

SELECTION & SPECIFICATION DATA

Generic Type	Single pack modified epoxy etch Multi-Gard 15-Q568
Description	Altra~Etch is a single pack etch primer, conforms to AS 3884 Type 1 and AS 3750.17 Type 1. A single component, versatile etch primer suited to many light industrial and marine applications and may be top-coated with most finish coats. May be used as a pre-fabrication holding primer.
Features	<ul style="list-style-type: none"> • Excellent adhesion to most common metals: Galvanised steel, zinc sheet, aluminium sheet & extrusions, mild steel, zinc & aluminium spray • Versatile, convenient, stable single pack primer • Fast drying • Good abrasion resistance • Compatible with a wide variety of topcoats
Colour	Standard AU/NZ: Grey, and Black NZ Only: Red
Gloss	Satin
Film Build	15 - 20 microns Do not exceed 30 microns
Solid(s) Content	10% ± 1%
Theoretical Coverage Rates	5.0 sq. metres per litre at 20 microns DFT Allow for loss in mixing and application.
Dry Temp. Resistance	Continuous: 80°C (176°F) Non-Continuous: 100°C (212°F)
Limitations	<ul style="list-style-type: none"> • Not designed to give long term exterior protection without over-coating • Not normally used in any immersed environment
Topcoats	May be over-coated with most topcoats including alkyd enamel, chlorinated rubber, vinyl acrylic, epoxy and polyurethane

SUBSTRATES & SURFACE PREPARATION

General	All surfaces must be sound and free of oil, grease, dirt, loose and flaking paint, moisture and other foreign substances prior to application of this product. Clean and/or degrease with either a suitable non-ionic detergent (such as Altex P40 Cleaner), or solvent wipe with Altex C50 Cleaner.
Steel	For optimum results, abrasive blast in accordance with to SSPC-SP 10 (AS 1627.4 Sa 2½). Satisfactory results will be obtained by abrasive blast to SSPC-SP 6 (AS 1627.4 Sa 2). For smaller areas or less critical exposure, power tool cleaning to SSPC-SP 3 (AS 1627.2 St 3) or hand tool cleaning to SSPC-SP 2 (AS1627.2 St 2) will provide an acceptable surface for coating.

SUBSTRATES & SURFACE PREPARATION

Galvanised Steel	<p>It is essential that all traces of dichromate (or similar) quench passivation are removed. This is often best accomplished with a light sweep abrasive blast or <u>very thorough</u> scouring with a synthetic scour pad or mechanical sander.</p> <p>For electro-deposition zincs, abrasion with a Scotchbrite® pad or P220-320 sandpaper is required to create a light surface profile.</p> <p>Do not apply over dichromate passivation layer.</p>
Aluminium	<p>Typically, surfaces are lightly abraded with either a Scotchbrite® pad or P220-320 sandpaper. Ensure surface is free of dust, grit and debris. Prime the prepared substrate as soon as possible before oxidation occurs.</p> <p><i>Scotchbrite® is a registered trademark of the 3M Company</i></p>

MIXING & THINNING

Mixing	Stir thoroughly to ensure a homogeneous condition.
Thinning	<p>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. Up to 10% thinning with Altex Thinning Solvent #155 may be added without affecting the efficiency of the coating.</p> <p>Do not use thinners other than those recommended by Altex Coatings.</p>
Pot Life	N/A - single component

APPLICATION EQUIPMENT GUIDELINES

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	The preferred method of application for this product is by spray. Small areas may be brushed or rolled if conditions are suitable; however care must be taken to ensure the correct film build is applied.
Air Spray	<p>Conventional Air Spray, suction cup set-up gives greater control than that using pressure pot equipment.</p> <p>1.0mm to 1.4mm Fluid Tip with appropriate Air Cap.</p>
Airless Spray	Not recommended

CURING SCHEDULE

Surface Temp.	Dry to Handle	Dry to Touch	Dry to Recoat	Dry to Topcoat w/ Other Finishes
2°C (36°F)	45 Minutes	15 Minutes	4 Hours	12 Hours
15°C (59°F)	25 Minutes	10 Minutes	90 Minutes	6 Hours
24°C (75°F)	15 Minutes	5 Minutes	1 Hour	4 Hours
32°C (90°F)	10 Minutes	5 Minutes	45 Minutes	2 Hours

These times above are based on a 15-20 micron dry film thickness per coat at 50% relative humidity.

Recoat Maximum: Within 90 days (when not exposed to weathering).

APPROVALS

Approvals NZ/AU	Product Conformity Altra~Etch conforms to AS 3884 Type 1 and AS 3750.17 Type 1 "Single Pack Etch Primer"
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CLEANUP & SAFETY

Cleanup | Use Altex Thinning Solvent #155 or Thinner #76

Ventilation | It is very important for the safety of the applicator and the proper performance of the applied coating 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.

Caution | 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. This product 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.

PACKAGING, HANDLING & STORAGE

Packaging | • **AU:** 4 litre & 10 litre
• **NZ:** 1 litre & 4 litre

36 months at 24°C

Shelf Life | Shelf Life: (actual stated shelf life) when kept at recommended storage conditions and in original unopened containers. For products/components exceeding the stated shelf life, contact Technical Services for further advice.

Storage Temperature & Humidity | 0°-40°C
0-90%

Flash Point (Setaflash) | 12°C

Storage | Store indoors under cool (10°-24°C) dry conditions

WARRANTY

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