



Multi~Bond Primer

Multi-Purpose Primer Undercoat

FEATURES

Advantages:

- Excellent anti-corrosive/protective primer for most substrates in industrial and marine exposures
- Excellent adhesion
- Suitable for use in below water systems
- Lead and chromate free
- Single package
- Easy application by brush, roller or spray

Limitations of Use:

- Not recommended for use on aluminium substrates
- Not recommended for immersion service on galvanised steel

RECOMMENDED USES

Multi~Bond Primer is a premium quality primer designed for general purpose use.

Multi~Bond Primer may be used:

- Applied directly to suitably prepared steel, galvanised steel, wood and GRP
- Above water - overcoated with a sandable undercoat (Altex Isotal Undercoat) and normally topcoated with Isotal Enamel
- Below water – in multiple coats as part of a marine protective system where it is normally overcoated with Sea~Barrier™ 1000, 3000 or 4000 anti-fouling

Multi~Bond Primer is recommended for:

- Agricultural equipment
- Timber yachts and launches (above and below the waterline)
- On site touch-up work-handrails etc
- Restoration of timber joinery

SPECIFICATION DATA

Coating Type:	Pigmented Blend of Proprietary Synthetic Water Resistant Resins
Colour:	Light Grey
Packaging:	NZ & Aust: 1 and 4 litres Single component
Gloss:	Matt
Mix Ratio:	N/A
Pot Life:	N/A
Flash Point:	36°C Setaflash
Thinner:	Altex Thinner #45 – Brush (formerly T48) Altex Thinner #53 – Spray (formerly S53)
Storage:	Store under cool dry conditions

Density:	1.5 kg per litre
VOC:	433g per litre
Volume Solids:	46 ±1 %
Theoretical Coverage Rate:	9.2 sq metres per litre at 50 microns DFT
Recommended Film Thickness Per Coat:	108 microns wet to obtain 50 microns dry
Application:	Spray, brush or roller
Dry Times (25°C / 50µm DFT / 50% RH):	
Touch Dry	- 1½ hours
Hard Dry	- 24 hours
Recoat Min	
Self	- 4 hours
Anti- foul	- 12 hours
Alkyds	- 4 hours
Recoat Max	
Self	- 1 month
Antifoul	- 1 month
Alkyds	- 1 month

SURFACE PREPARATION

All surfaces must be sound and free of oil, grease, dirt, chemicals, salt, loose and flaking paint, moisture and other foreign substances prior to application of Multi-Bond Primer.

Steel Surfaces:

For optimum results, abrasive blast to AS1627.4, Class 2½. (SSPC SP10). Satisfactory results will be achieved by abrasive blasting to AS1627.4 Class 2 (SSPC SP6). 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.

For mild conditions power tool cleaning to AS 1627.2 (SSPC SP3) may be satisfactory. (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. Avoid buffing or polishing the surface.) Apply Multi-Bond to the prepared surface as soon as possible to avoid re-rusting.

Galvanised Surfaces

Clean with Altex P40 Prepainting Cleaner, or solvent wipe with Altex C50 Surface Cleaner in accordance with AS1627.1 (SSPC SP1) solvent cleaning.

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

Alternatively, orbital sand with 80 grit sandpaper to achieve a matte surface with a clearly defined anchor pattern.

Ensure all galvanised surfaces are free of dichromate passivation treatment.

GRP and Wooden Surfaces:

GRP and wood should be thoroughly sanded with 80-120 grit paper. Dry timber can be pre-sealed with 421 Epoxy Resin, thinned 25% with Altex Thinner #12, or Altex Yacht & Boat 421 Epoxy Timber Sealer.

DIRECTIONS FOR USE

Mixing:

Use mechanical agitation for proper mixing to ensure homogeneous condition. Stir until thoroughly mixed.

Thinning:

Multi-Bond Primer is generally applied unthinned.

For spray application thin up to 10% with Altex Thinner #53 (formerly S53).

For brush/roller application thin with Altex Thinner #45 (formerly T48).

Note: Excessive thinning can cause low film thickness, sagging and other film defects.

Application:

Multi-Bond Primer may be applied by brush, roller or spray.

When spray applied Multi-Bond Primer should be applied in one wet coat, overlapping each pass 50%.

Suggested spray equipment:

Conventional Air Spray

1.4mm to 1.8mm Fluid tip with appropriate air cap

Airless Spray

Pump Ratio	30:1
Material Hose	3/8" I.D min
Tip Size	0.015 – 0.019

(Note: The above is a guide. Other similar equipment to the above may be used.)

Clean-up:

Use Altex Thinner #45 or #53.

PRECAUTIONS

For industrial use only: Read and follow all the caution statements on this Product Data Sheet, the product label and the Material Safety Data Sheet (MSDS) for health and safety information prior to use.

Multi-Bond 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.

ALTEX COATINGS LIMITED

Head Office
New Zealand
91 - 111 Oropi Road
Greerton, Tauranga
PO Box 142
Tauranga Mail Centre

Phone: +64 7 5411 221
Fax: +64 7 5411 310

www.altexcoatings.com

Head Office
Australia
7 Production Avenue
Molendinar
Queensland 4214
Australia

Phone: +61 7 5512 6600
Fax: +61 7 5512 6697

www.altexcoatings.com

DISCLAIMER

This is not a specification and all of the information is given in good faith. Since conditions of use are beyond the control of the manufacturer, information contained herein is without warranty, implied or otherwise, and final determination of the suitability of any information or material for the use contemplated, the manner of use and whether there is any infringement of patents is the sole responsibility of the user. The manufacturer does not assume any liability in connection with the use of the product relative to coverage, performance or injury. For application in special conditions, consult the manufacturer for detailed recommendations.

It is the users' responsibility to ensure they have the latest product data sheet and Material Safety Data sheet. Check the data sheet date with the listings at www.altexcoatings.com.