

FEATURES
Advantages:

- Excellent build properties up to 150µm DFT in a two-pass application
- Excellent surfacing and sanding properties
- Very good corrosion protection
- Wide maximum self re-coat times for easy project management
- Very good water and chemical resistance
- Long pot life
- AY&B Epoxy Barrier Undercoat may be top-coated with both acrylic or polyester urethane finishes and is especially formulated as an undercoat or sealer under the Altex Elite range of polyurethane finish coats
- May be used as a high build surfacer / undercoat for topcoating with AY&B Polyurethane Undercoat
- May be used in immersion service as part of an Altex Yacht & Boat recommended system
- May be applied as a thin film (50µm DFT) tie/seal coat, or as a high build undercoat. (see overleaf)

RECOMMENDED USES

Altex Yacht & Boat Paint Epoxy Barrier Undercoat is a high performance, sandable epoxy high build coating based on new technology Phenalkamide hybrid resins, which offers both superior corrosion and water resistance. This new epoxy undercoat offers both the DIY and Professional applicator an easy-to-use product with a diverse range of uses and benefits.

AY&B Epoxy Barrier Undercoat is recommended for:

- Topside & Superstructure final sealing to provide an optimum surface for finish coating
- As a high build surfacer to remove defects and achieve a finish suitable for application of AY&B Polyurethane Undercoat or one of the Elite Polyurethane finish coats
- As a high build barrier coat for below waterline application, used as part of an Altex Antifouling system
- Direct application to sanded GRP, epoxy laminated wood and epoxy sealed wood, aged polyurethane, and epoxy coatings.
- Direct application to epoxy faired surfaces
- Application over AY&B Epoxy Primer or AY&B Epoxy High Build Surfacer

SPECIFICATION DATA

Coating Type:	Phenalkamide Epoxy			
Colour:	Standard: Off-White NZ only: Light Grey			
Packaging:	1.25, 5 & 10 Litre kit			
Mix Ratio:	4 to 1 by volume			
Volume Solids:	45%			
Gloss:	Low sheen			
Flash Point:	27°C Seta flash			
Thinner:	Spray: Altex Thinning Solvent #12 Brush / Roller: Altex Thinning Solvent #22			
Pot Life:	8 hours at 25°C			
Induction Time:	15 minutes			
Density:	1.36 kg per litre			
VOC (EPA 24):	468 grams per litre			
Theoretical Coverage Rate:	4.5 sq metres per litre at 100 microns dry			
Recommended Film Thickness Per Coat:	225-335 microns wet to obtain 100-150* microns dry. (*applied in two passes)			
Application:	Air or airless spray, brush or roller			
Application Conditions:				
Condition	Material	Surface	Ambient	Humidity
Minimum	10°C	5°C	5°C	0%
Maximum	32°C	50°C	50°C	90%
Optimum	16-24°C	16-24°C	16-24°C	30-70%
This product requires the substrate temperature to be above the dew point.				
Storage:	Store under cool, dry conditions			
Shelf Life:	Part A: 48 months at 24°C Part B: 24 months at 24°C			

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.

Dry Times (25°C / 100 µm DFT / 50% RH):

Touch Dry: 90 mins **Dry to Sand:** 6 hours

Recommended Recoat:

Min. Self Recoat: 30 – 60 mins between passes
6 hours between coats

Min. To Overcoat: Overnight for all other coatings
excl. Antifouling (see overleaf)

Max. Self Recoat: 10 days without sanding.

Max. To Overcoat: 10 days, thereafter thoroughly sand
before overcoating

Max. To Topcoat (see additional notes opposite)

Undercover with Elite Polyurethane Finish:

12 Days max - freshly sanded within 3 days of topcoating.

Outside with Elite Polyurethane Finish:

10 Days max - freshly sanded within 3 days of topcoating.

Cure Time Notes: Maximum cure times before topcoating are based on thorough fine sanding & dedusting within 3 days and solvent wiping of the surface immediately before application of any subsequent coats.

If the coating has cured hard and will not adequately finish sand, then re-sand the surface with a coarse grade (80 – 180 grit) and re-apply a coat of Altex Epoxy Barrier Undercoat or Altex Polyurethane Undercoat before finish coating.

Dry to sand times will increase with higher film builds, and/or lower temperatures. Winter cure may be improved by utilising the following techniques. Warm the paint in a bath of tepid water for 4-5 minutes before use. Rest the mixed product for up to 30 minutes before thinning & application (induction). Store the sealed containers in a warm location overnight – before mixing. Do not heat the coating above 20-25°C. Warm the environment / substrate before application and provide optimal ventilation.

Or lightly sand the partially cured surface with 120 grit to open the film up & allow solvents to escape.

SURFACE PREPARATION

All surfaces must be clean, dry, free of wax or any other contaminants and be suitably abraded.

GRP, Epoxy Undercoats, Polyurethane Finishes & Epoxy Glass Laminates: Ensure the surface is thoroughly clean. Degrease and de-wax using Altex D30 Degreaser/Dewaxer if necessary. Abrade the cleaned surface using non-lubricated sandpaper such as Wet-Or-Dry paper. Depending upon the surface being prepared and the intended service, sandpaper grades may vary between 80 grit and 180 grit, with grades in the range of 100 to 120 grit providing optimum anchor pattern and with minimal sanding 'grin-through'.

