

APCOTHERM HR 250

Synthetic Aluminium



PRODUCT DESCRIPTION

Single pack, air drying, synthetic resin based aluminium finish.

FEATURES AND RECOMMENDED USE

- Heat resistance coating with extensive range of application
- Resistant to dry heat upto 250°C
- Good weather and water resistance

TECHNICAL DATA

Colour	Aluminium
Gloss	Bright Metallic
Volume Solids	Approx. 35%
Recommended DFT / Coat	20 - 25 microns
Theoretical Coverage Capacity	17.5 sq.mtr/ ltr @ 20 microns DFT 14.0 sq.mtr/ ltr @ 25 microns DFT
Drying time at 30°C	Surface Dry : 4 hours Hard Dry : 16 hours
Over coating interval at 30°C	Min. : 16 hours Max. : Unlimited, provided surface is dry and clean from all contamination.

The data given is for guideline only. The physical values are subject to normal manufacturing tolerances, colour and testing variances
The volume solids indicated are as per ASTM D 2697 air drying method.
The actual drying time/ overcoat interval may be shorter or longer, depending on film thickness, ventilation, humidity, temperature etc.
The information provided above is at 30° C and 65% relative humidity.

DIRECTION FOR USE

Surface Preparation

General

- Suitable conventional primer i.e. Apcomin Zinc Phosphate Primer, dry and free from any contamination
- Surfaces must be dry, clean and free from contaminants
- Ensure removal of dirt, dust, oil and all other contaminants that could interfere with adhesion of the coating
- Oil and grease should be removed as per SSPC-SP1 solvent cleaning
- Surface should be checked and treated in accordance with ISO 8504 prior to priming

Blast Cleaning

- Steel, blast clean to Sa 2.5 of Swedish specification
- A blasting profile of (Rz) 20 - 25 microns is recommended
- In case blast cleaning is not possible, surface should be cleaned to St 3 using power tools

APPLICATION CONDITIONS

- Substrate temperature should be at least 3°C above dew point but not above 50°C.
- Relative humidity should be below 85%
- Good ventilation is required in confined areas to ensure proper curing

MIXING

- Mix the entire quantity of supplied aluminium paste thoroughly with a small quantity of medium and then add the mixture to the remaining medium. Stir well before use

Mixing Ratio	Medium	: Aluminium Paste
(by weight)	80.5	: 19.5
Pot Life at 30°C	Not Applicable	

APPLICATION

Air Spray

Recommended thinner	T - 101
Volume of thinner	0 - 5%
Nozzle orifice	1.5 - 3.0 mm
Nozzle Pressure	0.3 - 0.4 MPa (= approx. 3 - 4 atm; 43 - 57 p.s.i.)
Cleaning Thinner	T - 101

Airless Spray

Recommended thinner	T - 101
Volume of thinner	0 - 5%
Nozzle orifice	0.38 mm (15 Thou)
Nozzle Pressure	8 MPa (= approx. 80 atm; 1140 p.s.i.)
Cleaning Thinner	T - 101

Brush / Roller

Recommended thinner	T - 101
Volume of thinner	Nil

Note:

- For best results, use the mixed paint within 6 hours of mixing.
- The larger period will reduce the lustre of the paint.
- Product should not be applied on hot surfaces

CLEANING

- Do not allow the product to remain in hoses, gun or spray equipment. Clean all equipments immediately after use with thinner T - 101. It is recommended to periodically flush out spray equipment during the course of the working day. The frequency of cleaning will depend on amount sprayed, temperature and time gap
- All surplus material and empty containers should be disposed of in accordance with appropriate regional legislation.

PRODUCT CHARACTERISTICS

- The maximum performance is achieved after complete drying
- At higher relative humidity, drying may get retarded
- Application of primer is necessary to ensure the adhesion and improve corrosion resistance
- Not recommended for use in highly acidic environment or where acid/ alkali spillage occurs

PACK SIZE	4 ltrs
STORAGE	Shelf Life: Atleast 12 months @ 30°C for original unopened pack, subject to inspection thereafter. Store in a cool, dry place and in accordance with local regulations
REGULATORY INFORMATION	Flash point Not less than 30°C
	VOC 540 ± 10 gm/ ltr (depending on shades)as per USA-EPA Method 24
	Product Weight Approx 0.95 ± 0.02 kg/ ltr

SAFETY INFORMATION

- As a general safety measure, inhalation of solvent vapours or paint mist and contact of liquid paint with skin & eyes, should be avoided. Forced ventilation should be provided when applying paint in confined spaces or stagnant air.
Even when ventilation is provided, respiratory, skin and eye protection are always recommended when spraying paint.
- Please refer our Material Safety Data Sheet prior to using the product.

Disclaimer:

To the best of our knowledge the information provided herein are true and accurate at the date of issuance. Since we have no control over the quality or condition of the substrate or the various factors affecting the use and application of the product, we do not accept any responsibility or liability arising out of use of the product.

The company reserves the right to modify data contained herein without prior notice. Any change in data would normally be followed by issue of a new data-sheet. The user should check with the nearest sales office of the company and confirm the validity of the information, prior to using the product.

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