ACRATHANE® IF SPARKLING ALUMINIUM
Isocyanate Free Catalysed Acrylic Metallic Finish

FEATURES
- BRIGHT METALLIC SPARKLE
- VISUALLY STRIKING
- GOOD WEATHERING AND CHEMICAL RESISTANCE
- GOOD ABRASION RESISTANCE AND TOUGHNESS

USES
ACRATHANE® IF SPARKLING ALUMINIUM is a gloss, two component, catalysed acrylic with aluminium flake pigment to impart a bright metallic sparkle to the finish. It is user friendly and can be recoated with itself after simply ensuring the surface is clean and has been lightly abraded.

ACRATHANE® IF SPARKLING ALUMINIUM is isocyanate-free and suited to on-site application.

ACRATHANE® IF SPARKLING ALUMINIUM has high visual impact and is ideal for architectural features such as awnings, columns, facades, lifts and joinery in retail spaces, lobbies, reception areas and showrooms.

ACRATHANE® IF CLEARCOAT may be applied over ACRATHANE® IF SPARKLING ALUMINIUM to extend design life.

SPECIFICATIONS
AS/NZS 3750.5

RESISTANCE GUIDE

<table>
<thead>
<tr>
<th>WEATHERABILITY</th>
<th>Good gloss and colour retention on exterior exposure</th>
</tr>
</thead>
<tbody>
<tr>
<td>SOLVENTS</td>
<td>Resists splash and spillage of most organic solvents</td>
</tr>
<tr>
<td>HEAT RESISTANCE</td>
<td>Up to 100°C dry heat</td>
</tr>
<tr>
<td>WATER</td>
<td>Excellent resistance to fresh and salt water but not suitable for immersion</td>
</tr>
<tr>
<td>SALTS</td>
<td>Unaffected by splash and spillage of neutral and alkaline salt solutions</td>
</tr>
<tr>
<td>ALKALIS</td>
<td>Fair resistance to splash and spillage of most common alkalis</td>
</tr>
<tr>
<td>ACIDS</td>
<td>Unsuitable for acid conditions</td>
</tr>
<tr>
<td>ABRASION</td>
<td>Good when fully cured</td>
</tr>
</tbody>
</table>

TYPICAL PROPERTIES AND APPLICATION DATA

CLASSIFICATION
- Two Component Catalysed Acrylic

APPLICATION CONDITIONS
- Air Temp.: 10°C - 45°C
- Substrate Temp.: 10°C - 45°C
- Relative Humidity: 85%

FILM THICKNESS (MICRONS)
- Wet film per coat (μm): 110 - 155 - 135
- Dry film per coat (μm): 50 - 70 - 60

COMPONENTS
Two

VOLUME SOLIDS
45%

VOC LEVEL
<530 g/L

FLASH POINT
15°C

POT LIFE
6 hours (4 litre kit, 25°C)

MIXING RATIO V/V
Part A : 4 Part B : 1

THINNER – BRUSH
965-42166 Duthin 040

THINNER – SPRAY
965-63023 Dulux Urethane Thinner

PRODUCT CODE
- Sparkling Aluminium
- Hardener

APPLICATION METHODS
- Conventional, airless spray or air assisted spray

APPLICATION SUBSTRATES
- Suitably primed steel, aluminium, zinc coated steel, fibreglass or MDF

PRIMERS
Most Dulux two pack epoxy primers (Apply within 24 hours of epoxy application).

OVERCOAT

<table>
<thead>
<tr>
<th>Temperature</th>
<th>Humidity</th>
<th>Touch</th>
<th>Handle</th>
<th>Full Cure</th>
<th>Min</th>
<th>Max</th>
</tr>
</thead>
<tbody>
<tr>
<td>10°C</td>
<td>50%</td>
<td>1.5 Hours</td>
<td>16 Hours</td>
<td>7 Days</td>
<td>16 Hours</td>
<td>Extended</td>
</tr>
<tr>
<td>15°C</td>
<td>50%</td>
<td>1 Hour</td>
<td>10 Hours</td>
<td>7 Days</td>
<td>10 Hours</td>
<td>Extended</td>
</tr>
<tr>
<td>25°C</td>
<td>50%</td>
<td>30 Minutes</td>
<td>7 Hours</td>
<td>7 Days</td>
<td>8 Hours</td>
<td>Extended</td>
</tr>
</tbody>
</table>

