

# light industrial systems guide

Altex Coatings systems based on the requirements of ASNZ2312:2002

TYPICAL COATING SYSTEMS – MILD STEEL									DURABILITY – YEARS TO 1ST MAINTENANCE							
AS2312: 2002 System	Preparation Standard	1st Coat		2nd Coat		3rd Coat		Total	Atmospheric Corrosivity Category – AS2312: Performance							
		Name	DFT	Name	DFT	Name	DFT		A Very Low	B Low	C Medium	D High	E-M Very High Industrial	E-M Very High Marine	F Tropical	
<b>ACRYLIC – Two pack, solvent borne</b>																
ACC1	ST 3	AS 2024	125	EL 239	75			200		10-15	5-10	2-5				5-10
ACC2	Sa 2	AP 514	75	239	75			150	40+	15-25	10-15	5-10	2-5	2-5	10-15	
ACC4	Sa 2 1/2	AP 514	75	AS 2024	125	EL 239	75	275		25-40	10-15	5-10	2-5	2-5	10-15	
ACC6	Sa 2 1/2	AZ 605	75	AS 2024	200	EL 239	75	350		25-40	15-25	10-15	5-10	5-10	15-25	
<b>ALKYD</b>																
ALK2	ST 3	D-Prime	75					75	25-40	5-15	2-5					2-5
ALK3	Sa 2	D-Prime	75	D-Fast	40			115	25-40	10-25	5-10	2-5				2-5
<b>EPOXY – High Build</b>																
EHB1	Sa 2 1/2	AS 2024	125	AS 2024	125			250	40 +	15-40	10-15	5-10	2-5	2-5	10-15	
EHB2	Sa 2 1/2	AS 2024	200	AS 2024	200			400		25-40	15-25	10-15	10-15	5-15	15-25	
EHB3	Sa 2 1/2	AP 514	75	AS 2024	200			275		25-40	15-25	5-15	5-15	5-15	15-25	
EHB6	Sa 2 1/2	AZ 605	75	AS 2024	125	AS 2024	125	325		25-40	15-25	10-25	10-15	10-25	10-25	
<b>POLYURETHANE – Two pack, solvent borne</b>																
PUR1	ST 3	AS 2024	125	EL 239	75			200		10-15	5-10	2-5				5-10
PUR2	Sa 2 1/2	AP 514	75	EL 239	75			150	40 +	15-25	10-15	5-10	2-5	2-5	10-15	
PUR3	Sa 2 1/2	AP 514	75	AS 2024	125	EL 239	75	275		25-40	15-25	10-25	5-10	5-10	15-25	
PUR4	Sa 2 1/2	AZ 605	75	AS 2024	125	EL 239	75	275		25-40	15-25	10-15	5-10	5-10	15-25	
PUR5	Sa 2 1/2	AZ 605	75	AS 2024	200	EL 239	75	350		40 +	25-40	15-25	10-15	10-15	25-40	

PRODUCT KEY		
Product Key	Product Names	Colours
D-Prime	Duroprime HB	Red Oxide, Light Grey
D-Fast	Durofast	AS2700, BS5252 colour range
AZ 605	Altra~Zinc 605	Grey
AP 514	Altra~Prime 514-ZP	Light Grey
AS 2024	Altra~Shield 2024	AS2700, BS5252 colour range
EL 239	E~Line 239	AS2700, BS5252 colour range

CODE KEY	
Preparation Standard	Definition
ST 3	Hand or Powertool clean
Sa 2	Abrasive blast to commercial standard
Sa 2 1/2	Abrasive blast to near white

## Single Pack Systems

Surface	Surface Preparation	Prime	Protect	Finish
Steel	Power Tool ST 3 or Abrasive Blast Class Sa 2	Duroprime HB	Duroprime HB Hammerfinish or Durafast Enamel	Hammerfinish or Durofast Enamel
Timber	Abrade to a matt finish approximating a surface texture of 80 git sandpaper	Multibond		
Fibreglass				
Plastic				
Galvanised	Degrease SP 1 Hand abrade or abrasive sweepblast to a matt finish	Altra~Etch		
Aluminium				

## Two Pack Systems

Surface	Surface Preparation	Prime	Protect	Finish
Steel	Abrasive blast Class Sa 2	Altra~Zinc 605	Altra~Shield 2024 or Altra~Build 520	E~Line 239
Galvanised	Hand abrade or abrasive sweepblast to a matt finish	Altra~Prime 514 ZP		
Aluminium				
Fibreglass	Hand/mechanical sand			

### CODE KEY

Prep	Definition
ST 3	Hand or Powertool clean
Sa 2	Abrasive blast to commercial standard
Sa 2 1/2	Abrasive blast to near white
SP 1	Solvent wipe to remove all surface contamination