

ACRATHANE® IF SPARKLING ALUMINIUM

Isocyanate Free Catalysed Acrylic Metallic Finish

PC 211

- 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

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

TYPICAL PROPERTIES AND APPLICATION DATA

CLASSIFICATION	Two Component Catalysed Acrylic		APPLICATION CONDITIONS			
FINISH	Gloss			Min	Max	
COLOUR	Sparkling Aluminium		Air Temp.	10°C	45°C	
			Substrate Temp.	10°C	45°C	
			Relative Humidity		85%	
COMPONENTS	Two		FILM THICKNESS (MICRONS)			
VOLUME SOLIDS	45%			Min	Max	Recommended
VOC LEVEL	<530 g/L		Wet film per coat (µm)	110	155	135
FLASH POINT	15°C		Dry film per coat (µm)	50	70	60
POT LIFE	6 hours (4 litre kit, 25°C)		SUITABLE SUBSTRATES	Suitably primed steel, aluminium, zinc coated steel, fibreglass or MDF		
MIXING RATIO V/V	Part A : 4	Part B : 1	PRIMERS	Most Dulux two pack epoxy primers (Apply within 24 hours of epoxy application).		
THINNER –BRUSH	965-42166	Duthin 040	APPLICATION METHODS	Conventional, airless spray or air assisted spray		
THINNER –SPRAY	965-63023	Dulux Urethane Thinner				
PRODUCT CODE	446-81814	Sparkling Aluminium Hardener				
	976-51087					

DRYING CHARACTERISTICS AT 60 µm DRY FILM THICKNESS*

Temperature	Humidity	Touch	Handle	Full Cure	OVERCOAT	
					Min	Max ¹
10° C	50%	1.5 Hours	16 Hours	7 Days	16 Hours	Extended
15° C	50%	1 Hour	10 Hours	7 Days	10 Hours	Extended
25° C	50%	30 Minutes	7 Hours	7 Days	8 Hours	Extended

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

¹When applying over epoxies, ensure that the application is carried out within 24 hours of applying the epoxy.

SPREADING RATE ASSUMING NO LOSSES

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.

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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.

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

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 is dependent 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. Typical Set-up Graco Airpro 1.4mm (239542) Pressure at Triton 308: 70-100 kPa (10-15 p.s.i.) Pressure at Gun: 380-410 kPa (55-60 p.s.i.)
AIRLESS SPRAY	Standard airless spray equipment such as a Graco Xtreme 30:1 with a fluid tip of 15-17 thou (0.38-0.43mm) and an air supply capable of delivering 550-690 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. Where 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 Gamlen 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 bonded 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, CO ₂ 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 INFORMATION

Dulux Protective Coatings a division of

DuluxGroup (Australia) Pty Ltd
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DuluxGroup (New Zealand) Pty Ltd
150 Hutt Park Road, Lower Hutt, NZ
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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

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