

ANCILLARY PRODUCTS

DATASHEETS



C50 Surface Cleaner & D30 Degreaser/Dewaxer

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FEATURES		RECOMMENDED USES	
<u>C50 Surface Cleaner:</u> Advantages: • Mild cleaning action will not damage cured, solvent sensitive primers/undercoats prior to finish coating. • Enhances the removal of sanding residues - a key component in ensuring good adhesion and a defect free finish. • Will not damage masking tape edges • Removes masking tape adhesive and moisture residues • Slow evaporation “tail” enhances ability to lift contaminants easily. Equally useful in summer conditions. <u>D30 Degreaser/Dewaxer:</u> Advantages: • Strong cleaning action to remove ingrained oils and grease. • Removes waxes from aged painted surfaces - these waxes can melt and be spread by sanding without removing them first • Excellent alternative where water-based cleaners are not suitable. • Leaves mild steel, aluminium, bronze, and other ferrous and non-ferrous metals oil free prior to abrasion.		<u>C50 Surface Cleaner:</u> C50 Surface Cleaner is a specialised solvent borne cleaner designed for the following uses: • To wipe down freshly applied coatings prior to sanding, and prior to re-coating and/or topcoating. • Designed to aid removal of mild fingerprint oils, wind-blown salts & residual sanding dust. • To remove unseen moisture residues. <u>D30 Degreaser/Dewaxer:</u> D30 Degreaser/Dewaxer is designed to remove more persistent surface contamination, oils and grease in industrial environments, marine situations, as well as wax from finish coats on pleasure craft topcoat surfaces. • Will remove most common oil/grease contaminants from most surfaces prior to sanding/sandblasting • Dissolves waxes and other surface polishes • Excellent for wiping aluminium fabrications to remove residual oils prior to abrading. D30 Degreaser/Dewaxer is a more aggressive cleaner than the C50 Surface Cleaner.	
SPECIFICATION DATA			
Product Type: C50: Specially formulated solvent-based cleaning blend D30: Aromatic and aliphatic solvents Colours: Clear liquids Availability: C50: New Zealand only D30: New Zealand and Australia Packaging: 1, and 4 Litre 20 Litre (New Zealand only) Flash Point: C50: 33°C Setaflash D30: 13°C Setaflash Storage: Store under cool, dry conditions		Density: C50: 0.89 kg per litre D30: 0.81 kg per litre Shelf Life: C50: 60 months at 24°C D30: 60 months at 24°C Shelf Life: (actual stated shelf life) when kept at recommended storage conditions and in original unopened containers. For products/components exceeding the stated shelf life, contact Technical Services for further advice. See overleaf for more detailed directions on use.	

DIRECTIONS FOR USE

C50 Surface Cleaner:

C50 Surface Cleaner is used to wipe down any undercoat after sanding has been completed to remove the following potentially invisible contaminants:

- Sanding dust
- Light fingerprints (skin oils)
- Residual salts (common in Marina hard stand environments)

If the undercoat has cured sufficiently to sand, then it is generally able to be cleaned with C50 Surface Cleaner without risk of marring the surface.

Partially cured coatings are susceptible to surface marring with any cleaner.

C50 Surface Cleaner may also be used prior to sanding aged coatings to remove light surface contamination.

Caution must be exercised when using thinning solvents as cleaning agents, as these more aggressive solvents will often dissolve and spread the oils. A true surface cleaner will allow the contamination to be lifted from the surface, thus allowing removal with a second rag.

We strongly recommend the use of the two-rag method, as described adjacent for cleaning the surface.

D30 Degreaser/Dewaxer:

D30 Degreaser/Dewaxer is used to remove both wax and grease/oil from substrates, painted surfaces (aged or new), steel, aluminium, and various other metal surfaces.

It is a more aggressive degreaser than C50 Surface Cleaner and should not be used on freshly cured undercoats.

D30 Degreaser is suitable for use to remove industrial grade grease and oils, including diesel, in both Commercial Shipping and Industrial situations.

Once the bulk of grease/oil has been removed (usually with multiple rags, soaked in D30 degreaser/Dewaxer, and disposed after wiping), use the two-rag method as described below to remove the final residues.

Two-Rag Method:

Ensure all sanded surfaces have been thoroughly dedusted before using any liquid cleaner. Blow down with clean, dry air and dust with clean cotton rags to remove sanding residues.

Saturate a clean, cotton rag in the selected product and apply liberally to the surface. Clean an area no greater than 0.5m² to avoid the surface drying before completion.

With a second, clean rag, wipe off the cleaner residues, rolling the cloth to ensure new, clean rag surfaces are used to wipe and lift the solution off the substrate.

Repeat the above steps over the entire surface, changing rags frequently to remove the contamination from the work site.

Ensure that you wear clean gloves during this process.

PRECAUTIONS

For Industrial & DIY use: 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.

C50 & D30 are 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.

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 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
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SELECTION & SPECIFICATION DATA

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Generic Type	Two-component abrasion resistant ceramic epoxy novolac matrix
Description	CAR 300 is an epoxy novolac ceramic system for the repair of steel surfaces subject to erosion, corrosion and chemical attack. CAR 300 will provide a surface that should also improve flow and equipment efficiency. It may be applied in a single coat application up to 400 microns dry without slumping. Multiple coats will be necessary in extreme circumstances.
Features	• CAR 300 is recommended for quick repair and lining of steel surfaces exposed to wear and chemical attack, i.e. impellers, pipes, valves & pump casings • Excellent abrasion resistance • Easy to apply by brush or roller to achieve a smooth finish • An optional Part C is available for additional reinforcement when a paste is required
Colour	Grey & Blue
Finish	Semi-Gloss
Film Build	When brushing and rolling, 200 to 400 microns per coat is recommended. For spray application, a thickness of 200 microns per coat is recommended. Do not exceed 600 microns dry per coat. If higher thicknesses are required, the product may be reinforced with a non-woven fiberglass to form a laminate. The use of laminates is a prerequisite for concrete lining.
Solid(s) Content	By Volume 98% ± 2%
Theoretical Coverage Rates	4.9 m²/litre at 200 microns dry 2.45 m²/litre at 400 microns dry NOTE: Material losses during mixing and application will vary and must be taken into consideration when estimating job requirements
Dry Temp. Resistance	Continuous: 190°C (374°F)
Limitations	• Not recommended for engine components. • Epoxies lose gloss and eventually chalk in sunlight exposure.
Temperature Resistance (Immersion)	Performance is dependent on actual chemical exposure. Refer to Altex Coatings Technical Department. Most aqueous solutions: 110°C

SUBSTRATES & SURFACE PREPARATION

General	Surfaces must be clean and dry. Employ adequate methods to remove dirt, dust, oil and all other contaminants as described in SSPC-SP 1 (AS 1627.1).
Steel	Dry abrasive blast to SSPC-SP 10 (AS 1627.4 Sa 2½) and achieve a uniform jagged blast profile of 50µm (minimum) and up to 75µm. For mild environments, power tool clean all surfaces to SSPC-SP 3 (AS 1627.2 St 3).

