

FEATURES

Altra~Build 536 is an upgraded high build epoxy coating for use in many applications in Industrial, Marine & Offshore exposure.

Advantages:

- Improved flexibility – resists chipping and aged embrittlement
- Lighter weight – 13% lighter
- Versatile surface tolerant coating
- Lower viscosity allows application at higher solids (less thinning) and reduced VOC at application
- Improved thermal qualities by syntactic modification; excellent for use under insulation to 120°C
- Good adhesion to tight rust - especially when used in conjunction with Rustbond[®] or Altra~Lock 577[®]
- Tolerant to surface dampness - particularly when brush applied
- Self-priming (DTM) for many applications
- Fast dry to recoat
- Improved dry to handling
- Suitable for fresh and salt water immersion
- Low temperature cure to below freezing; -5°C
- Reduced HAPS and Low VOC

Performance Data:

- Adhesion - Excellent
- Abrasion Resistance - Excellent
- Humidity Resistance - Excellent
- Salt Spray Resistance (Q-Fog Prohesion) - Excellent
- Water Immersion - Excellent
- Chemical Resistance - Excellent

* **NOTE: Altra~Build 536[®]** "Improved Formula" is an evolutionary development extensively tested and confirmed to improve certain application and exposure performance characteristics.

RECOMMENDED USES

Altra~Build 536 is a high performance upgrade to standard Altra~Build 536[®] designed for general use in the Industrial & Marine industries.

Altra~Build 536[®] is designed for:

- **Marine Service & Offshore**
 - Above and below water hulls, decks and super-structures, internal tanks, voids and wet spaces
 - DTM high build under Sea~Barrier[™] antifoulings
 - Ballast tanks, water tanks and any other water containment structures
 - Cargo, chemical, fuel and solvent tanks – ongoing testing in progress; refer to Altex Technical Service.
 - Black and grey water tanks
- **Industrial Structural Steel, Tankage & Equipment**
 - Pulp & paper mills
 - Petrochemical plants
 - Chemical plants
 - Fertiliser plants
 - Sewage Treatment plants
 - Potable water (when fully cured)

Altra~Build 536[®] may be applied over:

- Carbozinc[®] 859 EZ2
- Carbozinc[®] 858
- Carboguard[®] 504
- Direct to steel prepared to SP3 or better
- Over porous or rusty surfaces correctly sealed and strengthened with Altra~Lock 577

Limitations of Use:

Exterior exposure will cause early loss of sheen and chalking. This will not affect the protective properties of the coating.

SPECIFICATION DATA

Coating Type:	Proprietary Flexibilised Phenalkamine Epoxy
Colours:	Haze Grey, Off-White, MIO, Aluminium & Golden Yellow LF
Packaging:	5 litre and 10 litre Two component kits
Mix Ratio:	4 to 1 by volume
Gloss:	Low Sheen
Flash Point:	38°C Setaflash
Thinner:	Altex 1/2 Thinner
Pot Life:	4 hours at 25°C
Induction Time:	15 minutes
Shelf Life:	Minimum two years from date of manufacture
Storage:	Store under cool, dry conditions

Density:	1.3 kg per mixed litre (Haze Grey)		
VOC:	213 grams per litre		
Temperature Resistance:	121°C Dry,		
Volume Solids (Mixed):	80% (ASTM D2697 - 7 Days)		
Theoretical Coverage Rate:	5.3 sq metres per litre at 150 microns dry		
Recommended Film Thickness Per Coat:	187-250 microns wet to obtain 150-200 microns dry		
Application:	Airless Spray Preferred		
Dry Times (150 µm DFT / 50% RH):			
	<u>5°C</u>	<u>15°C</u>	<u>25°C</u>
Dry to Recoat	9 Hrs	5 Hr	3 Hrs
Hard Dry	17 Hrs	9 Hrs	6 Hr

Note: Ventilation, film thickness, humidity and other factors can influence the rate of drying.

SURFACE PREPARATION

All surfaces must be sound, dry, clean and free of oil, grease, dirt, and other foreign substances. Remove all loose paint, mill scale and rust prior to application of Altra~Build 536®.

Steel:

For optimum performance, abrasive blast to AS 1627.4 Class 2 (SSPC SP6) or better and prime with Carbozinc® 859 EZ2 or Carboguard® 504 (Carboguard® 504 may also be used as a primer in immersion service).

DTM Application to Steel (new or maintenance):

Altra~Build 536® is a surface tolerant coating however for maximum performance a high standard of preparation, ie abrasive blasting to AS 1627.4 Class 2 or 2½, is recommended. However, for atmospheric exposure acceptable performance may be achieved in maintenance situations with a thorough power tool clean to or, for marine immersion service, with abrasive blasting to AS 1627.4 Class 2.

Concrete – New or Old:

Ensure concrete is fully cured (28 day equivalent). Acid etch, sweep blast, scabble or HP water blast surface to remove all laitance and friable matter and contaminants. Altra~Build 536 may be applied direct to the prepared surface however for optimum performance, and to reduce the incidence of pin-holing, seal and strengthen the prepared concrete with Carboguard® 1340 or Altra~Lock 576 before applying Altra~Build 536.

Previously Painted Surfaces:

A test patch should be applied to check for lifting. If lifting occurs or if the old coatings are not sound and tightly adhered remove to bare metal. Prepare surface as for new steel. Achieve a minimum of AS 1627.4 Class 2 on rough or pitted steel.

DIRECTIONS FOR USE

Mixing:

Altra~Build 536® is a two component product supplied in 5 and 10 litre two component kits which contain the correct ratio of ingredients. The entire contents of each container must be mixed together. Power mix the base portion to obtain a smooth homogeneous condition. After mixing the base portion, slowly add the converter whilst continuing to agitate. After the converter addition is complete continue to mix slowly until homogeneous. Altra~Build 536® requires a 15 minute induction time before using.

The pot life of the mixed material is 4 hours at 25°C. Higher temperatures will reduce the working life of the coating; lower temperatures will increase it.

Thinning:

Thinning is generally not required; however, at lower temperatures, **small** amounts (15% or less) of Altex 1/2 Thinner may be added to the mixed material.

Clean-up:

Use 1/2 thinner

Application:

Altra~Build 536® can be applied by either conventional air spray or airless spray equipment.

Suggested spray equipment is:

Air Spray *De Vilbiss* - JGA gun, D Fluid Nozzle, 64 Air Nozzle

Airless Spray *Graco* - 45:1 pump, Contractor gun, 0.021-0.027" RAC IV tip

(Or equivalent equipment to the above)

Ventilation:

It is very important for the safety of the applicator and to obtain proper performance of Altra~Build 536® that good ventilation is provided to all portions of the enclosed area. It is equally important to bring into the enclosed area dry, fresh air to remove all solvent vapours. Since solvent vapours are heavier than air, ventilation ducts should reach to the lowest portions of the enclosed area as well as into any structural pockets. Ventilation should be maintained throughout the cure period.

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~Build 536® 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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