

SELECTION & SPECIFICATION DATA

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| Generic Type | Quick-dry alkyd |
| Description | A fast drying, economical, steel primer designed for use in engineering fabrication shops. Pre~Fab is suitable as a stand-alone coating in mild interior environments and provides good protection to structural steel in moderate exterior environments when topcoated with compatible alkyd or acrylic coatings. Pre~Fab is the primer of choice for SSPC-SP 2 hand tool cleaned structural steel to be enclosed within wall framing. |
| Features | <ul style="list-style-type: none"> • Fast drying action allows rapid handling of coated steel at 25°C • Modified zinc phosphate anti-corrosive pigmentation • Higher Zinc Phosphate content than other shop primers • Free of chromates and other heavy metal compounds • Suitable for acrylic and alkyd topcoats • Very economic cost per square metre • Can be applied using conventional spray equipment as well as airless spray • Highly recoatable with itself or other alkyd undercoats or finish coat |
| Colour | Red Oxide and Grey |
| Finish | Flat |
| Dry Film Thickness | 50 microns 116 microns wet to obtain 50 microns dry |
| Solids Content | By volume 43% ± 1% |
| Theoretical Coverage Rate | 8.6 m ² /L at 50 microns Allow for loss in mixing and application. |
| VOC Values | As Supplied : 479 g/L |
| Limitations | <ul style="list-style-type: none"> • Not recommended for extended exterior exposure without finish coating • Not recommended for galvanised steel |

SUBSTRATES & SURFACE PREPARATION

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| 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 Pre~Fab. 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 performance in 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 (AS1627.4 Sa 2). For mild internal conditions 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. |

MIXING & THINNING

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| 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. |

MIXING & THINNING

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) | Pre~Fab 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 Topcoat w/ Acrylics or Alkyds | Dry to Touch | Dry to Recoat (maximum) |
|---------------|---------------|--------------------------------------|---------------|-------------------------|
| 10°C | Overnight | 36-48 Hours | 4 Hours | 30 Days** |
| 15°C | 6-7 Hours | 24-48 Hours | 1½ Hours | 30 Days** |
| 24°C | 2-3 Hours | 18-36 Hours | 15-30 Minutes | 30 Days** |

Curing schedule based on 50 microns DFT

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

CLEANUP & SAFETY

Cleanup | Use Altex Thinning Solvent #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 Pre~Fab 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

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| 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) | 4L – 5.12 kg 20L – 25.6 kg |
| Storage Temperature & Humidity | Optimum: 15-20°C |
| Flash Point (Setaflash) | 15°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.