CAR 300

PRODUCT DATA SHEET



MIXING & THINNING

Mixing	For best results, the contents of the tin should be mixed together for approximately 4 to 5 minutes using a power mixer. DO NOT mix partial kits - Mix full kits only.
Thinning	A small amount of Altex Thinning Solvent #76 (2 to 5%) may be used to improve flow and levelling when brushing, rolling or spray applying. If to be applied by spray, consult Altex Coatings Technical department for specific equipment recommendations in writing.
Pot Life	30 Minutes at 25°C and less at higher temperatures. Pot life ends when coating becomes too viscous to use.

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.

General	Do not attempt to install material if temperatures of material and substrate are not within the recommended ranges. The curing time and application properties of the material are severely affected by temperature changes. Do not use water or steam in the vicinity of the application. Moisture can seriously affect the working time and other properties.
Spray Application (General)	Refer to Altex Coatings Technical Department for further information
Brush & Roller (General)	Using a brush or roller, apply product to the desired thickness. If mixed material is left in the container, it will become unusable within 30 minutes, depending on the temperature. If further build-up of coating is required, light abrasive blast or sand the cured surface to create a clear discernible surface profile for improved adhesion. A reinforcing fabric such as woven glass fibre can be bedded into the CAR 300 and overcoated immediately when additional support is required. Clean equipment immediately after use with Altex Thinning Solvent #12 and rinse off in clean water. Wash between coats with potable water and dry with clean cloth prior to overcoating.

APPLICATION CONDITIONS

Condition	Material	Surface	Ambient	Humidity
Minimum	16°C (61°F)	16°C (61°F)	10°C (50°F)	0%
Maximum	32°C (90°F)	32°C (90°F)	40°C (104°F)	85%
Optimum	24°C (75°F)	22°C (72°F)	22°C (72°F)	45%

Do not apply when the surface temperature is less than 3°C above the dew point.

Do not use water or steam in the vicinity of the application. Moisture can seriously affect the working time and other properties. Full cure will not be achieved and performance will be affected.

CURING SCHEDULE

Surface Temp.	Dry to Handle	Dry to Touch	Dry to Recoat	Final Cure
25°C (77°F)	8 Hours	2 Hours	12 Hours	48 Hours

Curing schedule is based on 200-400 microns DFT at 50% RH.

Wash between coats with potable water and dry with clean cloth prior to overcoating.

Post curing at 60°C for 4 hours will accelerate the cure rate to full cure status. This process must be carried out in a gradual increase and subsequent decrease in temperature so as not to shock the system.

CLEANUP & SAFETY

Cleanup	Altex Thinning Solvent #12 & water
Safety	Read and follow all caution statements on this product data sheet and on the SDS for this product. Employ normal workmanlike safety precautions. Hypersensitive persons should wear protective clothing, gloves and use protective cream on face, hands and all exposed areas.
Ventilation	When used as a tank lining or in enclosed areas, thorough air circulation must be used during and after application until the coating is cured. The ventilation system should be capable of preventing the solvent vapour concentration from reaching the lower explosion limit for the solvents used. In addition to ensuring proper ventilation, appropriate respirators must be used by all application personnel.

PACKAGING, HANDLING & STORAGE

Shelf Life	Part A and B: 24 months minimum at 25°C Shelf Life: (actual stated shelf life) when kept at recommended storage conditions and in original unopened containers. For products/components exceeding the stated shelf life, contact Technical Services for further advice.
Storage Temperature & Humidity	4 to 35°C 0 to 90%
Flash Point (Pensky Martens Closed Cup)	Part A: >93°C Part B: >93°C
Shipping Weight (Approximate)	5 Litre Kit Parts A & B: 9.5kg 1 Litre Kit Parts A & B: 1.9kg
Storage	Store indoors and KEEP DRY

WARRANTY

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SELECTION & SPECIFICATION DATA

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Generic Type	Two-component epoxy novolac powder metal filled paste
Description	CAR 400 is a solvent-free epoxy blended with atomized steel alloys and cross-linked with unique fast curing high performance amines processed from renewable resources. The chemistry employed allows for rapid return to service even at low temperatures with options of low energy forced heat curing which achieves an extremely high level of cross-linking, resulting in improved mechanical performance and chemical resistance. The product is used to repair and rebuild worn steel surfaces subjected to erosion, corrosion and chemical attack. CAR 400 can be applied from thin skim, pit filling layers to 15mm rebuilds without slumping, and in its wet state is water mist smoothable. After 30 minutes in a semi-set putty state, the product is mouldable to desired shapes and once set can be machined to the exact tolerances which may be required.
Features	CAR 400 is recommended for quick repair and rebuild of steel surfaces exposed to wear and chemical attack, i.e. impeller blades, shafts, pipes, valves and pump casings. The product is often used to smooth out weld joints in pipes, tanks and flanges, improving flow and restricting abrasion.
Colour	Metallic Grey
Finish	Smooth Machineable surface for specific requirements.
Film Build	200 microns to 15mm dry per coat, dependent on the rebuild requirements
Solid(s) Content	By Volume 100%
Theoretical Coverage Rates	80cm ² /kg at 5mm Material losses during mixing, application and machining will vary and must be taken into consideration when estimating job requirements.
Dry Temp. Resistance	Continuous - Ambient Cure: 110°C (230°F) Continuous - Post Cure: Stable up to 175°C (347°F)
Limitations	If exterior exposed, it will need abrading prior to coating.
Temperature Resistance (Immersion)	Temperature performance is dependent on actual chemical exposure. Typically being an epoxy novolac resin system, CAR 400 has outstanding resistance to most inorganic acids, alkalies, salt solutions and hydrocarbon solvents and oils. Refer to the Altex Coatings Technical Department for specific conditions. Most aqueous solutions: 110°C
Density	2.5 g/cm ³ (cured)

SUBSTRATES & SURFACE PREPARATION

General	Surfaces must be clean and dry. Employ adequate methods to remove dirt, dust, oil and all other contaminants as described in SSPC-SP 1 (AS 1627.1).
Steel	Dry abrasive blast to SSPC-SP 10 (AS 1627.4 Sa 2½) and achieve a uniform jagged blast profile of 50µm (minimum) and up to 75µm. For mild environments, power tool clean all surfaces to SSPC-SP 3 (AS 1627.2 St 3).

CAR 400

PRODUCT DATA SHEET



MIXING & THINNING

Mixing	For best results, the contents of the tin should be mixed together for approximately 4 to 5 minutes using a power mixer. DO NOT mix partial kits - Mix full kits only.
Thinning	Do NOT thin.
Pot Life	15 Minutes at 25°C and less at higher temperatures. Pot life ends when coating becomes too viscous to use.

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.

