INDUSTRIAL ALUMINIUM
Heat Resisting Aluminium Enamel
PC 652

FEATURES
- WITHSTANDS TEMPERATURES TO 200°C
- EXCELLENT HEAT REFLECTIVE PROPERTIES
- EXCELLENT WEATHERING RESISTANCE
- HIGH METALLIC LUSTRE
- GOOD MOISTURE RESISTANCE
- RECOMMENDED FOR STORAGE TANKS FOR HEAT REFLECTION

USES
INDUSTRIAL ALUMINIUM is a durable oleoresinous enamel coating containing high levels of aluminium flake. The finish provides a bright metallic sheen and excellent heat reflective properties. INDUSTRIAL ALUMINIUM is recommended for all applications requiring temperature control. INDUSTRIAL ALUMINIUM is formulated to give relatively high resistance to moisture and weathering for a single pack low film coating.

INDUSTRIAL ALUMINIUM has been extensively used over conventional and epoxy metal primers for overland pipelines, tank farms, silos, ducting and general structural steelwork. Also suitable for the protection of galvanised steel roofing, gates and fencing.

SPECIFICATIONS

RESISTANCE GUIDE

WEATHERABILITY
Excellent. Superior to conventional alkyd enamels

SOLVENTS
Resists splash and spillage of aliphatic hydrocarbons

HEAT RESISTANCE
Up to 200°C dry heat

WATER
Resists rain and condensation. Not recommended for permanently damp or immersed exposure

SALTS
Excellent resistance to neutral salt solutions

ALKALIS
Not recommended where fumes, splash or spillage may occur

ACIDS
Not recommended where fumes, splash or spillage may occur

ABRASION
Fair when fully cured

TYPICAL PROPERTIES AND APPLICATION DATA

CLASSIFICATION
Heat resisting aluminium enamel

APPLICATION CONDITIONS
Min Max
Air Temp. 5°C 45°C
Substrate Temp. 5°C 45°C
Relative Humidity 85%

COATING THICKNESS (MICRONS)
Min Max Recommended
Wet film per coat (μm) 45 70 55
Dry film per coat (μm) 15 25 20

COMPONENTS
One

SUITABLE SUBSTRATES
Suitably primed steel, aluminium and galvanised steel

VOLUME SOLIDS
36%

PRIMERS
Most Dulux® single pack and two pack primers

VOC LEVEL
<500 g/L

TOPCOATS
Not applicable

FLASH POINT
-3°C

APPLICATION METHODS
Brush, roller, conventional, airless spray or air assisted spray

POT LIFE
Not applicable

PRODUCT CODE
325-63008 Industrial Aluminium

MIXING RATIO V/V
Single Pack

THINNER – BRUSH
Duthin® 340 Spray Thinner

THINNER – SPRAY
965-63034

NOTE: Practical spreading rates will vary depending on such factors as application method, ambient conditions, surface porosity and roughness.

SPREADING RATE
18.0 square metres per litre equals 20 μm dry film thickness

DRYING CHARACTERISTICS AT 20 μm DRY FILM THICKNESS*

<table>
<thead>
<tr>
<th>Temperature</th>
<th>Humidity</th>
<th>Touch</th>
<th>Handle</th>
<th>Full Cure</th>
<th>Overcoat</th>
</tr>
</thead>
<tbody>
<tr>
<td>25°C</td>
<td>50%</td>
<td>4-6 Hours</td>
<td>16 Hours</td>
<td>7 Days</td>
<td>16 Hours 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.
## INDUSTRIAL 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>
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<tr>
<th>SURFACE</th>
<th>ENVIRONMENT</th>
<th>PREPARATION GUIDE</th>
<th>SYSTEM</th>
<th>DFT (μm)</th>
</tr>
</thead>
<tbody>
<tr>
<td>STEEL – NEW</td>
<td>Mild – Medium corrosivity (AS2312 Cat C2-4)</td>
<td>Abrasive blast AS1627.4 Class 2 or power tool clean AS1627.2 St 3</td>
<td>1st Coat</td>
<td>Luxaprime® ZP</td>
</tr>
<tr>
<td></td>
<td></td>
<td></td>
<td>2nd Coat</td>
<td>Industrial Aluminium</td>
</tr>
<tr>
<td></td>
<td></td>
<td></td>
<td>3rd Coat</td>
<td>Industrial Aluminium</td>
</tr>
<tr>
<td>STEEL – NEW</td>
<td>Very low corrosivity (AS2312 Cat C1)</td>
<td>Abrasive blast AS1627.4 Class 2 or power tool clean AS1627.2 St 3</td>
<td>1st Coat</td>
<td>Industrial Aluminium</td>
</tr>
<tr>
<td></td>
<td></td>
<td></td>
<td>2nd Coat</td>
<td>Industrial Aluminium</td>
</tr>
</tbody>
</table>

### SURFACE PREPARATION

Specifiers should follow the surface preparation guidelines from the data sheet for the primer or first coat selected.

**Steel:** Round off all rough welds, sharp edges and remove weld spatter. Remove grease, oil and other contaminants in accordance with AS1627.1. Degrease with Gamlen CA 1 (a free-rinsing, alkaline detergent) according to the manufacturer’s data sheet. Abrasive blast clean to a minimum of AS1627.4 Class 2. Remove all dust brushing or vacuum. **Steel where abrasive blast cleaning is not viable:** Rust, mill scale, oxide deposits and old paint films on metal surfaces must be removed by power tool cleaning according to AS1627.2 Class 2.

**Aluminium:** Round off all sharp edges. Remove grease, oil and other contaminants in accordance with AS1627.1. Whip blast with fine non-metallic media to provide a key. Remove all dust. Alternatively, degrease and abrade with an abrasive nylon pad wetted with Gamlen CA 1 and water. Rinse thoroughly with potable water.

### APPLICATION

Mix each can thoroughly using a power mixer until the contents are uniform. Remix thoroughly before and occasionally during application to prevent settling.

**Brush/Roller**

Apply even coats to the prepared surface. Thin if necessary with up to 50 ml/litre with mineral turpentine to aid application. When brushing and rolling additional coats may be required to attain the specified thickness.

**Conventional Spray**

Thin up to 50ml/litre with Duthin® 340 Spray Thinner (965-63034) to aid atomisation. Add only enough thinner to achieve atomisation. Apply in multiple wet coats overlapping each pass 50%.

**Airless Spray**

Standard airless spray equipment such as a Graco Xtreme 30:1 or Graco Merkur 30:1 with a fluid tip of 13-15 thou (0.33-0.38mm) 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 50 ml/litre of Duthin® 340 Spray Thinner (965-63034) may be added to aid 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® representative 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. Do not apply at temperatures below 5°C. Do not apply at relative humidity above 85% or when the surface is less than 3°C above the dewpoint. Do not overcoat before the minimum overcoat interval or wrinkling may occur. This product must not be directly applied on galvanised iron or zinc rich coatings.

### CLEAN UP

Clean all equipment with Duthin® 340 Spray Thinner (965-63034) 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.

### 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.

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 Pty Ltd

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