



No.1 Epoxy Primer

Data Sheet

FEATURES

- Excellent adhesion to a wide variety of substrates
- Formulated for use above and below water - simplifies full hull painting projects
- Very long mixed pot life
- Excellent long term re-coatability
- Lead and chromate free
- Very rapid dust-free and touch dry response
- Iso-cyanate free
- Excellent anti-corrosive properties

RECOMMENDED USES

No.1 Epoxy Primer is the basis for High Performance marine systems.

Epoxy Primer No.1 is recommended for use as :

- Primer on suitably prepared steel, alloy, GRP and wooden substrates
- Multi-coat primer and self-build system
- Primer and seal coat for 421 epoxy fairing systems

No.1 Epoxy Primer may also be used to seal off prepared, aged coatings prior to repainting - refer also to No.4 Epoxy Sealer Undercoat.

No 1 Epoxy Primer is ideal for use below the water-line as a tie coat between aged epoxies and Altex Yacht & Boat Antifouling-

- No 5 Ablative
- No 10 Semi-Ablative
- Vivid
- Hydrocoat

Limitations. No.1 Epoxy Primer is a thin film adhesion primer. It is not designed for thick film application-apply at 50-75µm maximum. Further, it is not designed to be sanded-refer to No.2 High Build Sanding Surfacer and No.3 Primer Undercoat.

SPECIFICATION DATA

Generic Type:	Polyamide Epoxy
Colour:	Grey
Packaging:	1.25 litre and 5 litre (20 Litre-Aust Only) Two component kits
Mix Ratio:	4 to 1 by volume
Gloss:	Flat
Flash Point:	27°C
Thinner:	Spray E10 Thinner Brush/Roller U22 Thinner
Pot Life:	12 hours at 25°C
Induction Time:	15 minutes
Storage:	Store under cool, dry conditions

Density:	1.33 kg per mixed litre
Volume Solids (Mixed):	45%
Theoretical Coverage Rate:	9.0 sq metres per litre at 50 microns dry
Recommended Film Thickness Per Coat:	111 microns wet to obtain 50 microns dry
Application:	Spray, brush or roller
Dry Times (50 µm DFT / 25°C / 50% RH):	Touch Dry 1 Hr Hard Dry 8 Hrs
Recoat Times (50 µm DFT / 25°C / 50% RH):	Minimum 2 Hr with self, No.3 or No.5 Antifouling Maximum Aged 24 Hrs with Various Antifouling (see above) 3 months with self or No.3

SURFACE PREPARATION

Refer to the relevant Two Component Systems Guide.

Use No.1 Epoxy Primer on suitably prepared steel, aluminium, GRP, wood (preferably sealed with 421 Epoxy Timber Sealer) and freshly sanded epoxy fairing. Also use as the final coat under water before applying the anti-fouling.

All surfaces must be sound and free of oil, grease, dirt, form release agents, curing compounds, loose and flaking paint, moisture and other foreign substances prior to application of No1 Epoxy Primer.

Steel Surfaces:

Blast to near white metal, equivalent to Steel Structures Painting Council SP10 or Swedish Standard Sa 2.5. The steel profile after blasting should be 30 to 50 microns in depth and be of a jagged nature as opposed to a peen pattern.

SSPC SP3: Mechanical preparation/power tool cleaning. Mechanically abrade the surface with 60-80 grit discs to remove all aged, failed coatings and achieve a bright metal look with a pronounced texture/profile. Do not buff or polish the surface.

No 1 Epoxy Primer should be applied to the cleaned surface as soon as possible to prevent re-rusting or contamination.

Aluminium

Degrease all alloy surfaces with D30 Degreasing Solvent, using the two-rag method, one to apply the D30, the other to wipe the surface clean.

Abrade the surface using 80-120 grit, non-metallic discs or sandpaper, to achieve a roughened profile, similar to 80 grit sandpaper. Dedust with clean, dry air. Do NOT use rags to remove particles.

GRP/Epoxy Fairing.

Ensure all surfaces are freshly sanded, clean and free of dust residues.

DIRECTIONS FOR USE

Mixing:

No.1 Epoxy Primer is a two component product supplied in kits which contain the correct ratio of ingredients. The entire contents of each container must be mixed together.

Power mix Part A first to obtain a smooth, homogeneous condition. After mixing Part A add Part B slowly with continued agitation. Allow an induction time of 15 minutes before application.

The pot life of the mixed material is 24 hours at 20°C. Higher temperatures will reduce the working life of the coating; lower temperatures will increase it.

Thinning:

Thinning is normally required for spray application. Thin between 10% and 25% with E10 Thinner.

For brush/roller application, thin 5-10% with U22 Thinners.

Application:

No.1 Epoxy Primer can 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 – 1.4mm Fluid Nozzle
 De Vibiss - JGA gun, E or D Fluid Nozzle, 704/765 or 64 Air Nozzle

Airless Spray *Graco* - 30:1 pump, Contractor gun, 0.019-0.023" RAC IV tip

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

Clean-up:

Use E10 Thinner

PRECAUTIONS

See the Altex Coatings Limited General Safety Data Sheet, product label and Material Safety Data Sheet (MSDS) for health and safety information prior to use.

No.1 Epoxy 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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