General	Do not attempt to install material if temperatures of material and substrate are not within the recommended ranges. The curing time and application properties of the material are severely affected by temperature changes. Do not add thinners to the system. Full cure will not be achieved and performance will be affected.
Application Tool	Using a spatula, apply product to the desired thickness. If mixed material is left in the container, it will become unusable within 15 minutes, depending on the temperature. If further build-up of coating is required, light abrasive blast or sand the cured surface to create a rough profile for improved adhesion. A reinforcing fabric such as woven glass fibre can be bedded into the CAR 400 and overcoated immediately when additional support is required. Clean equipment immediately after use with Altex Thinning Solvent #12 and rinse off in clean water.

APPLICATION CONDITIONS

Condition	Material	Surface	Ambient	Humidity
Minimum	5°C (41°F)	5°C (41°F)	5°C (41°F)	0%
Maximum	32°C (90°F)	32°C (90°F)	40°C (104°F)	100%
Optimum	24°C (75°F)	22°C (72°F)	22°C (72°F)	50%

Do not apply when the surface temperature is less than 3°C above the dew point.

CURING SCHEDULE

Surface Temp.	Dry to Handle	Chemical Exposure
5°C (41°F)	4 Hours	5 Days
10°C (50°F)	3 Hours	4 Days
20°C (68°F)	90 Minutes	36 Hours
25°C (77°F)	60 Minutes	24 Hours
35°C (95°F)	30 Minutes	18 Hours

Curing schedule is based on 50% RH.

Post curing at 100°C for 12 hours will accelerate the cure rate to full cure status. This process must be carried out in a gradual increase and subsequent decrease in temperature so as not to shock the system.

CLEANUP & SAFETY

Cleanup | Altex Thinning Solvent #12 and water

CLEANUP & SAFETY

Safety | Read and follow all caution statements on this product data sheet and on the SDS for this product. Employ normal workmanlike safety precautions. Hypersensitive persons should wear protective clothing, gloves and use protective cream on face, hands and all exposed areas.

Caution | Read and follow all caution statements on this product data sheet.

PACKAGING, HANDLING & STORAGE

Shelf Life | Part A: 12 Months minimum when stored at 25°C
Part B: 24 Months minimum when stored at 25°C

Shelf Life: (actual stated shelf life) when kept at recommended storage conditions and in original unopened containers. For products/components exceeding the stated shelf life, contact Technical Services for further advice.

Storage Temperature & Humidity | 4 to 35°C
0 to 90%

Flash Point (Pensky Martens Closed Cup) | Part A: >93°C
Part B: >93°C

Shipping Weight (Approximate) | **1kg**
Parts A & B: 1kg

Storage | Store indoors and KEEP DRY

WARRANTY

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Easy~Clean SX

Polyurethane Additive

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FEATURES		RECOMMENDED USES	
- Designed for two component polyurethane coatings - With a modified inorganic cross-linking formula, Easy~Clean SX creates a tougher polyurethane polymer - Does not contain Teflon® or similar fluorocarbon compounds or any known carcinogen - Improves water and oil repellence properties - Improves anti-block properties of curing and cured coatings - Low dirt pick-up and oleo/hydrophobicity improves weathering characteristics & chemical resistance - Co-reactive properties of Easy~Clean SX extends effective life - Convenient packaging - one 500 ml container of Easy~Clean SX treats one 5 litre kit of E~Line and some select Carbothane products - Under certain circumstances Easy~Clean SX Additive can improve surface wet-out and adhesion and levelling characteristics of the treated coating Limitation of Use: Due to the slip and anti-mar properties imparted to the treated polyurethane coating it is <i>essential</i> to thoroughly sand an Easy~Clean SX treated coating before re-painting or top-coating. If being used in a colour coat/clear coat anti-graffiti system, it is recommended to only use Easy~Clean SX Additive in the final clear coat.		Easy~Clean SX Additive is a proprietary modified inorganic additive for two component polyurethane coatings for improving cleaning & washing characteristics. It also improves aqueous chemical resistance, and anti-mar properties for products such as: - E~Line 379 - E~Line 949 - Selected Carbothane products - AY&B Elite Defender - AY&B Elite 239 - Multi-Gard GP 48^{AU} Typical uses for polyurethane coatings treated with Easy~Clean SX Additive include: - Coating of at-risk process vessels such as externals of concrete mixer bowls - Non-contaminating concrete shuttering release coating - Improving mar resistance - reduces scratching on bench-tops and floors - Reduced risk of moisture induced blushing of fresh coatings when applying under marginal conditions - Improved masking tape release qualities - Improved cleaning characteristics of coated items at risk of powder fall-out, oil or water contamination, exhaust fumes, recent graffiti attacks etc - Ideal easy cleaning coating for livestock sheds, milking sheds etc - Hydrophobic qualities improve washing characteristics and water drain-away	
SPECIFICATION DATA			
Coating Type: Cross-linking polyurethane additive Colour: Clear Packaging: 500 ml Gloss: As for parent product Flash Point: 5°C Thinner: N/A – Clean up with Altex Thinning Solvent #25 Pot Life: As for parent product Induction Time: As for parent product Storage: Store under cool, dry conditions Shelf Life: 60 months at 24°C When kept at recommended storage conditions and in original unopened containers. For products/components exceeding the stated shelf life, contact Technical Services for further advice.		Density: 0.86 kg per litre VOC: 786 grams per litre Temperature Resistance: As for parent product Volume Solids as supplied: 8.5% Theoretical Coverage Rate: Refer to parent product data sheet Recommended Film Thickness Per Coat: Refer to parent product data sheet Application: Refer to parent product data sheet Dry Times: Refer to parent product data sheet <i>(In all instances, refer to Product Data Sheet of the material being treated for Coverage Rates, Application and Dry Times.)</i>	

SURFACE PREPARATION

New or As-New Work

Refer to data provided with coating to be treated.

Self-Recoat

The low coefficient of friction and low-stick characteristics of coatings treated with Easy~Clean SX Additive make it essential to thoroughly sand before re-coating a treated coating with itself.

DIRECTIONS FOR USE

Easy~Clean SX Additive is presented as a low volume solid solution of reactive modified inorganic polymers that must be evenly and thoroughly mixed into two component polyurethane coatings such as E~Line 379 and 949, Elite Defender and Carbothane 130 Clear.

To achieve intimate molecular contact of all three components of the mixed paint system, it is recommended that the correct level of Easy~Clean SX Additive be added to the correct pre-measured quantity of polyurethane coating **base**, thoroughly stir to a homogeneous condition, and finally the pre-measured quantity of converter is added to the mix and stirred to a homogeneous condition. Induction times should be observed as described in the relevant coating's product data sheet.