OVERCOAT

<table>
<thead>
<tr>
<th>Temperature</th>
<th>Humidity</th>
<th>Touch</th>
<th>Handle</th>
<th>Full Cure</th>
<th>Min</th>
<th>Max</th>
</tr>
</thead>
<tbody>
<tr>
<td>10°C</td>
<td>50%</td>
<td>1.5 Hours</td>
<td>16 Hours</td>
<td>7 Days</td>
<td>16 Hours</td>
<td>Extended</td>
</tr>
<tr>
<td>15°C</td>
<td>50%</td>
<td>1 Hour</td>
<td>10 Hours</td>
<td>7 Days</td>
<td>10 Hours</td>
<td>Extended</td>
</tr>
<tr>
<td>25°C</td>
<td>50%</td>
<td>30 Minutes</td>
<td>7 Hours</td>
<td>7 Days</td>
<td>8 Hours</td>
<td>Extended</td>
</tr>
</tbody>
</table>

*These figures are a guide only, as ventilation, film thickness, humidity, thinning and other factors will influence the rate of drying.

When applying over epoxies, ensure that the application is carried out within 24 hours of applying the epoxy.

SPREADING RATE
7.5 square metres per litre equals 60 μm dry film thickness

NOTE: Practical spreading rates will vary depending on such factors as application method, ambient conditions and surface roughness.
ACRATHANE® IF SPARKLING ALUMINIUM

TYPICAL SYSTEMS

This is a guide only and not to be used as a specification. Your specific project needs must be discussed with a Dulux Protective Coatings Consultant.

<table>
<thead>
<tr>
<th>SURFACE</th>
<th>ENVIRONMENT</th>
<th>PREPARATION GUIDE</th>
<th>SYSTEM</th>
<th>DFT (μm)</th>
</tr>
</thead>
<tbody>
<tr>
<td>STEEL</td>
<td>Very high corrosivity (AS2312.1 Cat C5) Exceeds System ACC6</td>
<td>Abrasive blast AS1627.4 Class 2.5</td>
<td>1st Coat Zincanode® 402</td>
<td>75 μm</td>
</tr>
<tr>
<td></td>
<td></td>
<td></td>
<td>2nd Coat Duramex® GPE</td>
<td>200 μm</td>
</tr>
<tr>
<td></td>
<td></td>
<td></td>
<td>3rd Coat Acrathane® IF Sparkling Aluminium</td>
<td>60 μm</td>
</tr>
<tr>
<td></td>
<td></td>
<td></td>
<td>4th Coat Acrathane® IF Clearcoat</td>
<td>60 μm</td>
</tr>
<tr>
<td>STEEL</td>
<td>Low corrosivity (AS2312.1 Cat C2) Exceeds System ACC2</td>
<td>Abrasive blast AS1627.4 Class 2.5</td>
<td>1st Coat Durepon® P14</td>
<td>75 μm</td>
</tr>
<tr>
<td></td>
<td></td>
<td></td>
<td>2nd Coat Acrathane® IF Sparkling Aluminium</td>
<td>60 μm</td>
</tr>
<tr>
<td></td>
<td></td>
<td></td>
<td>3rd Coat Acrathane® IF Clearcoat</td>
<td>60 μm</td>
</tr>
<tr>
<td>ALUMINIUM</td>
<td>Exterior/Interior</td>
<td>Clean, degrease and abrade surface</td>
<td>1st Coat Luxepoxy® 4 White Primer</td>
<td>50 μm</td>
</tr>
<tr>
<td></td>
<td></td>
<td></td>
<td>2nd Coat Acrathane® IF Sparkling Aluminium</td>
<td>60 μm</td>
</tr>
<tr>
<td></td>
<td></td>
<td></td>
<td>3rd Coat Acrathane® IF Clearcoat (Optional)</td>
<td>60 μm</td>
</tr>
</tbody>
</table>

NOTE: If application is by brush or roller, additional coats will be necessary to achieve the minimum DFT and full opacity.

SURFACE PREPARATION

Specifiers should follow the surface preparation guidelines from the data sheet for the primer selected. The surface must be free from grease, oil, dirt, rust and other contaminants. If applying over an epoxy primer, ensure that this product is applied within 24 hours, otherwise the epoxy must be thoroughly sanded to provide a key.

APPLICATION

Mix each can thoroughly using a power mixer until the contents are uniform. Mix both packs together thoroughly with a power mixer and let stand for 10 minutes. Remix thoroughly before and during application.

