

## Aluminium Paint H.R.

### Product description

This is a one component styrene modified oxidatively drying alkyd coating. It is heat resistant up to 250 °C. Can be used as an exterior aluminium finish usually within an alkyd system. Can be used as primer, mid coat or finish coat in atmospheric environments. Suitable for properly prepared carbon steel and aluminium substrates.

### Typical use

Exhaust pipes, process piping and engine parts.

### Colours

aluminium

### Product data

Property	Test/Standard	Description
Solids by volume	ISO 3233	45 ± 2 %
Gloss level (GU 60 °)	ISO 2813	aluminium sheen
Flash point	ISO 3679 Method 1	36 °C
Density	calculated	0.9 kg/l
VOC-US/Hong Kong	US EPA method 24 (tested) (CARB(SCM)2007, SCAQMD rule 1113, Hong Kong)	435 g/l
VOC-EU	IED (2010/75/EU) (theoretical)	416 g/l
VOC-China	GB/T 23985-2009 (ISO 11890-1) (tested)	419 g/l
VOC-Korea	Korea Clean Air Conservation Act (tested)	410 g/l

The provided data is typical for factory produced products, subject to slight variation depending on colour.  
Gloss description: According to Jotun Performance Coatings' definition.

### Film thickness per coat

#### Typical recommended specification range

Dry film thickness	20 - 30	µm
Wet film thickness	45 - 65	µm
Theoretical spreading rate	22.5 - 15	m <sup>2</sup> /l

## Surface preparation

To secure lasting adhesion to the subsequent product all surfaces shall be clean, dry and free from any contamination.

### Surface preparation summary table

Substrate	Surface preparation	
	Minimum	Recommended
Carbon steel	Sa 2½ (ISO 8501-1)	Sa 2½ (ISO 8501-1)
Aluminium	The surface shall be hand or machine abraded with non-metallic abrasives or bonded fibre machine or hand abrasive pads to impart a scratch pattern to the surface and to remove all polish from the surface.	Cleanliness corresponding to description of Sa 1 (ISO 8501-1)
Shop primed steel	Clean, dry and undamaged shop primer (ISO 12944-4 6.1)	Sa 2 (ISO 8501-1)
Coated surfaces	Clean, dry and undamaged compatible coating (ISO 12944-4 6.1.4)	Clean, dry and undamaged compatible coating (ISO 12944-4 6.1.4)

## Application

### Application methods

The product can be applied by

- Spray: Use air spray or airless spray.
- Brush: Recommended for stripe coating and small areas. Care must be taken to achieve the specified dry film thickness.
- Roller: May be used for small areas. Not recommended for first primer coat. Care must be taken to achieve the specified dry film thickness.

### Product mixing

Single pack

### Thinner/Cleaning solvent

Thinner: Jotun Thinner No. 2

### Guiding data for airless spray

Nozzle tip (inch/1000): 15-19

Pressure at nozzle (minimum): 150 bar/2100 psi

## Drying and Curing time

Substrate temperature	5 °C	10 °C	23 °C	40 °C
Surface (touch) dry	30 min	30 min	30 min	15 min
Walk-on-dry	18 h	14 h	10 h	8 h
Dry to over coat, minimum	24 h	12 h	8 h	6 h

For maximum overcoating intervals, refer to the Application Guide (AG) for this product.

Drying and curing times are determined under controlled temperatures and relative humidity below 85 %, and at average of the DFT range for the product.

Surface (touch) dry: The state of drying when slight pressure with a finger does not leave an imprint or reveal tackiness.

Walk-on-dry: Minimum time before the coating can tolerate normal foot traffic without permanent marks, imprints or other physical damage.

Dry to over coat, minimum: The recommended shortest time before the next coat can be applied.

## Heat resistance

	Temperature	
	Continuous	Peak
Dry, atmospheric	250 °C	-

The temperatures listed relate to retention of protective properties. Aesthetic properties may suffer at these temperatures.

## Product compatibility

Depending on the actual exposure of the coating system, various primers and topcoats can be used in combination with this product. Some examples are shown below. Contact Jotun for specific system recommendation.

Previous coat: inorganic zinc silicate shop primer

## Packaging (typical)

	Volume (litres)	Size of containers (litres)
Aluminium Paint H.R.	5	5

The volume stated is for factory made colours. Note that local variants in pack size and filled volumes can vary due to local regulations.

## Storage

The product must be stored in accordance with national regulations. Keep the containers in a dry, cool, well ventilated space and away from sources of heat and ignition. Containers must be kept tightly closed. Handle with care.

### Shelf life at 23 °C

Aluminium Paint H.R.

24 month(s)

In some markets commercial shelf life can be dictated shorter by local legislation. The above is minimum shelf life, thereafter the paint quality is subject to re-inspection.

## Caution

This product is for professional use only. The applicators and operators shall be trained, experienced and have the capability and equipment to mix/stir and apply the coatings correctly and according to Jotun's technical documentation. Applicators and operators shall use appropriate personal protection equipment when using this product. This guideline is given based on the current knowledge of the product. Any suggested deviation to suit the site conditions shall be forwarded to the responsible Jotun representative for approval before commencing the work.

## Health and safety

Please observe the precautionary notices displayed on the container. Use under well ventilated conditions. Do not inhale spray mist. Avoid skin contact. Spillage on the skin should immediately be removed with suitable cleanser, soap and water. Eyes should be well flushed with water and medical attention sought immediately.

## Colour variation

When applicable, products primarily meant for use as primers or antifoulings may have slight colour variations from batch to batch. Such products may fade and chalk when exposed to sunlight and weathering.

## Disclaimer

The information in this document is given to the best of Jotun's knowledge, based on laboratory testing and practical experience. Jotun's products are considered as semi-finished goods and as such, products are often used under conditions beyond Jotun's control. Jotun cannot guarantee anything but the quality of the product itself. Minor product variations may be implemented in order to comply with local requirements. Jotun reserves the right to change the given data without further notice.

Users should always consult Jotun for specific guidance on the general suitability of this product for their needs and specific application practices.

If there is any inconsistency between different language issues of this document, the English (United Kingdom) version will prevail.