

FEATURES

RECOMMENDED USES

Advantages:

- Exceptional corrosion resistance
- Easy to mix - zinc pre-mixed into base component
- Extremely high zinc loading - 90% by weight in dry film
- Provides excellent cathodic protection
- Excellent adhesion to commercial blast cleaned surfaces
- Excellent for repair of inorganic zinc-rich coatings
- Excellent for repair of deteriorated galvanised steel surfaces
- Formulated without lead, chromate or mercury components
- Conforms to AS/NZS 3750.9 standard
- As a brush applied maintenance primer is tolerant to traces of surface moisture

Performance Data:

- Adhesion (ASTM D4541) - Excellent
- Humidity Resistance (ASTM D2247) - Excellent
- Salt Spray Resistance (ASTM B117) - Excellent
- Conforms to composition and performance requirements of SSPS Paint Spec. 20, Type 2

Approvals:

APAS 2916 ID3278

Approved for use on Transpower New Zealand towers and equipment (Ref: Appendix III - Transpower Contract Documents, Issue 2, 20 February 1998) - Primer for System 2

Altra~Zinc 625[®] is a high performance, two component, organic zinc-rich primer specifically formulated to provide sacrificial protection to steel surfaces where surface preparation may be less than ideal. It may also be used for the repair of aged inorganic zinc-rich coatings or galvanised steel surfaces.

Altra~Zinc 625[®] may be used for the above in the following environments:

- Chemical Process Industry
- Refineries
- Fertiliser Plants
- Pulp and Paper Mills
- Sewage or Waste Water Treatment Plants
- Bridges and Steel Fabrications
- Off-shore structures
- As a holding / weld-through primer at DFT less than 25 microns

Limitations of Use:

- Do not topcoat with alkyd coatings
- Not suitable for solvent, chemical or fresh water immersion service

SPECIFICATION DATA

Coating Type:	Zinc Rich Polyamide Epoxy
Colour:	Grey
Packaging:	5 litre Two component kit
Mix Ratio:	4 to 1 by volume
Gloss:	Flat
Flash Point:	21°C Setaflash
Thinner:	1/2 Thinner
Pot Life:	12 hours at 25°C
Induction Time:	30 minutes
Storage:	Store under cool, dry conditions

Density:	3.0 kg per mixed litre
VOC (EPA 24):	382 grams per litre
Temperature Resistance:	121°C Dry
Volume Solids (Mixed):	58%
Theoretical Coverage Rate:	7.7 sq metres per litre at 75 microns dry
Recommended Film Thickness Per Coat:	86-172 microns wet to obtain 50-100 microns dry
Application:	Spray or brush
Dry Times (25°C / 75 µm DFT / 50% RH):	
	Dry to Recoat 12 Hrs
	Dry to Handle 8 Hrs

SURFACE PREPARATION

All surfaces must be dry, clean, free of oil, grease, dirt loose and flaking paint and other foreign substances. Round off welds and sharp edges and remove weld splatter.

New Steel Surfaces:

Abrasive blast to a minimum of SSPC SP6 or SIS Sa 2. A cleaner surface (ie SSPC SP10/SIS Sa 2.5) will improve primer and system performance. 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. After blasting, vacuum or blow off all grit and dust and ensure the surface remains clean before painting.

Previously Painted Surfaces:

Remove old paint to bare metal. Prepare surface as for new steel. Achieve a minimum of SSPC SP6 (SIS Sa 2) on rough or pitted steel.

Weathered zinc-rich surfaces or galvanised steel should be thoroughly wire brushed to remove all products of corrosion or oxidation prior to painting.

DIRECTIONS FOR USE

Mixing:

Altra-Zinc 625[®] is a two component product supplied in 5 litre kits which contain the correct ratio of ingredients. The entire contents of each container must be mixed together.

The zinc metal is ready mixed in the base portion. Power 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 to a homogeneous condition. Strain through a 30 to 60 mesh sieve prior to use. Keep agitated whilst in use.

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.

Continuous agitation of the mixed product is recommended.

Thinning:

Thinning in the range of 5% to 15% addition of Altex 1/2 Thinner may be expected, depending upon conditions. When applying as a holding / weld-through primer at DFT's of 20-25 microns it is recommended to thin the mixed material up to 30% by volume with Thinner 1/2 for optimum film thickness control; at high thinning levels an agitated pot is recommended.

Application:

Suggested spray equipment is:

Air Spray *Graco* - Delta Air spray gun, 2.8mm (0.110") set up
De Vilbiss - JGA gun, E or D Fluid Nozzle, 704/64 Air Nozzle

Airless Spray *Graco* - 30:1 pump, Contractor gun, 0.021-0.025" RAC IV tip

Ideally fluid hoses should be not less than 10mm ID and not longer than 15 metres to obtain the optimum results. Fluid pressure should be kept low, ~15 psi, with just enough air pressure to get a good break-up of the coating. Excessive air pressure can cause overspray problems.

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

Clean-up:

Use 1/2 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.

Altra-Zinc 625[®] 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

Head Office New Zealand		Head Office Australia		DISCLAIMER
91-111 Oropi Road Greerton, Tauranga PO Box 142 Tauranga Mail Centre		7 Production Avenue Ernest Junction Queensland 4214 Australia		This is not a specification and all of the information is given in good faith. Since conditions of use are beyond the control of the manufacturer, information contained herein is without warranty, implied or otherwise, and final determination of the suitability of any information or material for the use contemplated, the manner of use and whether there is any infringement of patents is the sole responsibility of the user. The manufacturer does not assume any liability in connection with the use of the product relative to coverage, performance or injury. For application in special conditions, consult the manufacturer for detailed recommendations.
Phone: +64 7 5411 221 Fax: +64 7 5411 310		Phone: +61 7 5594 9522 Fax: +61 7 5594 9093		
www.altexcoatings.co.nz		www.altexcoatings.com.au		