

**FEATURES**

**Advantages:**

- Chrome & Lead Free Modified Epoxy Polyamide Anti-Corrosive Primer
- Performance superior to MIL-P-53022B Molybdate-modified Zinc Phosphate primer types
- Extensively tested against prevailing performance standards for aluminium primers
- Exceeds the performance requirements of MIL P – 23377 (strontium chromate type) as follows:-
  - Filiform Corrosion Resistance (ASTM D 2803)
    - Required Result 1000 hours; Pass
    - Tested Result 2000 hours, Pass
  - Corrosion Resistance (Salt Spray – B117)
    - Required Result 1000 hours; Pass
    - Tested Result 3000 hours; Pass
- Rapid Dry-to-Recoat
- Easy to use - 1:1:1 (base : converter : thinner) mix ratio
- Excellent adhesion to aluminium alloys and galvanising
- Excellent resistance to filiform corrosion on aluminium surfaces
- Cures well at low temperatures
- Can be used as a primer under all E~Line® Altra~Shield®, Altra~Build® and Chem~Bar™ systems

**RECOMMENDED USES**

**Altra~Bond® 3094-CF is a two component epoxy primer utilising state of the art chrome & lead free anti-corrosive technology designed for use on aluminium structures, plate and extrusions and galvanised substrates.**

- Excellent adhesion and anti-corrosive properties
- Fast dry to recoat
- Compatibility with high performance epoxy and urethane systems

**Altra~Bond® 3094-CF is ideal as**

- A primer for aluminium and aluminium alloys in all atmospheric exposures:-
  - A primer for aluminium architecture
  - Marine topsides
  - Aluminium road and rail hoppers / tanker externals
  - A primer for signwriting on alloy surfaces

**Altra~Bond® 3094-CF may also be used as**

- An excellent general purpose aviation primer

**Limitations of Use:**

- Do not overbuild
- Do not exceed recoat window
- Do not sand

**SPECIFICATION DATA**

<b>Coating Type:</b>	Modified Polyamide Epoxy Cr+Pb Free A/C Pigment
<b>Colour:</b>	Translucent Blue
<b>Packaging:</b>	2 and 8 litre Two component kits
<b>Mix Ratio:</b>	1 to 1 by volume
<b>Gloss:</b>	Low Sheen
<b>Flash Point:</b>	12°C Setaflash
<b>Thinner:</b>	1/2 Thinner
<b>Pot Life:</b>	12 hours at 25°C
<b>Induction Time:</b>	Not required
<b>Storage:</b>	Store under cool, dry conditions

<b>Density:</b>	1.05 kg per litre / mixed
<b>VOC:</b>	585 grams per mixed litre
<b>Temperature Resistance:</b>	80°C Dry
<b>Volume Solids (Mixed):</b>	30±1%
<b>Theoretical Coverage Rate:</b>	15 sq metres per litre at 20 microns dry
<b>Recommended Film Thickness per Coat (mixed and thinned at recommended 1:1:1 ratio):</b>	100 microns wet to obtain 20 microns dry
<b>Application:</b>	Conventional or Airless Spray
<b>Dry Times (25°C / 20 µm DFT / 50% RH):</b>	
Touch Dry	10-20 minutes
Optimum Recoat	3 hours
Maximum Recoat	24 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 prior to application of Altra~Bond® 3094-CF.

### Aluminium and Galvanised Surfaces:

For fairing systems or heavy duty exposures the recommended cleaning method is light abrasive blasting with fine, washed, non-metallic media to attain a uniform matt finish.

For light duty work Altra~Bond® 3094-CF provides good adhesion to degreased and Scotchbrite® abraded surfaces. Do not apply over dichromate passivated galvanising.

Scotchbrite® is a registered trademark of 3M Company.

## DIRECTIONS FOR USE

### Mixing:

Altra~Bond® 3094-CF is a two component product supplied in 2 and 8 litre kits which contain the correct ratio of ingredients. The entire contents of each container must be mixed together.

Stir the base portion first to obtain a smooth, homogeneous condition using a power stirrer. After mixing the base portion add the converter slowly with continued stirring. After mixing is completed, proceed to Thinning as directed below.

The pot life of the mixed material is 12 hours at 25°C. Higher temperatures will reduce the working life of the coating; lower temperatures will increase it.

### Thinning:

Thinning is required for optimum film thickness control. Thin 50% by volume with Altex 1/2 Thinner, ie 1:1:1 (Base:Converter:Thinner).

### Application:

Altra~Bond® 3094-CF is best applied by conventional spray. Altra~Bond® 3094-CF may also be applied to small areas by brush and roller.

Do not overbuild this product! The correct film thickness is achieved when the surface first just attains a semi-transparent light-blue colour.

### Equipment:

Suggested spray equipment is:

Air spray                      Graco - Delta Air spray gun, 1.1-1.8mm (0.040-0.070") set up  
   De Vilbiss - JGA gun, E Fluid Nozzle, 704 Air Nozzle

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

### Clean-up:

Use 1/2 Thinner.

## 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~Bond® 3094-CF** 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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