

FEATURES

- Fast dry allows rapid handling of coated steel
- Modified zinc phosphate anti-corrosive pigmentation
- Free of chromates and other heavy metal compounds
- Suitable for acrylic and alkyd topcoats
- Available in Red Oxide or Grey

RECOMMENDED USES

Pre~Fab Steel Shop Primer is a fast dry, economical, primer designed for use in engineering fabrication shops.

Pre~Fab Steel Shop Primer is suitable as a stand-alone coating in mild interior environments and provides good protection to structural steel in moderate exterior environments when topcoated with compatible alkyd or acrylic coatings.

Data Sheet

SPECIFICATION DATA

Coating Type:	QD Alkyd Zinc Phosphate
Colour:	Red Oxide & Grey
Packaging:	1 litre, 4 litre & 20 litre Single Package
Mix Ratio:	N/A - Single Package
Gloss:	Flat
Flash Point:	15°C
Thinner:	Spray S53 Brush Carboline Thinner No.10 or X-100
Storage:	Store under cool, dry conditions

Density:	Red 1.29 kg/litre Grey 1.27 kg/litre
VOC:	479 gm/litre (Red & Grey)
Temperature Resistance:	100°C Dry
Volume Solids:	43% (Red & Grey)
Theoretical Coverage Rate:	11.3 square metres per litre at 38 microns dry
Recommended Film Thickness Per Coat:	98-140 microns wet to obtain 38-60 microns dry
Application:	Spray, brush
Dry Times (38 µm DFT / 50% R.H. / 25°C):	
Tack Free	15 - 30 minutes
Through Dry	16 hours
Recoat:	
Acrylic	18 hours
Alkyd	36 hours

SURFACE PREPARATION

All surfaces must be sound and free of oil, grease, dirt, form release agents, curing compounds, loose and flaking paint, moisture and other foreign substances

Steel Surfaces:

For the best results abrasive blast to SSPC SP6 (Sa2). For mild conditions hand or power tool cleaning to SSPC SP2 or 3 may be satisfactory.

DIRECTIONS FOR USE

Mixing:

Use mechanical agitation for proper mixing to ensure homogeneous condition. Stir until thoroughly mixed.

Thinning:

For spray application thin up to 10% with Altex S53 Thinner. For Brush application thin up to 10% with Carboline Thinner No.10 or Altex X-100 Thinner if necessary.

Note: Excessive thinning can cause low film thickness, sagging and other film defects.

Application:

Pre-Fab Steel Shop Primer may be applied by brush or spray.

For spray Pre-Fab Steel Shop Primer should be applied in one wet coat, overlapping each pass 50%.

Suggested spray equipment is:

Air Spray *Graco* - Delta Air spray gun, 2.2mm (0.086") or 1.8mm (0.070") set up
De Vilbiss - JGA gun, E Fluid Nozzle, 704/765 Air Nozzle

Airless Spray *Graco* - 30:1 pump, Contractor gun, 0.015-0.017" RAC IV tip

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

Clean-up:

Use Carboline Thinner No.10, X-100 thinner or Cleaning Solvent.

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.

Pre-Fab Steel Shop 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

Head Office New Zealand	Head Office Australia	DISCLAIMER
91-111 Oropi Road Greerton, Tauranga PO Box 142 Tauranga Mail Centre Phone: +64 7 5411 221 Fax: +64 7 5411 310 www.altexcoatings.co.nz	7 Production Avenue Molendinar Queensland 4214 Australia Phone: +61 7 5594 9522 Fax: +61 7 5594 9093 www.altexcoatings.com.au	This is not a specification and all of the information is given in good faith. Since conditions of use are beyond the control of the manufacturer, information contained herein is without warranty, implied or otherwise., and final determination of the suitability of any information or material for the use contemplated, the manner of use and whether there is any infringement of patents is the sole responsibility of the user. The manufacturer does not assume any liability in connection with the use of the product relative to coverage, performance or injury. For application in special conditions, consult the manufacturer for detailed recommendations.