CODE: AL-158

PRODUCT NAME: ALKYD Top COAT Aluminum (Non-Leafing)

DESCRIPTION:

AL-158 is a versatile intermediate coat based on long oil alkyd resin complies with IPS-M-TP-155. AL 158 is a single pack alkyd decorative paint with heat resistance property more than other types of Alkyd coatings and also with good abrasion resistance for interior and exterior structures in Semi-Industrial environments above water. It is recommended for apply on steel, machinery parts, pipes, tanks. AL-158 is not suitable for immersion and should not be used in alkaline conditions. It is not designed for application over epoxies or polyurethanes, and should not be applied over zinc based primers because of dangers specification of the alkyd resin and consequent adhesion loss.

TECHNICAL DATA:

Binder	Alkyd resin
Pigment	Aluminum Flake
Finish	Semi Flat
Shade	Silver (Non-Leafing)
Specific gravity	0.95 ± 0.05 Kg/Lit
Volume solids	40 ± 3 %
Flash point	37 ºC
Typical dry film thickness	40-80 Microns per one coat
Number of coat	One or two
Substrate	Primed steel
Application method	Conventional or Airless Spray, brush , roller
Thinner / Cleaner	T-100
Weight of added thinner	Max 5%
Temperature resistance	Continues 120ºc Noncontiguous 150ºc
Theoretical spreading rate - one coat (at 40 microns)	10 M²/Lit
Packing	4 kg Or 20kg
Shelf life (cool and dry place)	12 Months

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Drying Time

Temp	Touch dry	Hard dry	Over coating Min	Max
15°C	5 ½ hours	29 hours	25 hours	45 days
25°C	3 hours	24 hours	20 hours	1 months
40°C	2 hours	18 hours	15 hours	20 days

Note 1: Drying times are dependent on applied film thickness; all data in this catalogue are reported at recommended DFT.

SURFACE PREPARATION

All surfaces to be coated should be clean, dry and free from contamination.
High pressure fresh water wash or fresh water wash, as appropriate, and remove all oil or grease, soluble contaminants, and other detrimental foreign matter in accordance with SSPC-SP1 solvent cleaning .
AL-158 should always be applied over a recommended primer coating scheme. The primer surface should be dry and free from all contamination, and AL-158 must be applied within the overcoating intervals specified (consult the relevant product data sheet). Areas of breakdown, damage etc. should be prepared to the specified standard (eg. Sa2½ (ISO 8501-1: 1988)) and patch primed prior to the application of AL-158.
AL-158 may be applied directly over aged AL-158 following thorough fresh water washing and degreasing provided the coating to be overcoated is in an intact and tightly adherent condition. Loose or flaking coatings should be removed back to a firm edge and AL-158 or an appropriate primer should be used to repair the area before application of the full coat.
- Surface preparation shall not take place in the following conditions:
A) At temperature below 5 ºC.
B) When the relative humidity greater than 85%.
C) When the metal surface temperature is less than 3 ºC above the dew point.
D) Outside day light hours on exterior location.

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Application Method:

This material is a one component coating and should always be mixed thoroughly with a power agitator before application.

1. Flush all equipment with recommended cleaner before use.
2. Stir the product thoroughly with a power mixer.
3. For conventional spray, thin with no more than 15% of recommended thinner for workability. For airless spray 5% of thinner is normally sufficient.
4. Apply a wet coat by parallel passes. Overlap each pass 50% to avoid bare areas, pinholes or holidays.
5. Double coat all welds, rough spots, sharp edges, rivets, bolts, etc. to ensure proper thickness.
6. Check thickness of dry coating with a non-destructive dry film thickness gauge. Recoat if greater thickness is required.

Note: If the maximum recoating interval is exceeded, roughening of the surface is necessary to ensure intercoat adhesion.
Before recoating after exposure in contaminated environment, clean the surface thoroughly by (high pressure) fresh water hosing and allow drying.

7. Random pinholes, holidays and small damaged or bare areas can be touched up by brush when the film is dry to touch. Larger areas should be replayed.
8. in confined areas ventilate with clean air during application and drying until all solvents are removed.
9. Clean all equipment with recommended cleaner immediately

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Application Equipments

Air less Spray	Tip range 0.013-0.019inch Total output pressure at spray tip not less than 141 Bar (2000 psi)
Air Spray	Nozzle Orifice:1.2-1.8mm Nozzle Pressure:2-3 Bar (29-43 psi)
Brush	Typically 50 mic can be achieved.
Roller	Typically 30 mic can be achieved.

Flush Equipment with recommended Cleaner before and after use.

ENVIRONMENTAL CONDITIONS:

-For satisfactory cure, air and surface temperature must be above 10 ºC.
- To prevent moisture condensation during application, surface temperature must be at least 3 ºC above the dew point.
- Never apply coatings under reverse environmental condition.
- Paint shall not be applied when wind speed is in excess of 7 m/s.

Air temperature	10 to 40 ºC
Surface temperature	10 to 50 ºC
Material temperature	15 to 40 ºC
Relative humidity	Max 80 %

Health and Safety:

This product is Flammable. Keep away from heat and open flame .Keep container closed .Use with adequate ventilation. Avoid prolonged and repeated contact with skin. If used in confined areas, observe the following precautions to prevent hazards of fire or explosion or damage to the health:

1-Circulate adequate fresh air continuously during application and drying.

2-Use fresh air masks and explosion proof equipment.

3- Prohibit all flames, sparks, welding and smoking.

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