

# Technical Data

## Aluminium Paint H.R.



### Product description

Aluminium Paint H.R. is a heat resistant paint, based on an air-drying, styrene modified oil.

---

### Recommended use

On steel items exposed to temperatures up to 250°C, e.g. exhaust pipes, engine parts etc. Can be used as an exterior aluminium finish usually within an alkyd system.

---

### Film thickness and spreading rate

	Minimum	Maximum	Typical
Film thickness, dry (µm)	20	30	25
Film thickness, wet (µm)	45	65	55
Theoretical spreading rate (m <sup>2</sup> /l)	22,5	15	18

---

### Physical properties

Colour	Aluminium
Solids (vol %)*	45 ± 2
Flash point	42°C ± 2 (Setaflash)
VOC	480 gms/ltr UK-PG6/23(97). Appendix 3
Gloss	Aluminium sheen
Abrasion resistance	Fair
Flexibility	Good

\*Measured according to ISO 3233:1998 (E)

---

### Surface preparation

All surfaces should be clean, dry and free from contamination. The surface should be assessed and treated in accordance with ISO 8504.

#### Bare steel

Cleanliness: Blast cleaning to Sa 2½ (ISO 8501-1:2007). Roughness: using abrasives suitable to achieve grade Fine to Medium G (30-85 µm, Ry5) (ISO 8503-2)

## Other surfaces

The coating may be used on other substrates. Please contact your local Jotun office for more information.

---

## Condition during application

The temperature of the substrate should be minimum 3°C above the dew point of the air, temperature and relative humidity measured in the vicinity of the substrate. Good ventilation is usually required in confined areas to ensure correct drying.

---

## Application methods

<b>Spray</b>	Use airless spray or conventional spray
<b>Brush</b>	Recommended for stripe coating and small areas, care must be taken to achieve the specified dry film thickness.
<b>Roller</b>	May be used for small areas but not recommended for first primer coat, however when using roller application care must be taken to apply sufficient material in order to achieve the specified dry film thickness.

---

## Application data

<b>Mixing ratio (volume)</b>	Single pack.
<b>Thinner/Cleaner</b>	Jotun Thinner No. 2
<b>Guiding data airless spray</b>	
<b>Pressure at nozzle</b>	15 MPa (150 kp/cm <sup>2</sup> , 2100 psi.).
<b>Nozzle tip</b>	0.38 - 0.46 mm (0.015 - 0.018").
<b>Spray angle</b>	40 - 60°
<b>Filter</b>	Check to ensure that filters are clean.

---

## Drying time

Drying times are generally related to air circulation, temperature, film thickness and number of coats, and will be affected correspondingly. The figures given in the table are typical with:

- \* Good ventilation (Outdoor exposure or free circulation of air)
- \* Typical film thickness
- \* One coat on top of inert substrate

<b>Substrate temperature</b>	<b>5°C</b>	<b>10°C</b>	<b>23°C</b>	<b>40°C</b>
<b>Surface dry</b>	1/2 h	1/2 h	1/2 h	1/4 h
<b>Through dry</b>	18 h	14 h	10 h	8 h
<b>Dry to recoat, minimum</b>	24 h	12 h	8 h	6 h

The given data must be considered as guidelines only. The actual drying time/times before recoating may be shorter or longer, depending on film thickness, ventilation, humidity, underlying paint system, requirement for early handling and mechanical strength etc. A complete system can be described on a system sheet, where all parameters and special conditions could be included.

---

## Typical paint system

Aluminium Paint H.R.                      2 x 25 µm                      (Dry Film Thickness)

Other systems may be specified, depending on area of use

---

## Storage

The product must be stored in accordance with national regulations. Storage conditions are to keep the containers in a dry, cool, well ventilated space and away from source of heat and ignition. Containers must be kept tightly closed.

---

## Handling

Handle with care. Stir well before use.

---

## Packing size

5 litre container.

Packing may vary from country to country according to local requirements.

---

## Health and safety

Please observe the precautionary notices displayed on the container. Use under well ventilated conditions. Do not breathe or inhale 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.

**For detailed information on the health and safety hazards and precautions for use of this product, we refer to the Material Safety Data Sheet.**

---

## DISCLAIMER

The information in this data sheet is given to the best of our knowledge based on laboratory testing and practical experience. However, as the product can be used under conditions beyond our control, we can only guarantee the quality of the product itself. We also reserve the right to change the given data without notice. Minor product variations may be implemented in order to comply with local requirements.

If there is any inconsistency in the text the English (UK) version will prevail.

Jotun is a World Wide company with factories, sales offices and stocks in more than 50 countries. For your nearest local Jotun address please contact the nearest regional office or visit our website at [www.jotun.com](http://www.jotun.com)

ISSUED 26 NOVEMBER 2010 BY JOTUN  
THIS DATA SHEET SUPERSEDES THOSE PREVIOUSLY ISSUED