

## FEATURES

- Modified Epoxy Polyamide Anti-Corrosive Primer
- Extensively tested against prevailing performance standards for aluminium primers
- Rapid Dry-to-prime or topcoat
- Easy to use - 1:1:1 (base : converter : thinner) mix ratio
- Excellent adhesion to aluminium alloys and galvanising
- Excellent resistance to filiform corrosion on aluminium surfaces
- Cures well at low temperatures
- Proven case histories over many years

### Limitations of Use:

- Not suitable for use on surfaces subject to continuous immersion.
- Do not overbuild – apply to achieve a semi-transparent yellow film
- Observe min/max recoat times strictly

## RECOMMENDED USES

**Altex Yacht & Boat Epoxy Aluminium Primer is a two component primer utilising high performance, anti-corrosive chromates designed for use on aluminium launches, dinghies & yachts.**

**It has been developed for use above the waterline (non-immersion) to provide the very best adhesion to aluminium substrates, and for optimum protection against filiform corrosion.**

**AY&B Epoxy Aluminium Primer** is recommended for:

- Launches, dinghies, yachts – topsides, cabin tops, decks, internal areas, void spaces, masts & spars
- Superior adhesion to aluminium surfaces
- Superior resistance to filiform corrosion.
- All atmospheric exposures (topcoated)
- All aluminium surfaces to be coated with high performance epoxy and urethane systems
- Trailers, caravans, house trucks, horse floats and other vehicles fabricated in aluminium

AY&B Epoxy Aluminium Primer may be intermediate / top coated with:

- AY&B Epoxy Primer
- AY&B Epoxy High Build Surfacer
- AY&B Epoxy Barrier Undercoat
- AY&B Polyurethane Undercoat
- AY&B Elite Defender
- AY&B Elite 239
- AY&B Elite 321 Brushing Polyurethane

## SPECIFICATION DATA

<b>Coating Type:</b>	Modified Polyamide Epoxy Anti-Corrosive
<b>Colour:</b>	Translucent Yellow
<b>Packaging:</b>	500 ml - Two component kits
<b>Mix Ratio:</b>	1 : 1 by volume
<b>Gloss:</b>	Low Sheen
<b>Flash Point:</b>	12°C Setaflash
<b>Thinner:</b>	Altex Thinning Solvent #12
<b>Pot Life:</b>	12 hours at 25°C
<b>VOC:</b>	585 g / litre
<b>Temp. Resistance:</b>	80°C Dry
<b>Volume Solids:</b>	30±1%
<b>Storage:</b>	Store under cool, dry conditions
<b>Shelf Life:</b>	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.

<b>Density:</b>	1.05 kg / litre						
<b>Theoretical Coverage Rate:</b>	15 square metres per litre at 20 microns dry						
<b>Recommended Film Thickness per Coat:</b>	70 microns wet to obtain 20 microns dry						
<b>Application:</b>	Conventional pressure pot						
<b>Dry Times (25°C / 20 µm DFT / 50% RH):</b>	<table border="0"> <tr> <td>Touch Dry</td> <td>10-20 minutes</td> </tr> <tr> <td>Optimum to Overcoat</td> <td>3 hours</td> </tr> <tr> <td>Maximum to Overcoat</td> <td>24 hours</td> </tr> </table>	Touch Dry	10-20 minutes	Optimum to Overcoat	3 hours	Maximum to Overcoat	24 hours
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(Overcoat being any epoxy primer / undercoat or polyurethane undercoat / finish coat)							
<b>Application Conditions:</b>							
<b>Condition</b>	<b>Material</b>	<b>Surface</b>	<b>Ambient</b>	<b>Humidity</b>			
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%			
This product requires the substrate temperature to be above the dew point							

## SURFACE PREPARATION

All aluminium surfaces must be sound and free of oil, grease, dirt, lubricants or other compounds, loose and flaking paint, moisture and other foreign substances prior to application of AY&B Epoxy Aluminium Primer.

### **All Aluminium Surfaces: - Degrease:**

Aluminium surfaces must be degreased (either with Altex P40 Prepainting Cleaner, or Altex D30 Degreaser/Dewaxer), before being mechanically abraded or sandblasted. Wipe the surface with a clean, white cloth and check for any residual contaminants, and repeat cleaning process until all surfaces are thoroughly clean.

**Note:** Avoid contact between your skin and the prepared surface to eliminate contaminating the surface with oils.

### **Abrasion:**

Increasingly higher surface profiles are required as the thickness of the coating system increases. Incorporating any Epoxy Fairing Compound and / or AY&B Epoxy High Build Surfacer in the coating system will require a higher surface profile than a thin film, non faired system. Higher profiles are achieved by using a coarser sandpaper- typically 60 - 80 grit, or abrasive blasting.

For fairing systems or heavy duty exposures the recommended cleaning method is sweep abrasive blasting with fine, non-metallic garnet or similar media to attain a uniform matt finish. The surface profile should be 45-70 microns - similar in texture to 80 grit sandpaper.

For low film build systems (prime / undercoat / finish coat) finer sanding grades are acceptable (120 – 180 grit) For light duty non faired work (prime / finish coat), AY&B Epoxy Aluminium Primer provides good adhesion to degreased and Scotchbrite® abraded surfaces.

*(Scotchbrite® is a registered trademark of 3M Company)*

**ALL PREPARED SURFACES MUST BE COATED AS SOON AS POSSIBLE AFTER SURFACE PREPARATION – WITHIN 2 HOURS MAXIMUM.**

Larger projects will require staggered preparation and application techniques to avoid oxidation of the prepared surface.

*(This product and method of priming aluminium surfaces does not require the use of acid treatment to prepare the surface. We do not recommend the practice of acid etching for priming with AY&B Epoxy Aluminium Primer)*

## DIRECTIONS FOR USE

### **Mixing:**

AY&B Epoxy Aluminium Primer is a two-component product supplied in 500ml kits which contain the correct ratio of ingredients. The entire contents of each container must be mixed together.

Stir the Part A (base portion) first to obtain a smooth, homogeneous condition using a power stirrer. After mixing the base portion add the Part B slowly with continued stirring. After mixing is completed, proceed to Thinning as directed below.

The pot life of the mixed material is 12 hours at 25°C. Higher temperatures will reduce the working life of the coating; lower temperatures will increase it.

### **Thinning:**

Thinning is required for optimum film thickness control. For spray application, thin 50% by volume with Altex Thinning Solvent #12, i.e. 1:1:1 (Part A : Part B : Thinner) by volume.

For roller application, thin 10-15% with Altex Thinning Solvent #12.

### **Application:**

AY&B Epoxy Aluminium Primer is best applied by conventional spray. AY&B Epoxy Aluminium Primer may also be applied to small areas by brush and roller.

**Do not overbuild this product!** The correct film thickness is achieved when the surface first just attains a semi-transparent yellow colour.

### **Equipment:**

Suggested spray equipment is:

Air spray	<i>Graco</i> - Delta Air spray gun, 1.1-1.4mm (0.040-0.070") set up
	<i>De Vilbiss</i> - JGA gun, E Fluid Nozzle, 704 Air Nozzle

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

### **Clean-up:**

Use Altex Thinning Solvent #12

## PRECAUTIONS

For DIY 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 Aluminium Primer** 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.

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