

FEATURES

Advantages:

- Premium performance primer for Marine and Industrial systems, including immersion service
- Resists topcoat pinholing
- Resistant to dry spray, mudcracking and topcoat bubbling
- Easy to mix - zinc pre-mixed into base component
- Easy application by brush, roller or spray
- Fast Dry-to-Recoat
- Good low temperature cure
- Good solvent resistance
- Safe - contains no lead or chromate pigments
- Versatile - can be used as the primer under all E-Line[®], Altra~Shield[®], Altra~Build[®] systems and Chem~Bar 900[™]

Performance Data (as part of a system):

- Salt Spray Resistance (Cyclic Prohesion Testing) 2500 hours - Excellent
- Immersion Resistance (5% Salt Solution) 2500 hours - Excellent

Approvals:

Conforms to the composition and performance requirements of SSPC Paint Specification 29; Level 2

RECOMMENDED USES

Altra~Zinc 605[®] is a high performance, two component, reinforced inorganic zinc-rich primer designed for use as a cathodic primer for protecting steel exposed to a variety of environments including the following:

- Bridges and Steel Fabrications
- Steel ship hulls - all areas
- Pulp and Paper Mills
- Refineries
- Sewage or Waste Water Treatment Plants
- Chemical Process Industry
- Fertiliser Plants
- Mining Structures
- Bulk Storage Tanks

Limitations of Use:

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

SPECIFICATION DATA

Coating Type:	Reinforced Inorganic Zinc Silicate
Colour:	Green
Packaging:	1.25, 5 and 10 litre Two component kits
Mix Ratio:	4 to 1 by volume
Gloss:	Flat
Flash Point:	14°C
Thinner:	1/2 Thinner
Pot Life:	8 hours at 25°C
Induction Time:	15 minutes
Storage:	Store under cool, dry conditions

Density:	2.15 kg per litre		
VOC:	415 grams per mixed litre		
Temperature Resistance:	Max. 200°C Dry, intermittent		
Theoretical Volume Solids (Mixed):	64% Wet/Dry Method		
Theoretical Coverage Rate:	8.5 sq metres per litre at 75 microns dry		
Recommended Film Thickness Per Coat:	50-100 microns dry		
Application:	Spray, brush or roller		
Dry Times (75 µm DFT / 50% RH):			
	5°C 15°C 25°C		
Touch Dry	2 Hrs 1 Hr ¾ Hr		
Hard Dry	4.5 Hrs 1.5 Hrs 1 Hr		
Minimum Recoat	2.5 Hrs 1.5 Hrs 1 Hr		
Maximum Recoat	<i>Dependant on topcoat to be used. Refer specification data.</i>		

SURFACE PREPARATION

All surfaces must be free of oil, grease and moisture. Round off welds and sharp edges and remove weld splatter.

New Steel Surfaces:

Abrasive blast to a minimum of SSPC SP6 or Swedish Standard Sa 2. A cleaner surface (ie SSPC SP10/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 (Swedish Standard Sa 2) on rough or pitted steel.

DIRECTIONS FOR USE

Mixing:

Altra-Zinc 605[®] Primer is a two component product supplied in 1.25, 5 and 10 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. 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. Allow a 15 minute induction time before using.

The pot life of the mixed material is 8 hours at 25°C. Higher temperatures will reduce the working life of the coating; lower temperatures will increase it.

Thinning:

Thinning in the range of 5% to 10% with Altex Thinner 1/2 may be required for optimum atomisation and wet film flow out. At higher temperatures increased thinning may be desirable for improved surface wetting and flow out.

Application:

Altra-Zinc 605[®] Primer can be applied by spray, brush or roller. Spray application by either airless or conventional air spray equipment is the preferred method of application. Apply Altra-Zinc 605[®] Primer by brush and roller primarily for touch-up and repair to small areas.

Suggested conventional spray equipment is:

Graco - Delta Air spray gun, 2.8mm (0.110") set up

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

Care should be taken to ensure that the correct film thickness is applied. Inorganic zinc coatings hide at very low film builds. Rough or pitted steel requires higher dry film thickness for optimum protection.

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 605 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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