The recommended addition rate for Easy~Clean SX Additive is as follows:

E~Line 379	500 ml per 5 litre kit
E~Line 949	375 ml per 4.5 litre kit
Carbothane 130 Clear	500 ml per 5 litre kit
Elite Defender	500 ml per 8 litre kit
Elite 239	500 ml per 5 litre kit
Multi-Gard GP 48 ^{AU}	500 ml per 5 litre kit

Easy~Clean SX Additive may be used in most two component polyurethane finishes however for optimum enhancement of easy-cleaning, mar resistance, weathering and chemical resistance it is recommended to use Easy~Clean SX Additive in a clear polyurethane finish such as Carbothane 130 Clear Coat applied over a colour coat of either Carbothane 134 HG, E~Line 379, E~Line 949, Multi-Gard GP 48^{AU}, or Elite 239 - similar to a "basecoat / clear-coat" system.

For maximum system application flexibility using the basecoat and clear-coat concept described above and an economic and practical system, with user-friendly re-coat windows, an ideal system would be to apply the following coatings over the suitably primed substrate:

Base Coat - Colour	Carbothane 134 HG, E~Line 379, E~Line 949, Multi-Gard GP 48^{AU}, or Elite 239
Clear Coat	Carbothane 130 Clear with Easy~Clean SX Additive

Note: The use of Easy~Clean SX Additive does NOT alter the mix ratio of the parent product.

PRECAUTIONS

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.

Easy~Clean SX Additive 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.

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Enamel Quick Dry Additive

Cure Accelerator for Single Pack
Alkyds

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FEATURES		RECOMMENDED USES															
- Accelerates the cure of enamel coatings. - Depending on addition rate, will reduce dust free times by up to 50%. - Increases hardness of the cured film. - Reduces time to be able to mask out areas. - May enhance both flow and final gloss levels Limitation: Due to the accelerated cure achieved with this product, the aged recoatability of Isotal Enamel is reduced. We recommend light sanding or Scotchbriting® between coats once the first coat has exceeded 7 days cure. Greater delays before final coating will require additional sanding to matte the surface. Although Enamel QDA may be used in Isotal Undercoat to accelerate the cure in colder months, this may affect the sanding properties of the coating.		For use in: - Isotal Enamel - Isotal Undercoat - AY&B Timbercote Exterior Varnish - May be used in other similar alkyd coatings.															
SPECIFICATION DATA																	
Coating Type: Isocyanate Additive Colour: Clear Packaging: 500ml Addition Rate: See overleaf Flash Point: 12°C Setaflash Storage: Store under cool, dry conditions Shelf Life: 12 months at 24°C When kept at recommended storage conditions and in original unopened containers. For products/components exceeding the stated shelf life, contact Technical Services for further advice.		Density: 0.99 kg per litre Pot Life*: 8 hours at 25°C Dry Times (25°C / 50% RH): <table><tr><td></td><td>Dust Free</td><td>Touch Dry</td><td>Hard Dry</td></tr><tr><td>Accelerated*</td><td>1½ hours</td><td>4 hours</td><td>10 hours</td></tr><tr><td>Non-Accelerated</td><td>3 hours</td><td>8 hours</td><td>24 hours</td></tr></table> * Example for 500ml of Enamel Quick Dry Additive in 4 litres of Isotal Enamel. In most instances, the addition rates above will approximately halve the relevant standard dry times					Dust Free	Touch Dry	Hard Dry	Accelerated*	1½ hours	4 hours	10 hours	Non-Accelerated	3 hours	8 hours	24 hours
	Dust Free	Touch Dry	Hard Dry														
Accelerated*	1½ hours	4 hours	10 hours														
Non-Accelerated	3 hours	8 hours	24 hours														

DIRECTIONS FOR USE

For maximum cure improvement use 500ml of Enamel Quick Dry Additive in 4 litres of Isotal Enamel.

For smaller quantities, mix 125ml of Enamel Quick Dry Additive per 1 litre of Isotal Enamel.

Do NOT accelerate above the recommended rates.

Stir thoroughly until mixture is uniform.

Caution should be exercised when using this product in Isotal Undercoat, as excessive use will compromise the sanding properties. Use as directed above.

Thinning:

Thin as recommended for the parent product. Refer relevant Product Data Sheet.

Typically, less thinning will be required with the addition of Enamel QDA.

The pot life of the mixed material is 8 hours at 25°C. Higher temperatures will reduce working life of the coating, lower temperatures will increase it.

Only mix the additive with the volume of coating that will be applied within the Pot Life.

Once the mixed product begins to thicken, it should no longer be used.

Do not store accelerated product.

PRECAUTIONS

For industrial & DIY use: 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.

Enamel Quick Dry Additive CONTAINS ISOCYANATE. When sprayed may be harmful by inhalation - do not breath vapour or spray. Wear suitable clothing, gloves, eye and face protection, including suitable breathing protection such as an air supplied respirator or hood.

Additional information is available from the Ministry of Health, Worksafe NZ, or Safe Work Australia on the safe handling and application of isocyanate containing products. We recommend that the latest information be obtained and read carefully. This information is being constantly updated and needs to be clearly understood by applicators prior to the use of this type of coating.

Enamel Quick Dry Additive is flammable. Keep away from heat, sparks, and open flame. Use with adequate ventilation. Do not breathe vapour or spray.

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Epoxy Accelerator

Cure Accelerator for
Selected Epoxy Coatings

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FEATURES		RECOMMENDED USES	
Advantages: - Accelerates cure of treated epoxy coatings at low temperatures - Cure and recoat times may be reduced by as much as 50% - Reduces time to touch dry / dust free - Reduce shop turn-around times in less than ideal conditions - Reduce time to mask out prior to topcoating For further information, consult Altex Coatings Technical Services.		Epoxy Accelerator is designed for use in epoxy coatings to reduce cure times at low temperatures: Limitations of Use: - The use of accelerators or force curing may shorten the aged recoat of individual coatings - The use of accelerators will shorten the mixed pot-life of individual coatings - Do not use in coatings with a pot life of 60 minutes or less. - The use of this accelerator may compromise the sanding properties of AY&B Epoxy Barrier Undercoat. Do not leave for extended periods, nor over accelerate. Epoxy Accelerator should only be used to <i>accelerate</i> the cure of coatings under adverse conditions; <i>it is <u>not a means by which to lower the absolute cure temperature of an individual coating</u></i> - such misuse of Epoxy Accelerator will result in marginal true cure and possible β-phasing of the epoxy polymer reaction.	
SPECIFICATION DATA			
Product Type: Amine Additive Colours: Amber Packaging: 500ml Mix Ratio: See Overleaf Flash Point: 115°C Setaflash Storage: Store under cool, dry conditions Shelf Life: 36 months at 24°C When kept at recommended storage conditions and in original unopened containers. For products/components exceeding the stated shelf life, contact Technical Services for further advice.		Density: 0.97 kg per litre Volume Solids: 100% Induction Time: 15 minutes at 10°C Dose Rates: Up to 25 ml of Epoxy Accelerator per 1 Litre of MIXED product. Can be added to Rustbond PS at a dosage rate of up to 15ml per 1 Litre of MIXED product	

DIRECTIONS FOR USE

Use up to 25ml of Epoxy Accelerator per litre of **mixed** product.

