

FEATURES

Advantages:

- Excellent surfacing and sanding properties
- Rapid cure to sanding time
- Free sanding properties with easy de-dusting – does not clog production sandpaper's
- Long pot life
- Isocyanate free
- Compatible with acrylic and polyester urethane topcoats
- May be used in immersion service as part of an Altex recommended system
- Formulated without lead, chromate or mercury containing materials

Limitations of Use:

- May change colour and chalk when exposed to direct sunlight. This does not affect the protective properties of the coating.
- If recoating outside the recommended schedule, sand the cured coating and re-apply a thin (50µm) coat of Altra~Build 520® before proceeding as per the schedule.
- DO NOT sand with Stearate coated sandpaper

RECOMMENDED USES

Altra~Build® 520 is a high performance, sandable epoxy coating which is both corrosion and water-resistant.

It is an excellent build coat and when top coated with E-Line® finishes and can be used in most industrial and marine situations.

Altra~Build® 520 is recommended for:

- Use on all suitably primed surfaces
- Direct application to sanded GRP, epoxy laminated wood and epoxy sealed wood
- Use as a high performance primer undercoat for fibreboard joinery and laboratory bench tops

SPECIFICATION DATA

Coating Type:	Specialised Rapid Cure Epoxy
Colour:	Off White
Packaging:	1 litre, 5 litre and 20 litre
Mix Ratio:	4:1 by volume
Gloss:	Semi gloss
Flash Point:	38 °C Setaflash
Thinner:	½ Thinner
Pot Life:	6 hours at 25 °C
Induction Time:	15 minutes
Shelf Life:	Store under cool dry conditions

Density:	1.51 kg per litre
VOC:	423 g per litre
Temperature Resistance:	121 °C dry
Volume solids (mixed):	49 %

Theoretical Coverage Rate:

6.5 sq. metres per litre at 75 microns dry

Recommended Film Thickness Per Coat:

103-206 microns wet to obtain 50-100 microns dry

Application: Spray, brush or roller

Dry Times (75µm DFT / 50% RH):

Recoat – minimum:	5 °C	15 °C	25°C	30°C
Self	24 hrs	12 hrs	8 hrs	6 hrs
Epoxy	24 hrs	12 hrs	8 hrs	6 hrs
Urethane	24 hrs	12 hrs	8 hrs	6 hrs
Recoat – maximum:	5 °C	15 °C	25°C	30°C
Self	336 hrs	336 hrs	336 hrs	140 hrs
Epoxy	336 hrs	336 hrs	336 hrs	140 hrs
Urethane	48 hrs	48 hrs	24 hrs	16 hrs

SURFACE PREPARATION

All surfaces to be coated should be clean, dry and free from contamination. Oil or grease should be removed in accordance with AS1627.1 solvent cleaning. Surface defects revealed by the preparation process, should be ground, filled, or treated in the appropriate manner. Clean to remove all grit dust and debris and ensure the surface is dry.

Suitable Primers:

Altra~Build[®] 520 is designed to be applied to suitably prepared surfaces primed with one of the following compatible primers.

Mild Steel:

Altra~Build[®], Altra~Etch[®], Altra~Prime[®], Altra~Shield[®], Altra~Zinc[®] coatings

May also be applied DTM to Class 2 abrasive blast for mild to moderate exposures.

Aluminium and Galvanising:

Altra~Bond[®], Altra~Etch[®], Altra~Prime[®] and Altra~Shield[®] coatings

Timber:

Altra~Build[®], Altra~Prime[®], Altra~Shield[®], Everseal, Altra~Lock

GRP/ Epoxy Laminate:

Altra~Build[®], Altra~Prime[®], Altra~Shield[®].

Concrete:

Altra~Lock[®] 577, Altra~Build[®], Altra~Etch[®], Altra~Prime[®], Altra~Shield[®]

Suitable Topcoats:

Altra~Build[®] 520 is designed to be top coated with E-Line[®] finishes.

All surfaces to be coated must be free of oil, grease and moisture and other foreign matter and be adequately primed and undercoated.

DIRECTIONS FOR USE

Mixing:

Altra~Build[®] 520 is a two component product supplied in 1 litre, 5 litre and 20 litre kits which contain the correct ratio of ingredients.

Power mix the base portion first to obtain a smooth homogeneous condition. After mixing the base portion, slowly add the converter whilst continuing to agitate at slow speed. After addition of the converter is complete, continue to mix slowly until homogeneous.

Higher temperatures will reduce the working life of the coating; lower temperatures will increase it.

Thinning:

Thinning maybe required to assist application. Any solvent addition should be made after the two components are thoroughly mixed. Excessive thinning can cause low film thickness and coating defects.

Clean-up:

Use ½ thinner

Application:

Altra~Build[®] 520 can be applied by spray, brush or roller.

Application by either airless or conventional air spray equipment is the preferred method.

Suggested spray equipment is:

Air Spray	Graco- Delta Air spray gun, 2.8mm 0.110")or 2mm (0.086") set up DeVilbiss JGA Gun, E Fluid Nozzle, 78 Air Nozzle
Airless Spray	Graco 30:1 pump, Contractor Gun, 0.019-0.023" RAC IV tip

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

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~Build[®] 520 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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