

FEATURES

Advantages:

- Fast cure at normal temperatures
- Rapid Dry to Recoat
- Ready to use as soon as components are mixed - no induction time required
- Good solvent resistance
- Resists solvent entrapment
- Good gloss hold-out
- Ideal tie-coat over inorganic zinc's
- Safe -contains no heavy metals or silica
- Excellent adhesion to almost any surface
- Versatile - can be used as the primer under all
- E-Line®, Altra~Shield®, Altra~Build® systems and Chem-Bar™ 900

Limitations of Use:

- Do not top-coat with alkyd coatings without testing
- Has a definite end of pot life - should not be kept overnight
- Cure is slowed down at temperatures below 4°C

Performance Data (as part of a system):

- **Salt spray resistance**
 (Cyclic Prohesion Testing) 2500 hours - excellent
- **Immersion resistance**
 (5% Salt Solution) 2500 hours - excellent

RECOMMENDED USES

Altra~Prime® 504 s a high performance multi- purpose, two component epoxy primer designed for use in both interior and exterior exposure over a variety of suitably prepared surfaces including:

- Steel
- Galvanised Metal
- Aluminium
- Concrete & Masonry
- Fibreglass

Altra~Prime® 504 has good gloss hold out and is an excellent holding primer.

Altra~Prime® 504 may also be used over suitably prepared, aged epoxy and urethane paint systems.

SPECIFICATION DATA

Coating Type:	Polyamide Epoxy
Colour:	Buff
Packaging:	5 litre and 20 litre
Mix Ratio:	4:1 by volume
Gloss:	Flat
Flash Point:	27 °C Setaflash
Thinner:	½ Thinner
Pot Life:	12 hours at 25 °C
Induction Time:	Summer – not required Winter – 15 minutes
Storage:	Store under cool dry conditions

Density:	1.48 kg per litre
VOC:	423 g per litre
Temperature Resistance:	120 °C dry
Volume solids (mixed):	55 % (Wet/ Dry method)
Theoretical Coverage Rate:	11.0 sq. metres per litre at 50 microns dry
Recommended Film Thickness Per Coat:	90-125 microns wet to obtain 50-75 microns dry
Application:	Spray, Brush or Roller

Dry Times (75µm DFT / 50% RH):

Recoat – minimum:	5 °C	15 °C	25°C	30°C
Self	9 hrs	3 hrs	1.5 hrs	1 hr
Epoxy	9 hrs	3 hrs	1.5 hrs	1 hr
Urethane	12 hrs	4 hrs	2 hrs	2 hrs
Recoat – maximum:	5 °C	15 °C	25°C	30°C
Self	1440 hrs	1440 hrs	1440 hrs	1440 hrs
Epoxy	1440 hrs	1440 hrs	1440 hrs	1440 hrs
Urethane	96 hrs	96 hrs	96 hrs	72 hrs

SURFACE PREPARATION

All surfaces to be coated should be clean, dry and free from contamination. Oil or grease should be removed in accordance with AS1627.1 solvent cleaning. Surface defects revealed by the preparation process, should be ground, filled, or treated in the appropriate manner. Clean to remove all grit dust and debris and ensure the surface is dry.

Steel Surfaces:

Abrasive blast to AS1627.4 Class 3 for immersion service and for non-immersion to AS1627.4 Class 2 ½ to achieve a uniform blast profile between 38 to 63 microns and be of a jagged nature as opposed to a peen pattern. A lesser degree of cleaning will reduce the service life of the coating. Apply primer coat to the cleaned surface to prevent re-rusting or contamination.

Galvanised Steel and Electrodepositing Zinc Surfaces:

All traces of dichromate passivation must be removed. Sweep abrasive blast with non-metallic media or thoroughly sand with synthetic scouring pad to provide a uniform roughened finish.

GRP and Wooden Surfaces:

Thoroughly sand with non-stearate paper with 80-120 grit

Concrete surfaces:

Concrete must cure for at least 28 days and not be greater than 10 pH. Acid etch with dilute hydrochloric acid solution (1 part concentrated acid to 10 parts water) to produce a uniformly roughened surface profile, followed by washing off with copious amounts of clean fresh water until the cleaning water is neutral to litmus paper. DO NOT allow etch solution to dry on the surface. Check for excessive moisture using the ASTM D-4263 "Plastic Sheet Method" test. Grinding or sweep blasted to remove all laitence may also be carried out.

Previously Painted Surfaces:

Clean with Altex P40 Cleaner. Remove all unsound coatings. Prepare all corroded and damaged paint areas in accordance with the preparation required for the applicable primer. Feather back edges to a sound clean existing coating. Matt all existing coating to provide a fine matt finish. Clean to remove all grit dust and debris and ensure the surface is dry.

Apply a test patch to confirm compatibility with existing coating system. If lifting occurs remove to bare substrate.

DIRECTIONS FOR USE

Mixing:

Altra-Prime[®] 504 Primer is a two component product supplied in 5 litre and 20 litre kits which contain the correct ratio of ingredients.

Power mix the base portion first to obtain a smooth homogeneous condition. After mixing the base portion, slowly add the converter whilst continuing to agitate at slow speed. After addition of the converter is complete, continue to mix slowly until homogeneous.

Higher temperatures will reduce the working life of the coating; lower temperatures will increase it.

Thinning:

Thinning maybe required to assist application. Any solvent addition should be made after the two components are thoroughly mixed. Excessive thinning can cause low film thickness and coating defects.

Clean-up:

Use ½ thinner

Application:

Altra-Prime[®] 504 Primer can be applied by spray, brush or roller. Application by either airless or conventional air spray equipment is the preferred method.

Suggested spray equipment is:

Air Spray: Graco - Delta Air spray gun, 2.8mm (0.110") or 2.2mm (0.086") set up
De Vilbiss - JGA gun, E or D Fluid Nozzle, 704/765 or 64 Air Nozzle
Airless Spray: Graco - 30:1 pump, Contractor gun, 0.019 - 0.023" RAC IV tip

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

Safety within enclosed areas:

It is very important for the safety of the applicator and to ensure correct performance of the coatings, 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. As 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-Prime[®] 504 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

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