Can be added to **Rustbond PS** at a dosage rate of up to 15ml per 1 Litre of **MIXED** product – Refer to the Rustbond PS data sheet for curing schedule when dosed with Epoxy Accelerator.

- Add to mixed product before adding any thinner.
- Epoxy Accelerator must be mixed in thoroughly.
- At 10°C, a 15 minutes induction time is required once added to the mixed product.

MIXING:

Mix the base and converter at the appropriate mix ratio, add the required amount of accelerator while continuing to mix the product.

Thoroughly mix the solution for at least 5 minutes. Allow to stand (induct) for 15 minutes (minimum) prior to thinning (if required) and application

For additional information / advice, please contact the Altex Technical Services.

PRECAUTIONS

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.

Epoxy Accelerator is corrosive. Use with adequate ventilation. Causes severe skin burns, and serious eye damage. Do not breathe vapour or spray. Wear suitable protective clothing such as gloves and eye and face protection.

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Flattening Paste

For Gloss Reduction in
Selected Finish Coats

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FEATURES		RECOMMENDED USES	
- Improved formula allows easier incorporation and minimises the risk of 'bits' - Versatile: Compatible with many solvent-borne finishes; however, compatibility tests should be carried out with finishes not listed below - Designed for use in two component polyurethane finishes, single pack alkyd enamels and acrylic-epoxy finishes. - Unique premixed additive allows customised gloss reduction of coloured finishes - Easy mix and spray - Infinitely variable finish from gloss through semi-gloss, satin, egg-shell and flat finish - Good mar resistance compared with standard semi-gloss finishes - Reduces material costs as one pack of finish coat product can be altered to any gloss level Does not affect pot life of mixed polyurethane finish		Flattening Paste is used for gloss reduction in coatings utilised in Industrial Facilities, for Architectural finishes, on Ocean going vessels and on Pleasure Craft. Flattening Paste is designed for use in the following products: - E~Line® 379 - E~Line® 949 - Carboguard® 2929 - AY&B Elite® Defender - AY&B Elite® 239 - AY&B Regatta® Gloss Enamel - Altex Isotal Enamel Flattening Paste can be used: - to create a pleasing semi-gloss finish which can reduce visual impact of surface irregularities - to reduce glare off cabin tops, decks, painted structures etc - to allow easy colour cross match between exterior gloss finish and interior soft tone finishes - in cabin interiors, floors, bathrooms, staff quarters etc to achieve an architectural finish and retain protective qualities	
SPECIFICATION DATA			
Coating Type:	Predispersed Flattening Paste	Density:	1.07 kg/L
Colours:	White paste	Solids:	14% by volume
Thinner:	As required, use same thinner as for the coating being treated	Packaging:	1 Litre
Storage:	Store under cool, dry conditions		
Shelf Life:	24 months at 24°C When kept at recommended storage conditions and in original unopened containers. For products/components exceeding the stated shelf life, contact Technical Services for further advice.		

DIRECTIONS FOR USE

Stir the Flattening paste into a smooth homogenous mix, ensuring that any settled material has been fully incorporated. Measure out the desired amount of Flattening Paste required, and place in a separate mixing container.

Add a small amount of the selected **mixed** finish coat and stir until the two components are completely blended. (the paint volume added should be less than 50% of the volume of Paste)

Progressively "thin" the paste with more of the selected **mixed** finish coat, stirring each addition until a smooth, thin, creamy consistency is achieved.

Then add, while stirring, the Flattening Paste "cream" to the balance of the mixed finish. Power stir the full mixture for 5 minutes and then thin as directed on the appropriate finish coat Product Data Sheet.

Straining the mixed product prior to use will minimise any un-dispersed particles affecting the finish.

Mix Ratio by Volume (Guide Figures based on E~Line® 379)

Semi-Gloss:

1 part Flattening Paste to 5 parts mixed E~Line 379®

Satin:

2 parts Flattening Paste to 5 parts mixed E~Line 379®

Flat:

3 parts Flattening Paste to 5 parts mixed E~Line 379®

NOTE:

The above are guide ratios only. Plan your work so there is time for you to determine the appropriate level of reduction before committing to the job.

Guide addition rates are based on E~Line® 379 White finish.

The degree of flattening will vary from finish to finish and in some cases from colour to colour depending upon the tint base used.

Users are advised to trial differing rates to establish the desired level of gloss reduction.

PRECAUTIONS

For Industrial & DIY use: 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.

Once mixed with the parent product, this material may contain isocyanate. When sprayed it may be harmful by inhalation. Do not breathe vapour or spray. Wear suitable clothing, gloves, eye and face protection, including suitable breathing protection such as an air supplied respirator or hood.

Flattening Paste 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

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Microballoons & General Purpose Thickener

Additives for use in
AY&B Epoxy Resin

[Click Here to Download](#)

FEATURES	RECOMMENDED USES
- Both modifiers are free of toxic compounds such as asbestos. Dust hazard only - Economical additives for Altex Epoxy Resin System to make glues, fairing, filleting material and fillers - Easy free sanding properties - Both modifiers may be mixed in infinitely variable proportions to produce desired consistency and performance - Convenient re-sealable packaging; containers are resistant to resin and may be used for mixing	Microballoons - Premium ultra light weight filler for fairing, filling and filleting for use above and below the waterline. General Purpose Thickener (Aerosil) - Inorganic, asbestos free powder for use in high strength water resistant gluing applications Thixotropic properties of General Purpose Thickener make it an excellent anti-sag agent in fairing and filleting mixes. Translucent properties do not affect the colour of glue line.
SPECIFICATION DATA	
Appearance and Properties: <u>Microballoons:</u> Red powder consisting of hollow phenolic microspheres Packaging: NZ Only: 400g (4L) & 2 kg (20L) AUS & NZ: 12 kg (120L) <u>General Purpose Thickener (Aerosil):</u> White Powder Packaging: NZ Only: 200g (4L), 1 kg (20L), & 10 KG (200L) Note: Product may settle after packing. Storage: Store under cool, dry conditions	Density: Microballoons- 0.1 kg/L General Purpose Thickener- 0.05 kg/L Temperature Resistance In both cases greater than the epoxy or polyester binder they may be used in. Shelf Life: Microballoons: 60 months at 24°C GP Thickener: 60 months at 24°C When kept at recommended storage conditions and in original unopened containers. For products/components exceeding the stated shelf life, contact Technical Services for further advice.

DIRECTIONS FOR USE

This guide assumes the use of fillers in AY&B Epoxy Resin System.

Users are advised to read this data in conjunction with the AY&B Epoxy Resin Product Data Sheet.

TYPICAL MIX RATIOS:

Fairing, Filling and Filleting

One part by volume of **mixed** Altex Epoxy Resin plus between two and three parts by volume Microballoons. To prevent sagging, up to one half part by volume General Purpose Thickener may be added.

In certain instances, such as elevated temperatures, the filler material levels may need to be slightly increased to maintain resistance to slumping.

Glue: Brushable Adhesive

One part by volume of **mixed** product Altex Epoxy Resin plus one part by volume General Purpose Thickener.

