

## 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

**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 m<sup>2</sup>/L at 50 microns  
8.5 m<sup>2</sup>/L at 75 microns  
6.4 m<sup>2</sup>/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<br>(Cyclic Prohesion Testing) | Excellent after 2,500 hours of exposure |
| Immersion Resistance<br>(5% Salt Solution)          | Excellent after 2,500 hours of exposure |

## SUBSTRATES & SURFACE PREPARATION

|                |   |
|----------------|---|
| <b>General</b> | All surfaces must be sound and free of oil, grease, dirt, loose and flaking paint, moisture, and other foreign substances prior to application of Altra~Zinc <sup>®</sup> 605.<br>Clean and/or degrease with either a suitable non-ionic detergent (such as Altex P40 Cleaner), or solvent wipe with Altex C50 Surface Cleaner.   |
| <b>Steel</b>   | For optimum results, abrasive blast to SSPC-SP 10/NACE No.2 (AS 1627.4 Sa 2½)<br>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.<br>Satisfactory results will be achieved by abrasive blasting to SSPC-SP 6 (AS 1627.4 Sa 2).<br><br>For small areas, power tool cleaning to SSPC-SP 3 (AS 1627.2 St 3) may be utilised. |

## MIXING & THINNING

|                 |  |
|-----------------|--|
| <b>Mixing</b>   | 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 <sup>®</sup> 605, in winter conditions allow 15 minutes induction time.   |
| <b>Thinning</b> | Thinning may be required. Thin up to 15% with Altex Thinning Solvent #12.<br>For brush / roller application, thin with Altex Thinning Solvent #25.<br><br>Note: Excessive thinning can cause low film thickness, sagging and other film defects.<br><br>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. |
| <b>Ratio</b>    | 4:1 by volume  |
| <b>Pot Life</b> | 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.

|                                     |   |
|-------------------------------------|---|
| <b>Spray Application (General)</b>  | The preferred method of application is spray.   |
| <b>Conventional Spray</b>           | 1.6mm to 2.8mm fluid tip with appropriate air cap.  |
| <b>Airless Spray</b>                | Pump Ratio      30:1<br>Material Hose    3/8" I.D min<br>Tip Size          0.017 – 0.021<br><br>(Note: The above is a guide. Other equipment to the above may be used.) |
| <b>Brush &amp; Roller (General)</b> | 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

## 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** | 12 months

**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.

Data sheets may change from time to time and it is your responsibility to ensure you have the latest product datasheet and material safety data sheet from your supplier. Check the data sheet date with the listings at [www.altexcoatings.com](http://www.altexcoatings.com) Altex Terms and Conditions of Trade, available at [www.altexcoatings.com](http://www.altexcoatings.com), apply in respect of all coating products and materials supplied, including samples.