Altex Thinning Solvent #12, ie 1:1:1 (Part A : Part B : Thinner).

For roller application, thin 10-15% with Thinning Solvent #12.

Application:
Epoxy Aluminium Primer is best applied by conventional spray. Epoxy Aluminium Primer may also be applied to small areas by brush and roller.

Do not overbuild this product! The correct film thickness is achieved when the surface first just attains a semi-transparent yellow colour.

Equipment:

Suggested spray equipment is:

Air spray	*Graco* - Delta Air spray gun, 1.1-1.4mm (0.040-0.070”) set up
	De Vilbiss - JGA gun, E Fluid Nozzle, 704 Air Nozzle

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

Clean-up:
Use Altex Thinning Solvent #12

PRECAUTIONS

For DIY 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.

Epoxy Aluminium 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.

WWW.ALTEXBOATPAINT.COM

Head Office New Zealand
Altex Coatings Ltd
91-111 Oropi Road
Greerton, Tauranga 3112

Ph : +64 7 541 1221
Fax : +64 7 541 1310

Head Office Australia
Resene Paints (Aust) Ltd
Industrial & Marine Division
7 Production Avenue, Molendinar
Queensland 4214
Ph : +61 7 5512 600
Fax : +61 7 5512 697

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