Glue: Knifing Adhesive

One part by volume of **mixed** product Altex Epoxy Resin plus two parts by volume General Purpose Thickener.

If a heavily filled glue mix is used it is advisable to pre-wet absorbent surfaces to be bonded with neat Altex Epoxy Resin. DO NOT over cramp joints - Epoxy adhesives offer superior strength with a gap-filled glue line.

Note:

The above mix ratios are guide figures only. The proportions of General Purpose Thickener and Microballoons may be varied to suit the specific requirements of the job.

Mixing:

General Purpose Thickener and Microballoons should be added straight after mixing the correct proportions of parts A and B Resin together. A firm paddle motion is the preferred method of mixing at all stages. Avoid the use of high speed mixers as this action tends to entrain air in the mix.

PRECAUTIONS

For industrial & DIY use: 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.

Dust Hazard - When handling General Purpose Thickener and Microballoons it is advisable to wear a dust mask to prevent inhalation of airborne particles.

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Non-Skid Particles

Additive for Anti-Slip
Properties

[Click Here to Download](#)

FEATURES		RECOMMENDED USES	
<u>Fine Medium Coarse:</u> Three grades of Particles available to achieve the desired finish. May be incorporated into a wide range of coatings, either as an intermediate coat, or as a finish coat. Either broadcast into a wet film, or mixed and roller applied. Fine grade may be spray applied. All products are sieved grades, meaning the finish is consistent and attractive, with no clumping of dust particles. Medium and Coarse grades are highly abrasion resistant, with over 20 years of proven service in many different industrial and marine situations. <u>Typical Systems:</u> • Straight epoxy high builds, roller applied with aggregate as a single coat, or broadcast & seal coated with epoxy. • Epoxy high builds, broadcast filled, or roller applied, with polyurethane finish coat to seal. • Spray applied polyurethane finish coats incorporating fine Non-Skid Particles.		The Altex range of Non-Skid Particles offers the end user a diverse set of options, both in particle size and application method. <u>Coarse Grade:</u> Used in Commercial Shipping, Freighters, Fishing Vessels, Ferries etc. Industrial facilities, pulp mills, tank platforms, tank roofs, production floors and other high-risk areas. Flooring, as an abrasion resistant non-skid finish, where forklift traction is required. <u>Medium Grade:</u> Use in any of the above situations, as well as Charter Boats, Passenger Ferries, Commercial Fishing, or other situations where a balance between traction, wear and cosmetics are important. The finish achieved with the Medium grade has greater visual appeal than the Coarse grade. <u>Fine Grade:</u> Primarily used on the decks of pleasure craft, where it achieves a pleasing stippled texture, while providing excellent non-skid properties. Spray application enhances the finish, and achieves a professional looking, even film. See overleaf for more details on achieving good traction with non-skid surfaces.	
SPECIFICATION DATA			
Product Type: Fine grade: Specialised synthetic bead Medium & Coarse grade: Ceramic chips Colours: White to Off White Packaging: Fine grade: 0.52 kg (Packed in a 1L container) Medium grade: 2 kg (Packed in a 2L container) Coarse grade: 2 kg (Packed in a 2L container) Contents may settle after packing Mix Ratio: See overleaf Storage: Store under cool, dry conditions Shelf Life: 60 months at 24°C When kept at recommended storage conditions and in original unopened containers. For products/components exceeding the stated shelf life, contact Technical Services for further advice.		Particle Grade/Size: Fine grade: 0.52 kg (1L) ≤ 300 microns. Similar to 80-100 grit* Medium grade: 2 kg (2L) 200-600 microns Similar to 30-40 grit* Coarse grade: 2 kg (2L) 600-1,200 microns Similar to 10-14 grit <i>*These grit grades are indicative of the finish achieved when the aggregate is broadcast into the wet paint film to achieve saturation.</i> <i>The coating into which the aggregate is broadcast will have an influence over the nature of the finish.</i> <i>The application of a topcoat over the aggregate will further influence the ultimate profile of the surface.</i> <i>See overleaf for further information.</i>	

DIRECTIONS FOR USE

Mix Ratios:

Low Build Coatings: 50g Fine Non-Skid Particles per **mixed** litre of finish.
For denser finishes up to 100g of Fine Non-Skid Particles per **mixed** litre of finish may be used.

High Build Coatings: Mix 2 kg of Medium or Coarse grade particles with 5 litres of the selected high build coating, making a total liquid volume of 6 mixed litres.
(these are guide ratios only)

Application Techniques:

Broadcast Method:

Generally used with epoxy high build coatings such as Carboguard 636 XT, and the Medium or Coarse grades of particles. In this method the particles are dropped onto the freshly applied coat of paint, so as to allow them to partially "sink" into the film. This can be achieved either by using a can or jar with holes drilled in the lid (good for smaller areas), or by "throwing" the material, in an upward motion so that the particles fall vertically into the film. It is important to ensure that the coating being "filled" is freshly applied - this typically means rolling and broadcasting in stages, or working with one person rolling, and another broadcasting. Using this method requires that the entire surface be evenly saturated with particles and consumes more aggregate. Once cured, the excess material is swept up and a subsequent coat (epoxy or polyurethane) is applied.

Roller Application:

Typically employed with epoxy high build coatings (the particles tend to sink before application when mixed with polyurethane coatings). The recommended ratio of Medium & Coarse Non-Skid to paint is 2 kg of Particles to 5 litres paint, making a total liquid volume of 6 mixed litres. Additional particles may be added - the main limitation is maintaining a suitably wet film to roll. It is important to ensure the particles do not settle before being applied - agitate the mix regularly.

Spray Application:

This technique only applies to the Fine grade particles and is usually employed with polyurethane finish coats - typically on the decks of Pleasure Boats using a hand held pressure pot, or a siphon set up. Aggregate is mixed at the required ratio with the coating, and carefully thinned so as to achieve acceptable fluid flow. Tip size should be 1.6 to 2mm. Reduce the pot pressure to 4 to 8 lbs and maintain a high atomisation pressure of 60-80 lbs. In this way the equipment tends to operate in a siphon cup way, allowing the fluid needle to be kept slightly open without material being released, thus clearing the orifice continually. The coating is applied while frequently agitating the pressure pot to maintain the particles in suspension. Other techniques will achieve the desired effect, we recommend trialling spray setups before applying to the main surface.

Best Results:

In some situations, a finer grade non-skid finish will provide superior traction compared to a coarser grade finish.

The degree of non-slip achieved is dependent on several factors: The coating used, the grade and nature of the particle applied, the density of the applied particles, application techniques and the type of footwear worn.

We recommend trialling different non-skid grades, application density and application methods to determine the most suitable finish in critical areas.

PRECAUTIONS

For industrial & DIY use: 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.

Dust Hazard

Non-Skid Particles are non-toxic. Avoid getting particles in eyes.

