Altra~Bond™ 3094

Strontium Chromate Epoxy Primer
PRODUCT DATA SHEET

SELECTION & SPECIFICATION DATA

Generic Type	Polyamide epoxy
Description	A two-component epoxy primer designed for use on aluminium sheets & extrusions, and galvanised substrates. Formulated with strontium chromate, which provides exceptional protection from filiform corrosion on aluminium surfaces.
Features	• Excellent adhesion to aluminium and galvanising • Fast dry to recoat • Low temperature cure down to 5°C • Superior anti-corrosive properties
Colour	Translucent yellow
Finish	Low sheen
Dry Film Thickness	15 - 20 microns 100 microns wet to obtain 20 microns dry (mixed and thinned at the recommended 1:1:1 mix ratio – refer 'Mixing' section) Do NOT overbuild
Solids Content	By volume 30% +/- 1%
Theoretical Coverage Rate	15 m²/L at 40 microns Allow for loss in mixing and application.
VOC Values	**As Supplied** : 585 g/L
Dry Temp Resistance	80°C
Topcoats	Epoxy, and polyurethane
Limitations	• Not suitable for below waterline / immersion service • Do not overbuild • Do not exceed the maximum recoat time • Do not sand/abrade

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~Bond 3094. Clean and/or degrease with either a suitable non-ionic detergent (such as Altex P40 Cleaner), or solvent wipe with Altex C50 Surface Cleaner prior to abrading or sandblasting..
Aluminium	For optimum performance it is recommended to sweep abrasive blast using fine, non-metallic media to attain a uniform matte finish. Where abrasive blasting cannot be undertaken, abrasion by means of disc grinders and/or other power tools, using non-metallic abrasives with a grit range of 60-120 grit will achieve clearly discernible surface profile. Using Scotchbrite® to abrade aluminium surfaces is adequate for thin film systems. Thick film systems will require a greater surface profile size. *Scotchbrite® is a registered trademark of 3M Company*

SUBSTRATES & SURFACE PREPARATION

Galvanised Steel & Electrodeposition Zinc Surfaces	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 orbital sanding typically using 80 grit sanding pads. Do not apply over dichromate passivated galvanising.

MIXING & THINNING

Mixing	Stir the base portion first to obtain a smooth, homogeneous condition using a power stirrer. After mixing the base portion, measure out the required volume of base into a clean mixing container, and add equal parts of the converter slowly with continued stirring. After mixing is completed, proceed to 'Thinning' as directed below.
Thinning	Thinning is required. Thin 50% by volume with Altex Thinning Solvent #12, i.e. 1:1:1 (Part A : Part B : Thinner). Do not use thinners other than those recommended by Altex Coatings.
Ratio	1:1 by volume (Part A : Part B)
Pot Life	12 hours at 25°C

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.

General	Best applied by conventional spray. Do NOT overbuild. The correct film thickness is achieved when the surface first just attains a semi-transparent yellow colour.
Conventional Spray	1.1mm to 1.4mm fluid tip with appropriate air cap.
Airless Spray	Not recommended
Brush & Roller (General)	Small areas may be brush and roller applied 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	5°C	5°C	5°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 (minimum)	Dry to Topcoat (maximum)	Dry to Touch
5°C	45 Minutes	4 Hours	24 Hours	45 Minutes
10°C	20 Minutes	2½ - 3 Hours	24 Hours	30 Minutes
24°C	15 Minutes	2 Hours	24 Hours	10 - 20 Minutes
37°C	10 Minutes	1½ - 2 Hours	24 Hours	10 Minutes

Optimum time to recoat is after 3 hours at 25°C

CLEANUP & SAFETY

Cleanup	Use Altex Thinning Solvent #12
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 this product 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	Part A: 48 months at 24°C Part B: 24 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)	1.11 kg per litre 2L – 2.22 kg
Storage Temperature & Humidity	Optimum: 15-20°C
Flash Point (Setaflash)	27°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.
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