



Altra~Bond 3094[®]

Strontium Chromate Epoxy Primer

Data Sheet

FEATURES

Advantages:

- Modified Epoxy Polyamide Primer - meets US Military specification MIL P - 23377D
- Rapid Dry-to-Recoat
- 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
- Can be used as the primer under all E~Line[®], Altra~Shield[®], Carboguard[®]504 and Carbothane[®] systems

Limitations of Use:

- Do not overbuild
- Do not exceed recoat window
- Do not sand
- Do not exceed 25 microns dry film build
- NOT suitable for below waterline / immersion service

RECOMMENDED USES

Altra~Bond 3094[®] is a two component epoxy primer designed for use on aluminium sheets and extrusions and galvanised substrates. It has

- Excellent adhesion and anti- corrosive properties
- Fast dry to recoat
- Compatibility with high performance epoxy and urethane systems

Altra~Bond 3094[®] is ideal as

- A primer for aluminium topsides, alloy hulls and a general primer for trailed alloy boats
- A primer for the exterior of petrol and bulk "dolphin" tanks
- A primer for signwriting on alloy surfaces

Altra~Bond 3094[®] is also

- An excellent general purpose aviation primer

SPECIFICATION DATA

Coating Type:	Modified Polyamide Epoxy
Colour:	Translucent Yellow
Packaging:	2 litre two component kits
Mix Ratio:	1 to 1 by volume
Gloss:	Low Sheen
Flash Point:	27°C Setaflash
Thinner:	Altex Thinning Solvent #12
Pot Life:	12 hours at 25°C
Induction Time:	Not required
Storage:	Store under cool, dry conditions
Shelf Life:	2 years in original unopened container

Density:	1.105 kg per litre
VOC:	585 grams per mixed litre
Temperature Resistance:	80°C Dry
Volume Solids (Mixed):	30%
Theoretical Coverage Rate:	15 sq metres per litre at 20 microns dry
Recommended Film Thickness Per Coat (mixed and thinned at recommended 1:1:1 ratio):	100 microns wet to obtain 20 microns dry
Application:	Conventional Air Spray
Dry Times (25°C / 20 µm DFT / 50% RH):	
Touch Dry	10-20 minutes
Optimum Recoat	3 hours
Maximum Recoat	24 hours

SURFACE PREPARATION

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 Altra~Bond 3094®.

Aluminium and Galvanised Surfaces:

Recommended cleaning of surface is light abrasive blasting with fine, washed, non-metallic media to attain a uniform matt finish.

Where abrasive blasting cannot be undertaken, abrasion by means of disc grinders and/or other powertools, using non metallic media with a grit range of 60-120 grit will achieve clearly discernible surface profile. The greater the film builds intended, the greater than profile required.

Altra~Bond 3094® provides good adhesion to degreased and Scotchbrite® abraded surfaces, and this preparation is adequate for thin film systems.. Do not apply over dichromate passivated galvanising.

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DIRECTIONS FOR USE

Mixing:

Altra~Bond 3094® is a two component product supplied in 2 litre kit which contains the correct ratio of ingredients. Equal volumes of each component must be mixed together.

Stir the base portion first to obtain a smooth, homogeneous condition using a power stirrer. After mixing the base portion, measure out the required volume of base into a clean mixing container, and add the converter 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. Thin 50% by volume with Altex Thinning Solvent #12, ie 1:1:1 (Base:Converter:Thinner).

Application:

Altra~Bond 3094® is usually applied by conventional spray. Altra~Bond 3094® may also be applied to small areas by brush and roller.

Suggested spray equipment is:

Air spray Graco - Delta Air spray gun, 1.8mm (0.070") set up
De Vilbiss - JGA gun, E Fluid Nozzle, 704 Air Nozzle

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

The correct film thickness is achieved when the surface first just attains a yellow colour.

Clean-up:

Use Altex Thinning Solvent #12.

PRECAUTIONS

For Professional use only. This product contains Strontium Chromate. See the Altex Coatings Limited General Safety Data Sheet, product label and Safety Data Sheet (SDS) for health and safety information prior to use.

Altra~Bond 3094® 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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