

SELECTION & SPECIFICATION DATA

Generic Type	Modified Alkyd
Description	Premium quality, single pack anti-corrosive primer designed to give superior protection to steel. It is recommended for use on: <ul style="list-style-type: none"> • Structural steel • Tanks • Industrial and farm equipment • Bridges, pipe bridges, roof trusses • Cranes
Features	<ul style="list-style-type: none"> • Inhibits corrosion of steel with high levels of zinc phosphate • Surface tolerant • Superior performance on power and hand tool cleaned surfaces • Easy application by brush, roller, or spray • Excellent flow and levelling • Approved primer for some intumescent coatings – Refer to Altex Coatings for further information
Colour	Red, and Grey-Green
Finish	Matte
Primer	Self-priming. Compatible with and is recommended to be applied over Altex Rust Inhibiting Penetrating Oil (RIPO).
Dry Film Thickness	50 - 75 microns 111 microns wet to obtain 50 microns dry 167 microns wet to obtain 75 microns dry
Solids Content	By Volume 45% ± 1%
Theoretical Coverage Rate	9 m ² /L at 50 microns 6 m ² /L at 75 microns Allow for loss in mixing and application.
VOC Values	As Supplied : 445 g/L
Dry Temp. Resistance	60°C Dry
Approvals	AS 4089:1993, Type 1 and 2 primer Meets and exceeds AS 4089:1993* in particular, adhesion and performance clauses: 5.5.4; 5.5.5; 5.5.6 <i>* Independently assessed by NZ DSIR (1992), Report No. SCPP 92/1160T</i>
Limitations	Do not use in chemical and/or continuous wet exposure Not recommended under chlorinated rubber or urethane finishes unless fully cured (approximately 48 hours) – refer to Altex Technical Services

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 High Build Rust Barrier. 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 interior fire rated systems and for exterior exposures abrasive blast to near white metal equivalent to SSPC-SP 10/NACE No.2 (AS 1627.4 Sa 2½). Interior steel (non-fire rated) may be blast cleaned to SSPC-SP 6 (AS 16.274 Sa 2). For mild conditions hand or power tool cleaning to SSPC-SP 3 (AS 1627.2 St 3) or hand tool clean to SSPC-SP 2 (AS 1627.2 St 2) may be utilised.

High Build Rust Barrier

PRODUCT DATA SHEET



SUBSTRATES & SURFACE PREPARATION

Primed Substrates | In some instances, High Build Rust Barrier may be used as an excellent tie-coat over unknown, aged coatings.
Normal surface preparation in this instance is to degrease the surface prior to sanding with 60-120 grit non-stearate sandpaper.

MIXING & THINNING

Mixing | Stir thoroughly to ensure a homogeneous condition.

Thinning | Thinning may be required. The addition of 5% to 15% v/v Altex Thinning Solvent #45 (brush/roller application), or Altex Thinning Solvent #53 (spray) will enhance application properties.
Note: Excessive thinning can cause low film thickness, sagging and other film defects.
Use of thinners other than those supplied or recommended by Altex Coatings may adversely affect product performance and void product warranty, whether expressed or implied.

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) | High Build Rust Barrier should be applied in one wet coat, overlapping each pass 50%.
The following spray equipment has been found suitable

Conventional Spray | 1.4mm to 2.2mm fluid tip with appropriate air cap.

Airless Spray | Pump Ratio 30:1
Material Hose 3/8" I.D min
Tip Size 0.015 – 0.019

(Note: The above is a guide. Other equipment to the above may be used.)

Brush & Roller (General) | 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	10°C	10°C	10°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.	Dry to Handle	Dry to Recoat	Dry to Touch
10°C	24 Hours	24 Hours	6 Hours
15°C	Overnight	Overnight	4 Hours
24°C	12-18 Hours	12-18 Hours	2 Hours

Maximum self-recoat time: 30 days

Maximum overcoat time with alkyd enamel finishes: 14 days

CLEANUP & SAFETY

Cleanup	Use Altex Thinning Solvent #45 or #53
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 High Build Rust Barrier 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	48 months at 24°C Shelf Life: (actual stated shelf life) when kept at recommended storage conditions and in original unopened containers. For products/components exceeding the stated shelf life, contact Technical Services for further advice.
Shipping Weight (Approximate)	1L - 1.31 kg 4L - 5.24 kg 20L - 26.2 kg
Storage Temperature & Humidity	Optimum: 15-20°C
Flash Point (Setaflash)	35°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 Altex Terms and Conditions of Trade, available at www.altexcoatings.com, apply in respect of all coating products and materials supplied, including samples.