Apply AY&B Epoxy Barrier Undercoat to the prepared surface.

Timber: All exposed timber surfaces should be sealed with AY&B Epoxy Everseal before application of Epoxy Barrier Undercoat.

Aged Epoxy High Builds, Fillers & Fairing: Ensure the surface is free of grease and other foreign matter. Initially sand using 40 - 60 grit non-lubricated sandpaper, dedust and re-sand with 80 to 120 grit.

Apply AY&B Epoxy Barrier Undercoat to the prepared surface.

Steel Surfaces: All exposed mild & corten steel surfaces should be primed with AY&B Epoxy Primer before application of AY&B Epoxy Barrier Undercoat.

Aluminium: All aluminium surfaces should be primed with AY&B Epoxy Aluminium Primer, or AY&B Epoxy Primer before application of AY&B Epoxy Barrier Undercoat.

Please refer to the appropriate Data Sheet for all products listed above.

DIRECTIONS FOR USE

Mixing:

Thoroughly power mix Part A first to obtain a smooth, blended homogeneous condition. Measure out 4 parts of Part A into a clean mixing container and add 1 part of Part B slowly with continued stirring. Continue to stir for at least 5 minutes. Allow an induction time of 15 minutes before thinning & application.

Care must be taken to accurately measure each component if mixing partial kits.

Thinning:

Undercoating: To achieve the desired build, thinning should be limited to no more than 10% with Altex Thinning Solvent #12 with two passes (min) required to achieve the desired dry film build of 150µm. For optimum build, thin only sufficiently to achieve good atomisation.

Seal Coating: Thin 20-30% with Altex Thinning Solvent #12 and use a fine, finishing tip to achieve a well atomised, thin film of 50µm dry film thickness.

For brush application, thin no more than 10% with Altex Thinning Solvent #22. Thin only sufficiently to assist application.

Application: AY&B Epoxy Barrier Undercoat may be applied by spray, brush or roller. Application by either airless or conventional air spray equipment is the preferred method

Suggested spray equipment is:

Air Spray: *Graco* - Delta Air Spray; 1.2 – 1.8mm Fluid Nozzle

DeVilbiss - JGA Gun, E Fluid Nozzle, 78 Air Nozzle

Airless Spray: *Graco* - 30:1 pump, Contractor Gun, 0.015-0.019" RAC IV tip

(Note: Other equipment equivalent to the above may be used.)

Roller Application: Use a 5mm nap roller – longer fibres will prove to be difficult to use. In cooler temperatures (<20°), try to avoid thinning to assist in achieving film build. In warmer temperatures, thin judiciously with Altex Thinning Solvent #22. Excess thinning will compromise build properties.

Sanding: By Hand: AY&B Epoxy Barrier Undercoat is normally hand sanded with 220 grit (for further undercoating), followed by 320 grit sandpaper prior to topcoating.

By Orbital: up to 220 grit when being overcoated with AY&B Polyurethane Undercoat, or 280 grit for finish coating. We recommend 3M Free-Cut® Gold or Norton NoFil®, (or equivalent) Zinc Stearate, or Calcium Stearate sandpapers for optimised sanding and self cleaning.

Attempting to orbital sand with 320 or finer will impair sanding properties and polish the surface.

Overcoating & Topcoating: For surface cleaning & dedusting prior to finish coating, fresh water rinse (as above) and / or use Altex C50 Surface Cleaner, or Altex Thinning Solvent #109, using the two-rag method. Do NOT use an epoxy thinner. We recommend the use of Tack Rags to remove dust residues.

Antifouling: Application of any Altex Antifouling should be completed before the AY&B Epoxy Barrier Undercoat has fully cured (i.e., when the epoxy is tack free but still soft to finger pressure). Do not apply antifouling to hard cured AY&B Epoxy Barrier Undercoat. Application of the first coat of antifouling MUST be completed the same day as the final coat of AY&B Epoxy Barrier Undercoat.

Clean-up: Use Thinning Solvent #12.

Compatible Primers/Undercoats:

- AY&B Epoxy Aluminium Primer
- AY&B Epoxy Primer
- AY&B Epoxy High Build Surfacer
- AY&B Epoxy Everseal
- AY&B Epoxy Resin / Microballoons

Compatible Products for Overcoating:

- AY&B Elite Defender
- AY&B Elite 239
- AY&B Elite 321 Brushing Polyurethane.
- AY&B Polyurethane Undercoat
- AY&B Epoxy Primer
- All Altex Antifouling (see note above)

PRECAUTIONS

For DIY & Professional Use: 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.

AY&B Epoxy Barrier Undercoat is flammable. Keep away from heat, sparks, and open flame. Use with adequate ventilation. May cause eye and skin irritation. Do not breathe vapour or spray. Wear suitable protective clothing such as gloves and eye and face protection.

WWW.ALTEXBOATPAINT.COM

Head Office New Zealand

Altex Coatings Ltd

91-111 Oropi Road
Greerton, Tauranga 3112

Ph: +64 7 541 1221
Fax: +64 7 541 1310

Head Office Australia

Resene Paints (Aust) Ltd

Industrial & Marine Division
7 Production Avenue, Molendinar
Queensland 4214

Ph: +61 7 5512 6600
Fax: +61 7 5512 6697

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