

### FEATURES

#### Advantages:

- Modified Epoxy Polyamide Primer - meets US Military specification MIL P - 23377D
- 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 the primer under all E~Line<sup>®</sup>, Altra~Shield<sup>®</sup>, Altra~Build<sup>®</sup> and Chem~Bar<sup>™</sup> systems

#### Limitations of Use:

- Do not overbuild
- Do not exceed recoat window
- Do not sand
- Do not exceed 25 microns dry film build

### RECOMMENDED USES

**Altra~Bond 3094<sup>®</sup> is a two component epoxy primer designed for use on aluminium sheets and extrusions and galvanised substrates. It has**

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

**Altra~Bond 3094<sup>®</sup> is ideal as**

- A primer for aluminium topsides, alloy hulls and a general primer for trailed alloy boats
- A primer for the exterior of petrol and bulk “dolphin” tanks
- A primer for signwriting on alloy surfaces

**Altra~Bond 3094<sup>®</sup> is also**

- An excellent general purpose aviation primer

### SPECIFICATION DATA

<b>Coating Type:</b>	Modified Polyamide Epoxy
<b>Colour:</b>	Yellow
<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>	27°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>	1.105 kg per litre
<b>VOC:</b>	585 grams per mixed litre
<b>Temperature Resistance:</b>	80°C Dry
<b>Volume Solids (Mixed):</b>	30%
<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®.

### Aluminium and Galvanised Surfaces:

Recommended cleaning of surface is light abrasive blasting with fine, washed, non-metallic media to attain a uniform matt finish.

Altra~Bond 3094® provides good adhesion to degreased and Scotchbrite® abraded surfaces. Do not apply over dichromate passivated galvanising.

Scotchbrite® is a registered trademark of 3M New Zealand Limited

## DIRECTIONS FOR USE

### Mixing:

Altra~Bond 3094® 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. Thin 50% by volume with Altex 1/2 Thinner, ie 1:1:1 (Base:Converter:Thinner).

### Application:

Altra~Bond 3094® can be applied by conventional or airless spray. Altra~Bond 3094® may also be applied to small areas by brush and roller.

Suggested spray equipment is:

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

Airless spray        *Graco* - 30:1 pump, Contractor gun, 0.015-0.021" RAC IV tip

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

The correct film thickness is achieved when the surface first just attains a yellow colour.

### 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®** 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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Phone: +64 7 5411 221 Fax: +64 7 5411 310	Phone: +61 7 5594 9522 Fax: +61 7 5594 9093	
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