BRUSH/ROLLER

Suitable for small areas only. Application can be improved by thinning with up to 100 ml/litre with DUTHIN® 040 (965-42166). When brushing and rolling additional coats may be required to attain the specified thickness. Note – The appearance of Acrathane® IF Sparkling Aluminium depends on thinning levels and application technique. The finish achieved by brush and roller will differ greatly from that obtained by spray application

CONVENTIONAL SPRAY

Thin up to 200ml/litre with Dulux Urethane Thinner (965-63023) to aid atomisation. Note – The appearance of Sparkling Aluminium is dependent on thinning levels, film build, spray technique and direction and gun set-up.

AIRLESS SPRAY

Standard airless spray equipment such as a Graco Xtreme 30:1 with a fluid tip of 15-17 thou (0.38-4.43mm) and an air supply capable of delivering 550-660 KPa (80-100 p.s.i.) at the pump. Thinning is not normally required but up to 100 ml/litre of Dulux Urethane Thinner (965-63023) may be added to ease application.

PRECAUTIONS

This is an industrial product designed for use by experienced Protective Coating applicators. When conditions may require variation from the recommendations on this Product Data Sheet contact your nearest Dulux® Consultant for advice prior to painting. Do not apply in conditions outside the parameters stated in this document without the express written consent of Dulux® Australia. Freshly mixed material must not be added to previously mixed material. The rate of cure is dependent upon temperature. Do not apply at temperatures below 10°C. Do not apply at relative humidity above 85% or when the surface is less than 3°C above the dewpoint. The surface to be coated must be totally free of moisture and contaminants. Ensure that in all circumstances Acrathane® IF Sparkling Aluminium is applied over epoxy primers and intermediates within 24 hours of applying the epoxy. Note – When applying Sparkling Aluminium, colour and appearance are dependent on thinning levels, film build, application method, technique and spray angle. Control of these parameters is especially important when coatings are used on cladding or broad wall areas. Do not use this product without consulting a Dulux® Protective Coatings Consultant.

CLEAN UP

Clean all equipment with Dulux® Urethane Thinner (965-63023) immediately after use.

OVERCOATING

Degrease with Gilmer CA 1 according to the data sheet. Test adhesion of existing coating by standard cross hatch adhesion test. If the coating fails, remove it. High-pressure water wash at 8.3 to 10.3 MPa (1,200-1,500 p.s.i.) to remove chalk and dust. Abrade surface to provide a good key for the new coating. Epoxies must be abraded if recoated outside the recoat window.

SAFETY PRECAUTIONS

Read Data Sheet, SAFETY DATA SHEET and any precautions on container labels. SAFETY DATA SHEET is available from Customer Service (13 23 77) or www.duluxprotectivecoatings.com.au

STORAGE

Store as required for a flammable liquid Class 3 in a bunded area under cover. Store in well-ventilated area away from sources of heat or ignition. Keep containers closed at all times.

HANDLING

As with any chemical, ingestion, inhalation and prolonged or repeated skin contact should be avoided by good occupational work practice. Eye protection approved to AS1337 should be worn where there is a risk of splashes entering the eyes. Always wash hands before smoking, eating, drinking or using the toilet.

USING

Use with good ventilation and avoid inhalation of spray mists and fumes. If risk of inhalation of spray mists exists, wear combined organic vapour/particulate respirator. When spraying, users must comply with their respective State Spray Painting Regulations.

FLAMMABILITY

This product is flammable. All sources of ignition must be eliminated in, or near the working area. DO NOT SMOKE. Fight fire with foam, CO₂ or dry chemical powder. On burning will emit toxic fumes.

WELDING

Avoid inhalation of fumes if welding surfaces coated with this paint. Grind off coating before welding.

COMPANY WELDING

Dulux Protective Coatings a division of

DuluxGroup (Australia) Pty Ltd
1956 Dandenong Road, Clayton 3168
A.B.N. 87 000 049 427

DuluxGroup (New Zealand) Pty Ltd
150 Hut Park Road, Lower Hut, NZ
A.B.N. 55 133 144 118

PACKAGING, TRANSPORT AND STORAGE

PACKAGING Available in 4 litre packs

TRANSPORTATION WEIGHT 1.01 kg/litre (Average of components)

DANGEROUS GOODS Part A: Class 3 UN 1263
Part B: Class 3 UN 1263

©Dulux, Acrathane, Duthin, Duramex, Durepon, Luxepoxy and Zincanode are registered trade marks of DuluxGroup (Australia) Pty Ltd.