

### FEATURES

**Advantages:**

- Excellent anti-corrosive/protective primer for most substrates in industrial and marine exposures
- Excellent adhesion
- Suitable for use in below water systems
- Lead and chromate free
- Single package
- Easy application by brush, roller or spray

**Limitations of Use:**

- Not recommended for use on aluminium substrates
- Not recommended for immersion service on galvanised steel

### RECOMMENDED USES

**Multi~Bond Primer is a premium quality primer designed for general purpose use.**

**Multi~Bond Primer may be used:**

- Applied directly to suitably prepared steel, galvanised steel, wood and GRP
- Above water - overcoated with a sandable undercoat (Altex Undercoat) and normally topcoated with Isotal Enamel
- Below water - as part of a marine protective system where it is normally overcoated with AF 1000 or AF 3000 anti-fouling

**Multi~Bond Primer is NOT recommended:**

- For use on aluminium
- For immersion service on galvanised steel

### SPECIFICATION DATA

<b>Coating Type:</b>	Pigmented Blend of Proprietary Synthetic Water Resistant Resins
<b>Colour:</b>	Light Grey
<b>Packaging:</b>	1 and 4 litre Single component
<b>Gloss:</b>	Matt
<b>Flash Point:</b>	36°C Setaflash
<b>Thinner:</b>	T48 - Brush and Spray
<b>Storage:</b>	Store under cool, dry conditions

<b>Density:</b>	1.52 kg per litre
<b>VOC:</b>	435g per litre
<b>Volume Solids:</b>	48%
<b>Theoretical Coverage Rate:</b>	9.6 sq metres per litre at 50 microns DFT
<b>Recommended Film Thickness Per Coat:</b>	104 microns wet to obtain 50 microns dry
<b>Application:</b>	Spray, brush or roller
<b>Dry Times (25°C / 50µm DFT / 50% RH):</b>	
Touch Dry	- 1½ hours
To Recoat	- 4 hours
Hard Dry	- 24 hours
To Anti-Foul	- 24 hours

## SURFACE PREPARATION

All surfaces must be sound and free of oil, grease, dirt, chemicals, salt, loose and flaking paint, moisture and other foreign substances prior to application of Multi-Bond Primer.

### Steel Surfaces:

For the best results blast to a commercial blast, equivalent to Steel Structures Painting Council SP6. The steel profile after blasting should be 30 to 50 microns in depth and be of a jagged nature as opposed to a peen pattern.

For mild conditions power tool cleaning to SSPC SP3 or hand tool cleaning to SSPC SP2 may be satisfactory.

### Galvanised Surfaces

Recommended cleaning of surface is light abrasive blasting with fine, washed, non-metallic media to attain a uniform matt finish.

### GRP and Wooden Surfaces:

GRP and wood should be thoroughly sanded with 80-120 grit paper. Dry timber can be presealed with A.Y. & B 421 Epoxy Resin, thinned 25% with Altex 1/2 Thinner.

## DIRECTIONS FOR USE

### Mixing:

Use mechanical agitation for proper mixing to ensure homogeneous condition. Stir until thoroughly mixed..

### Thinning:

Multi-Bond Primer is generally applied unthinned. For spray application thin up to 10% with Altex T48 Thinner.

Note: Excessive thinning can cause low film thickness, sagging and other film defects.

### Application:

Multi-Bond Primer may be applied by brush, roller or spray.

When spray applied Multi-Bond Primer should be applied in one wet coat, overlapping each pass 50%.

Suggested spray equipment is:

Air Spray      *Graco* - Delta Air spray gun, 2.2mm (0.086") or 1.8mm (0.070") set up  
*De Vilbiss* - JGA gun, E Fluid Nozzle, 704 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.)

### Clean-up:

Use T48 thinner

## PRECAUTIONS

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

**Multi-Bond 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.

## ALTEX COATINGS LIMITED

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