

FEATURES

RECOMMENDED USES

Advantages:

- Tough High Build Epoxy
- Excellent Resistance Properties
- Fresh and salt water
- Alkalis and salts
- Spillage of solvents and dilute acids

Versatile

- Can be a finish coating
- Can be top-coated with epoxy or urethane finish coats
- Non-Skid version available
- Good Cure and Application Properties

Altra~Shield 2024 is specially formulated as a tough high build epoxy coating for use on structures and fittings in the following environments:

- Industrial
- Pulp and Paper Plants
- Sewerage and Waste Plants Refineries
- Chemical Process Plants

Floors and Decks

- Excellent for use on concrete floors and walls in heavy service areas such as food processing factories and workshops

Offshore Structures

- General marine use above water

Data sheet

SPECIFICATION DATA

Coating Type:	Polyamide Epoxy
Colour:	White and Pastels
Packaging:	8 litre and 20 litre
Mix Ratio:	1:1 by volume
Gloss:	Semi gloss
Flash Point:	27 °C Setaflash
Thinner:	½ Thinner
Pot Life:	8 hours at 25 °C
Induction Time:	30 minutes at 25 °C
Shelf Life:	More than 2 years

Density:	1.33 kg per litre
VOC:	
Temperature Resistance:	121 °C dry
Volume solids (mixed):	60 %
Theoretical Coverage Rate:	6.0 sq. metres per litre at 100 microns dry
Recommended Film Thickness Per Coat:	166-250 microns wet to obtain 100-150 microns dry
Application:	Spray

Dry Times (100µm DFT / 50% RH):					
Recoat – minimum:	5°C	15°C	25°C	30°C	
Self	12 hrs	8 hrs	4 hrs	3 hrs	
Epoxy	12 hrs	8 hrs	4 hrs	3 hrs	
Urethane	24 hrs	12 hrs	5 hrs	4 hrs	
Recoat – maximum:	5°C	15°C	25°C	30°C	
Self	720 hrs	720 hrs	720 hrs	360 hrs	
Epoxy	720 hrs	720 hrs	720 hrs	360 hrs	
Urethane	120 hrs	120 hrs	96 hrs	48 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 3 for immersion service and for non-immersion to AS1627.4 Class 2 ½ to achieve a uniform blast profile between 38 to 63 microns and be of a jagged nature as opposed to a peen pattern. A lesser degree of cleaning will reduce the service life of the coating. Apply primer coat to the cleaned surface to prevent re-rusting or contamination.

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 roughened finish.

GRP and Wooden Surfaces:

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

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 laitance may also be carried out.

Previously Painted Surfaces:

Clean with Altex P40 Cleaner. Remove all unsound coatings. 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. Matt all existing coating to provide a fine matt finish. Clean to remove all grit dust and debris and ensure the surface is dry. Apply a test patch to confirm compatibility with existing coating system. If lifting occurs remove to bare substrate.

DIRECTIONS FOR USE

Mixing:

Altra~Shield 2024 is a two component product supplied in 8 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:

Application by either conventional air spray or airless spray equipment is the preferred method. For touch-up and repair to small areas, Altra~Shield 2024 can be applied by brush and roller.

Suggested spray equipment is:

Air Spray:	Binks - type 2001 gun, 66SS Fluid Nozzle, 63P8 Air Nozzle DeVilbiss - JGA Gun, D Fluid Nozzle 64 Air Nozzle
Airless Spray:	Binks - 88-36 pump, Airless 1 0.021-0.027" tip Graco - 45:1 pump, Contractor Gun, 0.021-0.027" 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~Shield 2024 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.

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