

SELECTION & SPECIFICATION DATA

Generic Type	Single Pack Modified Epoxy Etch
Description	Altra~Etch [®] is a versatile etch primer suited to many light industrial and marine applications.
Features	<ul style="list-style-type: none"> • Excellent adhesion to most common metals • Versatile, convenient, stable, single pack primer • Fast drying • Good abrasion resistance • Compatible with a wide variety of topcoats
Colours	Grey and Red
Finish	Satin
Dry Film Thickness	15 - 20 microns
Solids Content	10% ± 1%
Theoretical Coverage Rate	5.0 sq metres per litre at 20 microns dry
VOC Values	736 gms/ltr
Dry Temp. Resistance	100°C Dry
Top Coats	May be over coated with a wide range of coatings including enamel, chlorinated rubber, epoxy, vinyl acrylic and polyurethane.

SUBSTRATES & SURFACE PREPARATION

General	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~Etch [®] . Clean and/or degrease with either a suitable non-ionic detergent, (such as Altex P40 Cleaner), or solvent wipe with Altex C50 Surface Cleaner.
Steel	For optimum results, abrasive blast to near white metal equivalent to AS1627.4, Class 2½ (SSPC SP-10). Satisfactory results will be achieved by abrasive blasting to AS1627.4 Class 2 (SSPC SP6). For smaller areas, power tool cleaning to AS1627.2, (SSPC SP3) will provide an acceptable surface for coating.
Galvanized Steel and Electrodeposition Zinc Surfaces	Degrease with either a suitable non-ionic detergent, (such as Altex P40 Prepainting Cleaner), or solvent wipe with Altex C50 Surface Cleaner. For electrodeposition zincs, abrasion with a Scotchbrite [®] pad or P220-320 sandpaper is required to create a surface profile. 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.

Altra~Etch®
Single Pack Etch Primer
 PRODUCT DATA SHEET



Aluminium | Degrease as above. Typically, surfaces are lightly abraded with either a Scotchbrite® pad or P220-320 sandpaper. Apply Altra~Etch® to the clean and dry surface.
(Scotchbrite® is a registered trademark of the 3M Company)

MIXING & THINNING

Mixing | Stir thoroughly to ensure a homogeneous condition.

Thinning | This product is supplied at application consistency however some thinning may be required depending upon the type of surface to be painted, and the prevailing weather conditions. Up to 10% may be added without affecting the efficiency of the coating. Use only Altex Thinning Solvent #155.

Ratio | N/A – single component coating

Pot Life | N/A

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.

Spray Application (general) | The preferred method of application for Altra~Etch® is spray.

Conventional Spray | 1.0mm to 1.4mm Fluid tip with appropriate air cap.

Airless Spray | Not recommended

Brush/Roller | Small areas may be brush or rolled if conditions are suitable, however, care must be taken to ensure the correct film build is applied.

Application conditions

Condition	Material	Surface	Ambient	Humidity
Minimum	7°C	2°C	2°C	0%
Maximum	32°C	37°C	35°C	85%
Optimum	16-24°C	16-24°C	16-24°C	30-70%

CURING SCHEDULE

Surface Temp & 50%RH	Dry to Handle	Dry to Topcoat	Dry to Touch
2°C	45 mins	4 hrs self, 12 hrs other	15 mins
15°C	25 mins	1½ hrs self, 6 hrs other	10 mins
24°C	15 mins	1 hr self, 4 hrs other	5 mins
37°C	10 mins	45 mins self, 2 hrs other	5 mins

CLEAN UP & SAFETY

Clean Up | Thinning Solvent #155

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 Altra~Etch [®] 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.
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PACKAGING, HANDLING & STORAGE

Shelf Life	12 months
Shipping Weight (Approximate)	970 g/litre 3.88kg/4 litre
Storage Temperature & Humidity	Avoid large fluctuations between high and low temperatures. Optimum 15-20°C. Avoid the formation of condensate due to low temperatures.
Flash Point (Setaflash)	12°C Setaflash
Storage	Store under cool, dry conditions

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

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