

## SELECTION & SPECIFICATION DATA

<b>Generic Type</b>	Polyamide epoxy
<b>Description</b>	A high-performance multi-purpose epoxy coating with a wide variety of tintable past tone colours. It's ideal for use in many industrial environments such as pulp & paper plants, water & wastewater plants, fertiliser works, power generation plants, and food processing plants. Can be used on concrete floors in services areas such as workshops, warehouses, and factories.
<b>Features</b>	<ul style="list-style-type: none"> <li>• Versatile - Can be applied directly to suitably prepared steel, galvanised steel, concrete, or fibreglass</li> <li>• Fast cure at normal temperatures</li> <li>• Fast dry-to-recoat</li> <li>• Excellent solvent and chemical resistance</li> <li>• Low VOC / High solids</li> <li>• Tintable to a wide range of pastel colours</li> <li>• Safe – All colours are lead and chrome free</li> <li>• Can be topcoated with E~Line® series and Chem~Bar™ 900</li> </ul>
<b>Colour</b>	White. Can be tinted to a range of pastel tone colours
<b>Finish</b>	Low sheen
<b>Dry Film Thickness</b>	125 - 200 microns 179 microns wet to obtain 125 microns dry
<b>Solids Content</b>	By volume 70% +/- 1%
<b>Theoretical Coverage Rate</b>	5.6 m <sup>2</sup> /L at 125 microns 4.6 m <sup>2</sup> /L at 150 microns 3.5 m <sup>2</sup> /L at 200 microns  Allow for loss in mixing and application.
<b>VOC Values</b>	<b>As Supplied</b> : 211 g/L
<b>Limitations</b>	Exterior exposure will cause early loss of sheen, possible discolouration, and chalking. However, this will not affect the protective properties of the coating. Cure is slowed down at temperatures below 10°C
<b>Topcoats</b>	Polyurethane and vinyl acrylic

## PERFORMANCE DATA

<b>Performance Data</b>	Resists 35% sodium hydroxide, 10% ammonia, 10% hydrochloric acid, 10% sulphuric acid, 5% sodium hypochlorite, petrol, ethanol, motor oil, xylene, MEK, ethylene glycol.	
	Salt Spray Resistance (Cyclic Prohesion Testing)	2,500 hours – Excellent
	Immersion Resistance (5% Salt Solution)	2,500 hours – Excellent
	Chemical Resistance (ASTM D1308)	24-hour contact - Excellent

## SUBSTRATES & SURFACE PREPARATION

<b>General</b>	All surfaces must be sound and free of oil, grease, dirt, loose and flaking paint, moisture, and other foreign substances prior to application of Altra~Lock 576. Clean and/or degrease with either a suitable non-ionic detergent (such as Altex P40 Cleaner), or solvent wipe with Altex C50 Surface Cleaner.
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**SUBSTRATES & SURFACE PREPARATION**

<b>Steel</b>	For optimum results, abrasive blast to near white metal equivalent to SSPC-SP 10 (AS 1627.4 Sa 2½). Satisfactory results will be achieved by abrasive blasting to SSPC-SP 6. (AS 1627.4 Sa 2). For smaller areas, power tool cleaning to SSPC-SP 3 (AS 1627.2 st 3) will provide an acceptable surface for coating.
<b>Galvanised Steel</b>	For galvanised items it is essential that all traces of dichromate passivation are removed. This is accomplished with thorough abrasion, ideally with a light sweep abrasive blast or very thorough scouring with a synthetic scour pad, or mechanical sander.
<b>Aluminium</b>	Typically surfaces are abraded by sweep abrasive blasting with non-metallic media or orbital sanding with 80 non-metallic abrasives. Blow down with clean, dry compressed air to remove dust, grit, and debris. Prime as soon as possible with either Altra~Bond 3094 or Carboguard 504.

**MIXING & THINNING**

<b>Mixing</b>	Stir the two components to obtain a smooth, homogeneous condition using a power stirrer. After mixing the base portion, add the converter slowly with continued agitation. Allow 15 minutes induction time during winter conditions.
<b>Thinning</b>	Thinning may be required. Thin up to 15% with Altex Thinning Solvent #12. For brush / roller application, thin with Altex Thinning Solvent #25.
<b>Ratio</b>	4:1 by volume (Part A : Part B)
<b>Pot Life</b>	4 hours at 25°C

**APPLICATION EQUIPMENT GUIDELINES**

Listed below are general equipment guidelines for the application of this product. Job site conditions may require modifications to these guidelines to achieve the desired results.

<b>Spray Application (General)</b>	The preferred method of application is spray
<b>Conventional Spray</b>	2.0mm to 2.8mm fluid tip with appropriate air cap.
<b>Airless Spray</b>	Pump Ratio: 30:1 Material Hose: 3/8" I.D min Tip Size: 0.015 – 0.021  (Note: Other equipment equivalent to the above may be used.)
<b>Brush &amp; Roller (General)</b>	Brush and roller application are acceptable as long as conditions are not extreme. however, care must be taken to ensure the correct film build is applied.

**APPLICATION CONDITIONS**

Condition	Material	Surface	Ambient	Humidity
Minimum	10°C	10°C	10°C	0%
Maximum	32°C	35°C	35°C	85%
Optimum	16-24°C	16-24°C	16-24°C	30-70%

This product is designed for cool temperature applications. Applying in hot weather conditions will reduce the wicking and penetrative properties of the coating – Consider using Rustbond as an alternative for warmer weather conditions and non-immersed applications.

## CURING SCHEDULE

Surface Temp.	Dry to Handle	Dry to Recoat	Dry to Touch
10°C	15 Hours	8 Hours	8 Hours
15°C	9 Hours	5 Hours	6 Hours
25°C	4½ Hours	4 Hours	3 Hours
32°C	2 Hours	Hours	1 Hour

Curing schedule based on 125 – 200 microns DFT

## CLEANUP & SAFETY

**Cleanup** | Use Altex Thinning Solvent #12

**Safety** | For industrial use only: Read and follow all the caution statements on this Product Data Sheet, the product label, and the Safety Data Sheet (SDS) for health and safety information prior to use.

**Ventilation** | It is very important for the safety of the applicator and the proper performance of this product that good ventilation be 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 areas as well as into any structural pockets. Ventilation should be provided throughout the cure period to ensure all the solvents are removed from the coating.

## PACKAGING, HANDLING & STORAGE

**Shelf Life** | 24 months (Part A and B)

**Shipping Weight (Approximate)** | 1.85 kg per litre  
5L – 9.25 kg

**Storage Temperature & Humidity** | Optimum: 15-20°C

**Flash Point (Setaflash)** | 27°C

**Storage** | Store under cool, dry conditions.  
Avoid large fluctuations between high and low temperatures.  
Avoid the formation of condensate due to low temperatures.

## WARRANTY

### DISCLAIMER

The information in this datasheet is provided as a guide only and is provided without warranty, implied or otherwise. It is your responsibility to determine the suitability of any information or product for the use contemplated. Conditions of use, application and the substrate are beyond our control so no liability whatsoever (whether as to coverage, performance, injury or otherwise) is accepted for the information contained herein.

Data sheets may change from time to time and it is your responsibility to ensure you have the latest product datasheet and material safety data sheet from your supplier. Check the data sheet date with the listings at [www.altexcoatings.com](http://www.altexcoatings.com) and Altex Terms and Conditions of Trade, available at [www.altexcoatings.com](http://www.altexcoatings.com), apply in respect of all coating products and materials supplied, including samples.