

Epoxy Surtol Aluminium Fast

Solvent based, surface tolerant epoxy primer

A two component, medium solids, amine cured, zinc phosphate & aluminium pigmented epoxy primer.

Intended Uses:

A general-purpose epoxy primer that is surface tolerant i.e. which can be applied to hand prepared surfaces. It is used as a heavy-duty primer/intermediate coat, which can also be over-coated by a variety of topcoats such as epoxies, polyurethanes, alkyds & acrylics.

Suitable for application to steel roofing, structural steel, agricultural and earth moving equipment, construction equipment, tank & pipe externals & processing equipment.

Suitable substrates are mild steel, stainless steel and alloys, galvanized steel, aluminium, GRP, thermoset polyester coatings. Epoxy Surtol Aluminium Fast has a long overcoating window and rapid curing properties.

Properties:

- Excellent adhesion to various substrates.
- Excellent water and corrosion resistance.
- Excellent recoat ability.
- Exhibits good physical properties such as adhesion to steel and impact resistance.
- Resistant to humidity, salt water and exterior exposure conditions.
- Cures at temperatures down to +5°C.
- Surface tolerant.
- Medium-high solids.

Technical Data:

Colour	Aluminium grey
Finish	Smooth semi-matt
Mix Ratio (Volume)	4 : 1
Activator	Epoxy Activator Multi
Density	1.3 Kg/ Litre
Volume Solids (Volume)	57%
Typical Film Thickness	75 – 150µm DFT
Theoretical Coverage	7.6 m ² / Litre @ 75µm DFT, allow for loss factors
Method of Application	Brush, roller, or spray
Temperature Resistance	Dry continuous – 150°C
Number of Coats	1 – 2 by brush or spray

Drying Information:

	0°C	5°C	10°C	20°C	30°C	40°C
Touch Dry	-	8 hrs	5 hrs	2 hrs	1 hr	45 min
Hard Dry	-	13 hrs	6 hrs	4 hrs	2 hrs	1 hr
Full Cure	-	21 days	14 days	7 days	5 days	3 days
Overcoating Data – See Limitations						
Substrate Temp.	0°C	5°C	10°C	20°C	30°C	40°C
Minimum	-	13 hrs	6 hrs	4 hrs	2 hrs	1 hr
Maximum*	7 days					

Note:

* See Specialized Coating Systems Definitions & Abbreviations – If over coating times are exceeded, the surface must be high pressure cleaned, sweep blasted or abraded prior to re-coating.

Surface Preparation:

Degrease surfaces with Hydrosolve Degreasers followed by a high-pressure water rinse. Grind and fettle weld spatter, protrusions, and sharp edges. All surfaces must be dry and clean.

Steel

All surfaces shall be abrasive blast cleaned to grade SA 2 ½ of standard ISO 8501-1 with a blast profile of 30 – 50µm. The coating must be applied before any flash rusting occurs or the surface shall be re-blast cleaned. Alternatively abrade the surface thoroughly using grinding disks to achieve a similar profile. Hand prepared surfaces are also suitable, wire brush surface to remove any surface contamination or scale.

Galvanizing

New Galvanizing – degrease using Galvanized Iron Cleaner and rinse. Roughen up using 100 # sandpaper or lightly flash blasting.

Old Galvanizing – abrade or abrasive blast clean with ultra-fine grit to remove corrosion product.

Application:

Mixing	Material is supplied in two containers as a kit. Always mix a complete kit in the quantities supplied. Once mixed the product should be used within the pot life specified.		
	Stir the base component well with a flat-bottomed paddle or mechanical mixer until product is uniform. Continue stirring and add the entire contents of the activator container. Continue stirring until the mixture is homogeneous.		
	Ensure that just sufficient material be mixed so that the product can be applied within its use-able life.		
	The temperature of the mixed product should preferably be above 10°C.		
Pot Life	10 hours at 15°C 8 hours at 20°C 5 hours at 30°C 4 hours at 35°C		
Thinner	SA65 Thinners	0 – 20% depending on application	
Airless Spray	Tip range 15 – 21 Thou. Pressure at the tip should not be less than 150 bar (2200 PSI).		
Air Spray	Recommended	Gun	Pressure/Gravity Feed
		Fluid Tip	1.6mm to 1.8mm
Brush/Roller	Suitable	Typically, 40 – 50µm can be achieved	

Clean Up	Clean all equipment immediately after use with SA65 Thinners . It is good working practice to periodically flush out the spray equipment during the course of the working day. Frequency of cleaning will depend upon the amount sprayed, temperature and elapsed time, including delays
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Environment:

	Surface Temperature	Ambient Temperature	Relative Humidity
Minimum	5°C*	5°C	No lower limit
Maximum	45°C	45°C	85%

* Or 3°C above dew point

Limitations:

- In common with all epoxies, Epoxy Surtol Aluminium Fast will chalk and discolour on exterior exposure. However, these phenomena are not detrimental to long term overcoating properties.
- Overcoating information is given for guidance only and is subject to local climate and environmental conditions. Consult a Specialized Coating Systems representative for specific recommendations.
- Test performance results were obtained in a controlled laboratory environment and Specialized Coating Systems makes no claim that the exhibited published test results, or any other tests, accurately represent results found in all field environments. As application, environmental and design factors can vary, due care should be exercised in the selection and verification of the performance and use of the coating.

Pack Size:

5 & 20 Litre.

Storage:

- Shelf Life:
 - Part A: 24 months minimum at 25°C from date of manufacture. Subject to inspection thereafter.
 - Part B: 12 months minimum at 25°C from date of manufacture. Subject to inspection thereafter.
- Store in dry conditions out of direct sunlight, away from sources of heat or ignition.

Precautions:

For complete safety and handling information please refer to the appropriate Safety Data Sheets prior to using this product.