

FEATURES

Advantages:

- Resists top coat pinholing
- Easy application by brush, roller or spray
- Easy to mix - zinc pre-mixed into base component
- Resistant to dry spray, mudcracking and topcoat bubbling
- Good low temperature cure
- Fast Dry-to-Topcoat
- 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

Limitations of Use:

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

Performance Data (as part of a system):

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

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

SPECIFICATION DATA

Coating Type:	Reinforced Inorganic Zinc Silicate
Colour:	Grey
Packaging:	5 litre and 10 litre
Mix Ratio:	4:1 by volume
Gloss:	Flat
Flash Point:	14 °C Setaflash
Thinner:	½ Thinner
Pot Life:	8 hours at 25 °C
Induction Time:	15 minutes
Shelf Life:	Store under cool dry conditions

Density:	2.15 kg per litre
VOC:	415 g per mixed litre
Temperature Resistance:	200 °C dry intermittent
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:

117 microns wet to obtain 75 microns dry

Application: Spray, Brush or Roller

Dry Times (75µm DFT / 50% RH):

Recoat – minimum:	5°C	10°C	25°C	30°C
Self	2 hrs	1 hr	1 hr	1 hr
Epoxy	4 hrs	2 hrs	1 hr	1 hr
Urethane	12 hrs	6 hrs	4 hrs	4 hrs
Recoat – maximum:	5°C	10°C	25°C	30°C
Self	1440 hrs	1440 hrs	1440 hrs	1440 hrs
Epoxy	1440 hrs	1440 hrs	1440 hrs	1440 hrs
Urethane	96 hrs	96 hrs	96 hrs	72 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 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.

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-Zinc® 605 is a two component product supplied in 5 and 10 litre kits, which contain the correct ratio of ingredients. The entire contents of each container must be mixed together. 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-Zinc® 605 can be applied by brush and roller.

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

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 thicknesses for optimum protection.

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 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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