

# Resene Alumastic

## high build epoxy

Resene Alumastic is formulated with a unique blend of low-molecular weight resins, penetrants and surface active agents. This allows excellent wetting and penetration of rusted steel surfaces. Reaction occurs on the surface, setting the components into a high molecular weight, tough durable polymer.

Self-priming maintenance coat over steel, rusted steel and galvanised steel.

### Typical uses

- Galvanised steel
- Roofing
- Structural steel

<b>Vehicle type</b>	Two component epoxy
<b>Curing agent</b>	Polyaminoamide/amine
<b>Pigmentation</b>	Bright aluminium
<b>Solvent</b>	Aromatic
<b>Pot life</b>	4 hours at 21°C
<b>Mix ratio</b>	1 part base: 1 part hardener (by volume)
<b>Dry time (minimum)</b>	Light foot traffic: 24 hours at 18°C
<b>Overcoat</b>	Contact the manufacturer
<b>Primer required</b>	Not normally
<b>Theoretical coverage</b>	7.2 sq. metres per litre at 125 microns DFT 5.1 sq. metres per litre at 175 microns DFT
<b>Volume solids</b>	90%
<b>Recommended DFT</b>	Typical exposures: 125 microns (minimum) Severe exposures: 175 microns DFT (minimum)
<b>Usual no. of coats</b>	1 (airless spray)
<b>Abrasion resistance</b>	Good
<b>Chemical resistance</b>	Acids – fair; alkalis – poor
<b>Heat resistance</b>	80°C (dry continuous)
<b>Solvent resistance</b>	Good
<b>Durability</b>	Excellent
<b>Thinning and clean up</b>	Thin with Resene Thinner No.6 Clean up with Resene Thinner No.12
<b>Pack size</b>	4 and 20 litre composites

### Physical properties

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Clean up with Resene Thinner No.12  
4 and 20 litre composites

### Performance

### Performance and limitations

1. Extremely tolerant of poor surface preparation.
2. Excellent resistance to marine environments.
3. A high-build coating that can be used as a self-finish, or as a heavy duty primer.
4. High level of flexibility

### Limitations

1. Cure time is considerably slowed below 10°C.
2. Limited resistance to acids and alkalis.
3. Do not apply over thermoplastic coatings.
4. Excellent adhesion to most aged paint systems (see limitation 3). However a test patch is always recommended to confirm compatibility.
5. Do not apply to rubber or bitumen based roofing membranes.

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## Surface preparation

Notwithstanding the ability of Resene Alumastic to penetrate and protect rusting surfaces, the basic tenet of protective coating systems is not contravened – that is, the better the surface penetration the better the results. Regardless of the degree of surface rusting, Resene Alumastic will give the best surface wetting of our range of products. Circumstances in the field rather than a blanket recommendation, will really dictate the amount of surface preparation that is permitted or affordable.

Ensure all surfaces to be painted are dry and free from loose rust, salt, dirt, dust, oil, grease and mould. Minimum requirements are cleaning with Resene Roof Wash and Paint Cleaner (see [Data Sheet D88](#)), followed by waterblasting at 3000 psi. Rusted areas must be power tool cleaned to SSPC SP3 or hand tool cleaned to SSPC SP2. Immediately spot prime all cleaned red rust areas only with Resene Alumastic or Resene Vinyl Etch (see [Data Sheet RA31](#)). The more severe the environment the coating system will be required to withstand the greater degree of surface preparation required. Special attention must be paid to ensure minimum film build requirements are achieved on top edges of trough section roofing.

*Residues and dust from old paint systems containing lead or chromate may be dangerous to the health of the operator and the environment. Ensure approved procedures are put in place to safeguard against this.*

## Application

### Mixing

Base and hardener are mixed in a 1:1 ratio. Mix each component separately. Power mixing is recommended to ensure thorough blending of the components. Allow mixed product to stand for 10-15 minutes before application.

### Application

Although small areas can be touched up by brush the product is specifically designed for airless spray application. The high levels of thinner required for other application methods reduces the desirable high build properties.

A 30:1 pump capable of delivering a fluid pressure of 21,000 kPa (3000 psi) is recommended. A tip of about 25 thou is necessary (tip size may vary depending upon equipment).

## Safety precautions

Consult Safety Data Sheet for this product prior to use. Users should ensure that they are familiar with all aspects concerning safe application of this product. **IF IN DOUBT, DO NOT USE THIS PRODUCT.**

Epoxies, polyamines, polyamides have been known to cause dermatitis. When skin contact does occur, wash off with plenty of soap and water.

*Please ensure the current Data Sheet is consulted prior to specification or application of Resene products.  
If the surface you propose to coat is not referred to by this Data Sheet, please contact Resene for clarification.*

**In Australia**  
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the paint the professionals use

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