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P40

Prepainting Cleaner

Water Based Cleaner

[Click Here to Download](#)

FEATURES		RECOMMENDED USES	
<u>Advantages:</u> • Promotes adhesion as it cleans • Dramatically improves re-coatability of aged, painted surfaces • Powerful degreaser • Solvent free • Biodegradable • Easy to apply, low odour • Can eliminate costly sandblasting or sanding • Contains no phosphates, halogens, or alkali hydroxides <u>Approvals:</u> <u>Ministry for Primary Industries (NZ)</u> MPI Approved C 37 (All animal product except dairy) <u>Limitations of Use:</u> • P40 Prepainting Cleaner must not be allowed to dry on the surface • Do not apply under freezing conditions • Do not apply to glass surfaces, metallic automobile finishes, aluminium surfaces which will remain unpainted or strong alkali sensitive painted surfaces • May dull glossy finishes • May damage vegetation. Protect while using P40 Prepainting Cleaner, rinse thoroughly with fresh water if contact occurs.		P40 Prepainting Cleaner is a non-ionic detergent, which is designed to clean intact, painted surfaces, as well as new surfaces in preparation for repainting. Old painted surfaces are made “super-clean” with P40 Prepainting Cleaner, and the adhesion of subsequent coatings is promoted. No other preparation may be needed before repainting above water line surfaces, eliminating costly sanding, solvent wiping, abrasive sweep blasting or roughening-up of the old painted surfaces. P40 Prepainting Cleaner is ideal for: • Dry dock painting • Maintenance painting • New construction • Hygienic cleaning • Topsides wash down to remove salts & oils P40 Prepainting Cleaner is particularly useful for cleaning dirty, greasy concrete floors, walls, machinery, and equipment in industrial and commercial environments.	
SPECIFICATION DATA			
Coating Type: Water Based Cleaner Colours: Clear to slightly hazy Packaging: 1, 4 and 20 litres Boiling Point: 100°C Freezing Point: -4°C Clean-up Solvent: Water Storage: Store under cool, dry conditions Shelf Life: 60 months at 25°C When kept at recommended storage conditions and in original unopened containers. For products/components exceeding the stated shelf life, contact Technical Services for further advice.		Density: 1.03 kg/L VOC: 32 g/L pH: 10.0 - 11.0 Alkaline - Not Caustic! Solubility: Infinite - in fresh or sea water	

DIRECTIONS FOR USE

For most applications P40 Prepainting Cleaner may be diluted up to 1:3 with fresh, clean water. Test cleaning a small area may be useful to determine proper dilution and to ensure compatibility with the substrate.

Apply the solution with brush, roller, mop, or low-pressure spray. Ensure adequate protective equipment and clothing is used, such as rubber gloves and protective eyewear.

- If the surface is hot, pre-wet before applying cleaner solution, or defer cleaning until temperatures reduce.
- Moderate scrubbing will aid in performance and speed of cleaning
- Allow cleaner to remain on surface for five to ten minutes depending on temperatures.
- Rinse with large volumes of low pressure, fresh water. Thorough rinsing is very important as all of the P40 Cleaner must be removed before painting. **DO NOT allow to dry on surface.**

Rinsing to the extent that there is no more foaming evident indicates that the P40 Prepainting Cleaner has been fully removed.

If the solution dries on the surface, you must re-wash with P40 Prepainting Cleaner to dissolve the crystals, and rinse thoroughly.

PRECAUTIONS

For industrial & DIY use: 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.

P40 Prepainting Cleaner is alkaline. Care should be taken to prevent eye contact. Avoid prolonged or repeated skin contact. During application the use of suitable protective clothing such as gloves and eye and face protection is recommended. Care should be exercised as treated areas remain very slippery until fully rinsed.

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Polyurethane Accelerator

Cure Accelerator for
Selected Topcoats

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FEATURES		RECOMMENDED USES																					
- Accelerates cure of Altex E~Line 379, Carbothane 130 Clear Coat, AY&B Elite Defender, AY&B Elite 239, and Multi-Gard GP 48^{AU} - Reduces “dry to handle” times when time is critical - Reduces time to mask out, and improves masking properties when conditions are marginal CAUTION! Polyurethane Accelerator should only be used when it is essential to improve cure time. Mixed product should be thinned at least 10% <u>BEFORE</u> adding Polyurethane Accelerator. (excluding Elite Defender) Over addition of Polyurethane Accelerator may result in drastically reduced Pot Life and be detrimental to finish gloss level and overall performance.		Polyurethane Accelerator is designed to reduce the time to Hard Cure in winter temperatures in a range of polyurethane finish coats: Use in: AY&B Elite Defender AY&B Elite 239 Carbothane 130 Clear Coat Multi-Gard GP 48^{AU} (Aust. Only) E~Line 379 (NZ Only) Typically, Polyurethane Accelerator would be used in: - A production situation where finished fabrications require to be moved or erected soon after painting has been completed. - Where masking out areas, (especially in maintenance repaints of pleasure craft), would be significantly delayed. - To reduce the time to a return to service for various industrial items, commercial floors, earthmoving equipment etc.																					
SPECIFICATION DATA																							
Coating Type: Urethane Catalyst Colour: Clear Packaging: 500ml Flash Point: 27°C Setaflash Shelf Life: 1 year Storage: Store in cool dry conditions Shelf Life: 12 months at 24°C When kept at recommended storage conditions and in original unopened containers. For products/components exceeding the stated shelf life, contact Technical Services for further advice.		Density: 0.87 kg per litre Mixing: See Rates overleaf. DO NOT add Polyurethane Accelerator until after mixing and thinning of finish coat. Approximate Curing Time & Pot Life at 20°C (Hours): (Based on E~Line 379) <table><tr><th>Accelerator Addition Rates</th><th>Touch Dry</th><th>Hard Dry</th><th>Pot Life</th></tr><tr><td>5ml / 1 litre of mix</td><td>2¼</td><td>4</td><td>6</td></tr><tr><td>8ml / 1 litre of mix</td><td>1½</td><td>3¼</td><td>4</td></tr><tr><td>10ml / 1.25 litre kit</td><td>1½</td><td>3¼</td><td>4</td></tr><tr><td>40ml / 5 litre kit</td><td>1½</td><td>3¼</td><td>4</td></tr></table> Note: The use of Polyurethane Accelerator will affect the maximum self recoat time and reduce the pot life of the product. Contact Altex Coatings Technical Department for specific recommendations.		Accelerator Addition Rates	Touch Dry	Hard Dry	Pot Life	5ml / 1 litre of mix	2¼	4	6	8ml / 1 litre of mix	1½	3¼	4	10ml / 1.25 litre kit	1½	3¼	4	40ml / 5 litre kit	1½	3¼	4
Accelerator Addition Rates	Touch Dry	Hard Dry	Pot Life																				
5ml / 1 litre of mix	2¼	4	6																				
8ml / 1 litre of mix	1½	3¼	4																				
10ml / 1.25 litre kit	1½	3¼	4																				
40ml / 5 litre kit	1½	3¼	4																				

DIRECTIONS FOR USE

Stir thoroughly before use.

