

FEATURES

Advantages:

- Excellent adhesion to all common metals
- Versatile, convenient, stable, single pack primer
- Fast drying
- Good abrasion resistance
- Compatible with a wide variety of topcoats

Limitations of Use:

- Altra~Etch[®] is not designed to give long term exterior protection without over coating.

Approvals:

- AS3884 Type 1
- AS3750.17 Type 1.

RECOMMENDED USES

Altra~Etch[®] is a single pack etch primer and may be over coated with most finish topcoats including enamel, chlorinated rubber, epoxy, vinyl acrylic and polyurethane.

Altra~Etch[®] is recommended:

- As a high performance key coating
- As a conventional etch over surfaces including Galvanised steel, Zinc sheet, Aluminium sheet/ extrusions, Mild steel, Zinc or Aluminium wire spray

SPECIFICATION DATA

Coating Type:	Single Pack Modified Epoxy Etch
Colour:	White, Grey, Black
Packaging:	1 litre, 4 litre and 20 litre
Mix Ratio:	n/a
Gloss	Satin
Flash Point:	12 °C Setaflash
Thinner:	Altex Multi Purpose Thinner
Pot Life:	n/a
Induction Time:	n/a
Shelf Life:	Store under cool dry conditions

Density: 0.97 kg per litre

VOC:

Temperature Resistance:

Volume solids: 10 % (+ or - 1 %)

Theoretical Coverage Rate:

5.0 sq. metres per litre at 20 microns dry

Recommended Film Thickness Per Coat:

150-200 microns wet to obtain 15-20 microns dry

Application: Spray, Brush or Roller

Dry Times (15µm DFT / 50% RH):

Touch dry: 5 minutes

To handle: 15 minutes

Recoat – minimum:	5°C	10°C	25°C	30°C
Single pack	8 hrs	4 hrs	2 hrs	2 hrs
Epoxy	8 hrs	4 hrs	4 hrs	4 hrs
Urethane	8 hrs	4 hrs	4 hrs	4 hrs
Recoat – maximum:	5°C	10°C	25°C	30°C
Single pack	n/a	n/a	n/a	n/a
Epoxy	n/a	n/a	n/a	n/a
Urethane	720 hrs	720 hrs	720 hrs	720 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.

Steel Surfaces:

Abrasive blast to AS1627.4 Class 2 ½ to achieve a uniform blast profile between 38 to 63 microns and a jagged nature as opposed to a peen pattern. A lesser degree of cleaning will reduce the service life of the coating.

Galvanised Steel and Electrodepositing Zinc Surfaces:

All traces of dichromate passivation must be removed. Sweep abrasive blast with non-metallic media or thoroughly sand with synthetic scouring pad to provide a uniform matt finish.

GRP and Wooden Surfaces:

Thoroughly sand with non-stearate paper with 80-120 grit

Concrete surfaces:

Concrete must cure for at least 28 days and not be greater than 10 pH. Acid etch with dilute hydrochloric acid solution (1 part concentrated acid to 10 parts water) to produce a uniformly roughened surface profile, followed by washing off with copious amounts of clean fresh water until the cleaning water is neutral to litmus paper. DO NOT allow etch solution to dry on the surface. Check for excessive moisture using the ASTM D-4263 "Plastic Sheet Method" test. Grinding or sweep blasted to remove all laitence may also be carried out.

Previously Painted Surfaces:

Clean with Altex P40 Cleaner. Remove loose and peeling paint. Prepare all corroded and damaged paint areas in accordance with the preparation required for the applicable primer. Feather back edges to a sound clean existing coating. Abrade all existing coating to provide a fine matt finish. Clean to remove all grit dust and debris and ensure the surface is dry.

DIRECTIONS FOR USE

Mixing:

The entire contents of the container must be thoroughly mixed with mechanical agitation to a homogeneous condition prior to application.

Thinning:

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

Clean-up:

Use Multi Purpose Thinner.

Application:

The preferred method of application for Altra~Etch® is spray. Small areas may be brush or rolled if conditions are suitable, however care must be taken to ensure that the correct film thickness is obtained.

Ventilation:

It is very important for the safety of the applicator and the proper performance of Altra~Etch® 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.

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~Etch® 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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