

SELECTION & SPECIFICATION DATA

Generic Type	100% solids epoxy
Description	A rapid dry/quick cure 100% solids penetrating epoxy sealer designed for use where less than ideal surface preparation is attainable or where surfaces have inherent porosity or surface weakness. It has a very low viscosity which allows it to wick into and bond porous substrates and residual rust into a tough epoxy composite. It may be applied to residual rust, degraded or new concrete, fibre-reinforced cement, and timber.
Features	<ul style="list-style-type: none"> • Excellent wetting properties • 100% solids • Rapid cure • Low temperature cure as low as 4°C • Ideal for marginally prepared steel • Easy application by brush, roller, or low atomisation spray • Can be used to seal asbestos • Suitable for below waterline applications on marine vessels when used underneath a high build epoxy barrier system • Approved for use in food & dairy processing plants (refer to "Approvals NZ/AU" section)
Colour	Light amber clear
Finish	Low sheen
Dry Film Thickness	40 microns 40 microns wet to obtain 40 microns dry Avoid excessive film thickness and/or ponding
Solids Content	By volume 100%
Theoretical Coverage Rate	25 m ² /L at 40 microns Actual coverage rate will vary depending on surface porosity Allow for loss in mixing and application.
VOC Values	As Supplied : 0 g/L
Limitations	Short pot-life – Refer to 'Pot-Life' section
Topcoats	Chlorinated rubber, vinyl acrylic, epoxy, 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~Lock 576. 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	Minimum 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.
Concrete	Degrease with a suitable non-ionic detergent (such as Altex P40 Cleaner). Grinding is the most suitable means of preparation, as this promotes rapid penetration of the coating into the substrate. This will also ensure a surface profile similar in texture to 80 grit sandpaper is achieved.

MIXING & THINNING

- Mixing** | Stir thoroughly to ensure a homogeneous condition.
- Thinning** | Do NOT thin
- Ratio** | 1:1 by volume (Part A : Part B)
- Pot Life** | This product is highly reactive and has a short pot life of 90 minutes at 20°C. Unless large areas are to be covered in a short period of time only small amounts should be mixed at once.
This product will exotherm with a 2 litre mix temperature rising to 47°C over 90 minutes (ambient 20°C). Material should be disposed of and equipment flushed out as soon as the temperature reaches 50°C.
A maximum mix of a 1 litre mix is recommended

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)** | This product can be applied by spray using conventional spray equipment. To minimise overspray use low air pressure and pot pressure – 5 to 10 psi.
With its low viscosity, it should be applied in one **thin** wet coat, sufficient to completely cover and penetrate the surface. Do NOT apply in heavy coats. Remove excess product, drips, or ruddles with clean rags.
Refer also to the ‘Pot-Life’ section for limitations
- Conventional Spray** | 1.0mm to 1.4mm fluid tip with appropriate air cap.
- Airless Spray** | Not recommended
- Brush & Roller (General)** | Brush and roller application are acceptable as long as conditions are not extreme. however, care must be taken to ensure the correct film build is applied.

APPLICATION CONDITIONS

Condition	Material	Surface	Ambient	Humidity
Minimum	5°C	2°C	2°C	0%
Maximum	<30°C	<30°C	<30°C	85%
Optimum	16-24°C	16-24°C	16-24°C	30-70%

This product is designed for cool temperature applications. Applying in hot weather conditions will reduce the wicking and penetrative properties of the coating – Consider using Rustbond PS as an alternative for warmer weather conditions and non-immersed applications.

CURING SCHEDULE

Surface Temp.	Dry to Handle	Dry to Recoat or Topcoat w/ Epoxy (minimum)	Dry to Recoat or Topcoat w/ Epoxy (maximum)	Dry to Touch
5°C	16 Hours	12 Hours	72 Hours	12 Hours
10°C	12 Hours	8 Hours	72 Hours	8 Hours
24°C	6 Hours	6 Hours	72 Hours	4 Hours
30°C	5 Hours	4 Hours	48 Hours	3 Hours

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) | 1.05 kg per litre
4L – 4.2 kg

Storage Temperature & Humidity | Optimum: 15-20°C

Flash Point (Setaflash) | 12°C

Storage | Store under cool, dry conditions.
Avoid large fluctuations between high and low temperatures.
Avoid the formation of condensate due to low temperatures.

APPROVALS

Approvals NZ/AU | **Food Processing - New Zealand**
AsureQuality® assessed for food/beverage industry including dairy factory and dairy farm non-incident contact (assessment reference number: h3104c).

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.