The maximum recommended addition rate of Polyurethane Accelerator is 8ml per 1 litre of MIXED product.

8ml per 1.0 litre kit

10ml per 1.25 litre kit

40ml per 5 litre kit

...in any of the following products:

AY&B Elite® 239

Carbothane® 130 Clear Coat

Multi-Gard® GP 48^{AU} (Aust. Only)

E~Line® 379 (NZ Only)

Due to the 1:1 mix ratio of Elite®, Defender the recommended rate is:

40ml per 8 litre kit

Mixed product should be thinned at least 10% BEFORE adding Polyurethane Accelerator. (excluding Elite Defender).

The addition of Polyurethane Accelerator reduces the pot life of the finish coat treated.

Temperatures above 26°C will drastically reduce the pot life of the coating. Best results are achieved at temperatures in the range of 10-20°C.

Treatment is not normally required in temperatures above 25°C. However, should there be a need to accelerate, then do so with extreme caution.

PRECAUTIONS

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.

Polyurethane Accelerator 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.

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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. Altex Terms and Conditions of Trade, available at www.altexcoatings.com, apply in respect of all coating products and materials supplied, including samples.

SELECTION & SPECIFICATION DATA

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Generic Type	Epoxy Polyamide
Description	Solvent-free patching compound used for repairing pits, cracks and voids in steel, concrete, wood and other surfaces. Has the unique ability to be mixed, applied and cured underwater.
Features	• Designed for underwater and other wet applications • Can be applied up to 50 mm (2") in thickness • Self-priming on most surfaces and over most generic types of coatings • Rapid cure characteristics • VOC compliant to current AIM regulations
Colour	Olive Green
Finish	Flat
Primer	Self-priming
Film Build	3-50 mm for most applications. 6 mm is practical maximum per pass for vertical and overhead applications.
Solids Content	By Volume 99% +/- 2%
Coverage Rate	1 m ² /litre at 1 mm (1000 microns) DFT 0.3 m ² /litre at 3 mm (3000 microns) DFT Allow for loss in mixing and application.
VOC Values	As Supplied : 0 g/l These are nominal values.
Topcoats	Epoxies Polyurethanes

SUBSTRATES & SURFACE PREPARATION

General	Remove all oil or grease from the surface with in accordance with AS 1627.1 (SSPC-SP1). Remove all dirt, loose paint, spalling concrete, rotted wood, marine growth and other contaminants by abrasive blasting or high pressure water blasting. Hand or power tool cleaning methods may be used but are of limited benefit and are time consuming. Abrasive blasting can be done underwater as the initial air blast will clear a path through the water for the abrasive/air mixture. When working at the splash zone or in salt water, coat cleaned metal surfaces as soon as possible to minimize new corrosion.
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MIXING & THINNING

Mixing	Mix one Part A to one Part B by volume. Mix by hand "scooping" a quantity of the "A" component from the can and then "scoop" the same quantity of the "B" component from its can. Mix and knead the two components by hand until the yellow and black colours have combined to make a uniform olive green colour. Apply this mixture immediately after mixing; no sweat-in time is required. To assist in mixing, keep the gloved hands and the materials wet with water during the mixing process.
Thinning	Not recommended. Use of thinners other than those supplied or recommended by Carboline may adversely affect product performance and void product warranty, whether expressed or implied.

Splash Zone A-788

PRODUCT DATA SHEET



MIXING & THINNING

Pot Life

Working times at 21°C, below and above water:

- Golf ball size mix: 40 minutes
- Tennis ball to Softball size mix: 30 minutes
- 2 litre mix: 15 minutes.

Working times are reduced by one-half at temperatures above 27°C.

Do not mix more material than can be applied in the working times listed. The material may still appear to be workable after the time limit is exceeded, but it will not properly adhere to the substrate after application and curing.

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.

General

Apply by hand, trowel or broad knife. Spread material smoothly onto the surface in a 3 to 6 mm thick layer using enough pressure to displace water and air bubbles. Smooth out the area by hand. When starting another mix, start spreading at and away from the previous applied film. This will help prevent trapped air bubbles or leaving an area uncoated.

If applying to dry surfaces in dry air, periodically re-wet hands or tools with water to keep the product from sticking.

When used as a patch or grout, force the material into the hole or crack and smooth by hand to the thickness needed. For larger patches greater than 13 mm, use a steel or fiberglass plate for added support. Apply to the substrate, then embed the support plate (cut larger than the hole) and apply product overall.

When applied under water or when wetted with water during application, the surface will form an emulsified lighter green "scum" layer. This layer is normal and facilitates application. The film under the "scum" layer remains undisturbed and will cure properly. The "scum" layer will cure and become part of the finish when it is cured above water; however, this layer will remain soft and uncured when the product is kept underwater during curing.

APPLICATION CONDITIONS

Condition	Material	Surface	Ambient	Humidity
Minimum	10°C (50°F)	10°C (50°F)	10°C (50°F)	0%
Maximum	38°C (100°F)	43°C (109°F)	38°C (100°F)	100%

Special application techniques may be required above or below normal application conditions. Do not apply or cure in acidic or alkaline water (pH less than 6 or greater than 9) or in solutions containing solvents.

CURING SCHEDULE

Surface Temp.	Dry to Handle or Topcoat	Dry to Recoat Maximum	Dry to Touch
10°C (50°F)	36 Hours	72 Hours	8 Hours
16°C (60°F)	16 Hours	48 Hours	4 Hours
24°C (75°F)	8 Hours	24 Hours	2 Hours
32°C (90°F)	6 Hours	12 Hours	1 Hour

These times are based on a 3 mm dry film thickness. Higher film thicknesses or cooler temperatures will require longer cure times. If the maximum recoat times have been exceeded, the surface must be abraded by sweep blasting or sanding to produce a rough surface and to remove the "scum" layer before the application of any further coatings.

CLEANUP & SAFETY

Cleanup | Use Thinner #2 or Acetone

Safety | Read and follow all caution statements on this product data sheet and on the SDS for this product. Employ normal workmanlike safety precautions. Some people may be sensitive to the epoxy resins used in this material, so tight fitting rubber gloves should always be worn during the mixing process. When used for marine applications in splash zone areas, use all necessary precautions to protect the applicators. Wear wet or dry suits if necessary to help preserve body heat and use approved life jackets and safety lines. Avoid working in rough water.

PACKAGING, HANDLING & STORAGE

Shelf Life | Part A & B: Min. 24 months at 24°C
*Shelf Life: (actual stated shelf life) when kept at recommended storage conditions and in original unopened containers.

Shipping Weight (Approximate) | 1.8 Gallon (6.8 litres) Kit
13 kg

Storage Temperature & Humidity | 4°-43°C
0-100% Relative Humidity

Flash Point (Setaflash) | Part A: >93°C
Part B: >93°C

Storage | Store Indoors

WARRANTY

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