Altra~Zinc™ 605

Multi-Gard 15-605
PRODUCT DATA SHEET

SELECTION & SPECIFICATION DATA

Generic Type	Reinforced phenalkamine epoxy zinc
Description	High performance, two component, reinforced epoxy zinc-rich primer designed for use as a cathodic primer for protecting steel exposed to a variety of environments.
Features	• Premium performance primer for most industrial systems. • Resists topcoat pinholing • Resistant to dry spray, mudcracking and topcoat bubbling • Easy to mix - zinc pre-mixed into base component • Easy application by brush, roller, or spray • Fast dry-to-recoat times • Good low temperature cure • Good solvent resistance • Safe - contains no lead or chromate pigments • Versatile - can be used as the primer under numerous coating systems including fireproofing
Colour	Grey and Green
Finish	Matte
Dry Film Thickness	50 - 100 microns 78 microns wet to obtain 50 microns dry 156 microns wet to obtain 100 microns dry
Solids Content	By volume 64%
Theoretical Coverage Rate	12.8 m²/L at 50 microns 8.5 m²/L at 75 microns 6.4 m²/L at 100 microns Allow for loss in mixing and application.
VOC Values	**As Supplied** : 415 g/L
Dry Temp. Resistance	200°C Dry (non-continuous)
Limitations	• Do not topcoat with alkyd coatings • Not suitable for solvent, chemical or fresh-water immersion service • A minimum of 8 hours of protected cure is required before exposure to condensation / dew / rainfall. • Ponding on coated steelwork will result in discolouration & possible film issues.

PERFORMANCE DATA

Test Method	Results
Salt Spray Resistance (Cyclic Prohesion Testing)	Excellent after 2,500 hours of exposure
Immersion Resistance (5% Salt Solution)	Excellent after 2,500 hours of exposure

SUBSTRATES & SURFACE PREPARATION

General	All surfaces must be sound and free of oil, grease, dirt, loose and flaking paint, moisture, and other foreign substances. Clean and/or degrease with either a suitable non-ionic detergent (such as Altex P40 Cleaner), or solvent wipe with Altex C50 Surface Cleaner.

SUBSTRATES & SURFACE PREPARATION

Steel	For optimum results, abrasive blast to SSPC-SP 10/NACE No.2 (AS 1627.4 Sa 2½) The steel profile after blasting should be 35 to 75 microns in depth and be of a jagged nature as opposed to a peen pattern. Satisfactory results will be achieved by abrasive blasting to SSPC-SP 6 (AS 1627.4 Sa 2). For small areas, power tool cleaning to SSPC-SP 3 (AS 1627.2 St 3) may be utilised.

MIXING & THINNING

Mixing	Power mix the base portion first to obtain a smooth, homogeneous condition. After mixing the base portion add the converter slowly with continued agitation. During the summer, no induction time is required for Altra~Zinc® 605, in winter conditions allow 15 minutes induction time.
Thinning	Thinning may be required. Thin up to 15% with Altex Thinning Solvent #12. 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	4:1 by volume
Pot Life	8 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.

Spray Application (General)	The preferred method of application is spray.
Conventional Spray	1.6mm to 2.8mm fluid tip with appropriate air cap.
Airless Spray	Pump Ratio 30:1 Material Hose 3/8” I.D min Tip Size 0.017 – 0.021 (Note: The above is a guide. Other equipment to the above may be used.)
Brush & Roller (General)	For small areas, this coating may be brush or 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	10°C	2°C	2°C	0%
Maximum	32°C	35°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	Maximum to Topcoat
2°C	8 Hours	8 Hours	2-3 Hours	Dependent on topcoat to be used – refer to specification data
15°C	4 Hours	3½ Hours	1 Hour	
24°C	2 Hours	2 Hours	35 Minutes	
37°C	45 Minutes	45 Minutes	25 Minutes	

Curing schedule based on 50-75 microns DFT and 50% RH

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 Altra~Zinc® 605 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: 36 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)	5L kit – 10.75 kg 10L kit – 21.5 kg
Storage Temperature & Humidity	Optimum: 15-20°C
Flash Point (Setaflash)	14°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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