

SELECTION & SPECIFICATION DATA

Generic Type	Modified alkyd
Description	<p>Single component premium quality primer based on proprietary synthetic, immersion grade alkyd resins. An excellent protective primer for most substrates in marine and industrial exposures. It is recommended for use on:</p> <ul style="list-style-type: none"> • Agricultural equipment • Commercial charter yachts, launches and fishing vessels (above and below the waterline) • On site touch-up work-handrails etc • Restoration of timber joinery
Features	<ul style="list-style-type: none"> • Applied directly to suitably prepared steel, galvanised steel, wood, and GRP • Excellent adhesion • Above the waterline - overcoat with a sandable undercoat (Altex Isotal Undercoat) and topcoat with Altex Isotal Enamel) • Below the waterline – in multiple coats as part of a marine protective system where it is normally overcoated with Sea~Barrier® 3000 antifouling • Interior or exterior usage • Marine quality • Easy application by brush, roller, or spray • Sandable
Colour	Light Grey
Finish	Flat
Dry Film Thickness	50 microns 109 microns wet to obtain 50 microns dry
Solids Content	By volume 46% ± 1%
Theoretical Coverage Rate	9.2 m ² /L at 50 microns Allow for loss in mixing and application.
VOC Values	As Supplied : 433 g/L
Limitations	<ul style="list-style-type: none"> • Not recommended for use on aluminium substrates • Not recommended for immersion service on galvanised steel

SUBSTRATES & SURFACE PREPARATION

General	<p>All surfaces must be sound and free of oil, grease, dirt, loose and flaking paint, moisture, and other foreign substances prior to application of Multi~Bond Primer. Clean and/or degrease with either a suitable non-ionic detergent (such as Altex P40 Cleaner), or solvent wipe with Altex C50 Surface Cleaner.</p>
Steel	<p>For optimum performance, below waterline systems and for exterior exposures abrasive blast to SSPC-SP 10/NACE No.2 (AS 1627.4 Sa 2½) The steel profile after blasting should be 30 to 70 microns in depth and be of a jagged nature as opposed to a peen pattern. Interior steel (mild environments) may be abrasive blasted to SSPC-SP 6 (AS 1627.4 Sa 2).</p> <p>For mild conditions and spot repairs, 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.</p>
Galvanised Steel	<p>Sand with 80 - 120 grit non-stearate sandpaper, and de-dust. Ensure surfaces are clean and that all dichromate passivation residues are removed.</p>
GRP / Fibreglass	<p>Sand with 80 - 120 grit non-stearate sandpaper, and de-dust.</p>

Multi~Bond Primer

PRODUCT DATA SHEET



SUBSTRATES & SURFACE PREPARATION

Wood	Sand surfaces to create a clearly discernible surface profile, and de-dust. Prime the surface with Multi~Bond Primer thinned 30% to aid penetration into the timber. Apply an additional coat/s to achieve a fully coated surface. Dry timber may be pre-sealed with AY&B Epoxy Everseal.
Previously Painted Surfaces	All aged and failing coatings must be sanded back to a smooth, sound condition. Edges of coatings must be feathered to ensure a smooth transition. Any exposed substrate must be abraded to ensure a profiled surface is achieved. Ensure the surface is clean and free of dust prior to application.

MIXING & THINNING

Mixing	Stir thoroughly to ensure a homogeneous condition.
Thinning	The addition of up to 10% v/v Altex Thinning Solvent #45 (brush/roller application), or up to 15% v/v 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)	Multi~Bond Primer should be applied in one wet coat, overlapping each pass 50%. The following spray equipment has been found suitable.
Conventional Spray	1.4mm to 1.8mm fluid tip with appropriate air cap. Note: Use the lowest air pressure that will achieve good atomisation to minimise overspray.
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)	Brush and roller application are acceptable 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 Touch	Dry to Recoat (minimum)	Dry to Recoat (maximum)
10°C	Overnight	4 Hours	8-10 Hours*	30 Days**
15°C	6-7 Hours	2 Hours	6 Hours*	30 Days**
24°C	4-5 Hours	30-60 Minutes	4 Hours*	30 Days**

Curing schedule based on 50 microns DFT

* When overcoating with antifouling (products such as Sea~Barrier® 3000), a minimum 24 hours cure of the primer is required to ensure adequate hard cure is achieved.

** When overcoating with itself, other alkyds, or antifouling – without sanding

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 Multi~Bond Primer 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 | 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 – 1.52 kg
4L – 6.08 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.