

## SELECTION & SPECIFICATION DATA

<b>Generic Type</b>	Phenalkamine epoxy
<b>Description</b>	Corrosion and water resistant high performance, chemically cured, sandable epoxy coating, It can be used as a tie-coat over suitable prepared, aged epoxies and polyurethanes. Suitable for Industrial and Marine situations.
<b>Features</b>	<ul style="list-style-type: none"> <li>• Excellent surfacing and sanding properties</li> <li>• Isocyanate free</li> <li>• Very good chemical resistance</li> <li>• Self-priming onto suitably prepared steel</li> <li>• Long pot-life</li> </ul>
<b>Colour</b>	Off White
<b>Finish</b>	Low sheen
<b>Dry Film Thickness</b>	100-125 microns. Can be applied at 150 microns in two passes..
<b>Solids Content</b>	By volume 45%
<b>Theoretical Coverage Rate</b>	4.5 m <sup>2</sup> /L at 100 microns 3 m <sup>2</sup> /L at 150 microns Allow for loss in mixing and application.
<b>VOC Values</b>	<b>As Supplied</b> : 468 g/L
<b>Dry Temp. Resistance</b>	Continuous: 90°C Non-Continuous: 121°C
<b>Topcoats</b>	Multi-Gard GP 48 <sup>AU</sup> , GP 88 <sup>AU</sup> , Carbothane 134 HG or 133 LH
<b>Limitations</b>	May change colour and chalk when exposed to direct sunlight. This does not affect the protective properties of the coating.

## SUBSTRATES & SURFACE PREPARATION

<b>General</b>	All surfaces to be coated should be clean, dry and free from contamination. Oil or grease should be removed in accordance with AS1627.1 (SSPC-SP 1) solvent cleaning.
<b>Steel</b>	<u>Minimum</u> : AS 1627.4 Sa 2 (SSPC-SP 6) with a 35-75 micron surface profile Prime all power tool or hand tool cleaned surfaces as recommended by Technical Services.
<b>Galvanised Steel</b>	Sweep abrasive blast to SSPC-SP 16 using non-metallic media to achieve a uniform surface profile of between 20 and 50 microns.
<b>Previously Painted Surfaces</b>	Lightly sand or abrade to roughen and degloss the surface. Existing paint must attain a minimum 3B rating in accordance with ASTM D3359 "X-Scribe" adhesion test.

## MIXING & THINNING

<b>Mixing</b>	Thoroughly mix each component separately, then combine and mix well using mechanical agitation. DO NOT MIX PARTIAL KITS. <u>Induction Time</u> : Allow 15 minutes induction time at 10-15°C. Do not mix more than can be applied during the product's useful pot life.
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**MIXING & THINNING**

<b>Thinning</b>	Thinning requirement will vary depending upon conditions. Thin with Thinning Solvent #12 as required for good atomisation; typically no more than 10%.  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>	Pressure pot equipped with dual regulators, 9mm (3/8") I.D. minimum material hose, 1.2mm to 1.8mm fluid tip and appropriate air cap.
<b>Airless Spray</b>	Pump Ratio: 30:1 (min.)* Output: 10 litres/min (min.) Material Hose: 9mm (3/8") I.D. (min.) Tip Size: 0.015-0.019" Output PSI: 2100-2400 Filter Size: 60 mesh *Teflon packings are recommended and available from the pump manufacturer.
<b>Brush &amp; Roller (General)</b>	Multiple coats may be required to obtain desired appearance, recommended dry film thickness and adequate hiding. Avoid excessive rebrushing or re-rolling.  In cooler temperatures (<20°C), try to avoid thinning to assist in achieving film build. In warmer temperatures, thin judiciously with Thinning Solvent #22. Excess thinning will compromise build properties.

**APPLICATION CONDITIONS**

Condition	Material	Surface	Ambient	Humidity
Minimum	10°C	10°C	10°C	0%
Maximum	32°C	50°C	50°C	95%

Industry standards are for substrate temperatures to be above the dew point.

## CURING SCHEDULE

Surface Temp.	Dry to Sand	Dry to Recoat	Dry to Topcoat with Polyurethane	Maximum Cure Time to Topcoat (with sanding)
10°C	24 Hours	10 Hours	12 Hours	8 Days* Refer to notes below
15°C	12 Hours	8 Hours	10 Hours	
25°C	6 Hours	6 Hours	6 Hours	
30°C	6 Hours	5 Hours	6 Hours	

These times are based on a 100-150 micron dry film thickness. Higher film thickness, insufficient ventilation, or cooler temperatures will require longer cure times and could result in solvent entrapment and premature failure.

**\*Notes:** Dry to sand times will increase with higher film builds, and/or lower temperatures. Multi-Gard GP 33<sup>AU</sup> must be topcoated within 8 days of application. Any sanding should be carried out no more than 2 days before topcoating. If top coating is not achieved within 8 days then the Multi-Gard GP 33<sup>AU</sup> must be thoroughly sanded with a coarse grade sandpaper (80-180grit) and reapply a coat of Multi-Gard GP 33<sup>AU</sup>.

## SANDING GUIDELINES

<b>Hand Sanding</b>	Multi-Gard GP 33 <sup>AU</sup> is normally hand sanded with 220 grit (for further undercoating), followed by 320 grit sandpaper prior to topcoating.
<b>Orbital Sanding</b>	Up to 280 grit for finish coating with recommended topcoats. We recommend 3M Free-Cut® Gold or Norton NoFil®, (or equivalent) Zinc Stearate, or Calcium Stearate sandpapers for optimised sanding and self-cleaning. Attempting to orbital sand with 320 grit or finer will impair sanding properties and polish the surface.

## CLEANUP & SAFETY

<b>Cleanup</b>	Use Altex Thinning Solvent #12 or #2
<b>Safety</b>	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.
<b>Ventilation</b>	It is very important for the safety of the applicator and the proper performance of this product 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

<b>Shelf Life</b>	Part A and B: 24 months at 24°C Actual stated shelf life when kept at recommended storage conditions and in original unopened containers
<b>Pack Sizes</b>	5 litre and 10 litre kits
<b>Storage Temperature &amp; Humidity</b>	Store under cool, dry conditions. 4-38°C 0-95% RH
<b>Flash Point (Setaflash)</b>	Part A and B: 26°C
<b>Storage</b>	Avoid large fluctuations between high and low temperatures. Avoid the formation of condensate due to low temperatures.

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## WARRANTY

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### 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)  
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