



DIXIE ALUMINIUM PAINT

Heat Resistant Aluminum Finish

Technical data sheet

Product description

Dixie Aluminum Paint is a one component, solvent based, coating. It is enriched with thermal resistant and heat reflective aluminum pigments. The coating produces thermally stable finish up to 200°C of dry and continuous heat.

Physical properties

Finish / Colors	Metallic lustered –Aluminum finish
Volume Solid –ASTM D 2697	33 ±2%
Flash Point –ASTMD 3278	25°C
VOC –ASTM D 3960	< 560 grams/ liter

Usage data	Dry film thickness per coat (μ)	Wet film thickness per coat (μ)	Theoretical spreadingrate (m2/l)
Range	20 -30	60 -90	11 –16.5
Recommended	25	75	13.2

Advantages and Intended use

- Suitable for exterior of tanks, pipes, poles, roofs and general machine parts.
- Requires no hardener mixing and has no potlife restriction, giving low application cost with minimum wastage.
- Provides general purpose thermal reflective and heat resistant finish.
- As a suitable topcoat in a new or maintenance projects.

Performance and Certifications

- Meets requirements of C3exposure,asoutlined in ISO 12944-5 when used as part of a coating system.
- Other certificates are available upon request.



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Application data

<u>Mixing Ratio</u>	Single pack Not applicable Pressure at nozzle : 2000 -2500 psi.
<u>Pot life</u>	Nozzlesize : 0.011 -0.015 in
<u>Airless spray</u>	Spray angle: 40 -80 degree. Typically thinner not required Pressure at nozzle : 35 -50 psi. Nozzle size : 1.8 -2.2mm Spray angle: 40 -80 degree.
<u>Airassisted gun</u>	Typically thinner not required Applicable for inaccessible area, corners and edges. Multiple coat may be required for desired film thickness. Typically thinner not required Humidity : Below 85% RH, Temperature of the substrate should be at least 3°C
<u>Brush /Roller</u>	above the dew point of the air. Application temperature : min 10°C, maximum 45°C Dixie GP Thinner
<u>Conditions</u>	
<u>Thinner /Cleaner</u>	

Storage and handling

<u>Storage instruction</u>	Product must be stored according to local regulations and manufacturer recommendation. Recommended to store at 30°C, away from direct sunlight, heat, source of ignition and exposure to water or rain, within a well ventilated place.
<u>Packaging</u>	Available in 0.9Liter, 3.6 Liters and 18 Liters.
<u>Shelf life</u>	24 months in original sealed drums from the date of manufacture when stored at or below 30°C.



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Curing -time	Substrate temperature			
	10°C	20°C	30°C	40°C
Touch dry	2 hours	1.5 hours	1 hour	45 minutes
Dry to Handle	48 hours	30 hours	24 hours	20 hours
Recoat interval	Min: 48 hours	Min: 30 hours	Min: 24 hours	Min: 20 hours
	Max: Indefinite*	Max: Indefinite*	Max: Indefinite*	Max: Indefinite*

Drying and curing times are determined under controlled temperatures and relative humidity below 85 %, and at average of the DFT range for the product and should be considered as guidelines only. The actual drying time/times may be shorter or longer, depending on film thickness, temperature, ventilation, humidity, preceding paint system etc.

*The surface should be dry and free from contaminants prior to over coating. The best intercoat adhesion is achieved when the subsequent coat is applied before the preceding coat is fully cured. When recoating with products, maximum recoat interval is limited. After prolonged exposure it may be necessary to roughen the surface to ensure intercoat adhesion. When in doubt, consult your nearest Dixie paints representative.

Surface preparation

Steel

Oil and grease should be removed by solvent cleaning according to SSPC-SP1. Remove weld spatter and smooth weld seams and sharp edges as applicable. Abrasive blasting: min. Sa2 – ISO 8501:1 or Power tool cleaning: min. ISO-St3. Please note that better surface preparation always results in longer lifetime expectations. Apply coating immediately after the steel has been cleaned and the quality of preparation has been approved.

Coated surface

All surfaces should be clean, dry and free from contamination. Surfaces should be treated in accordance with ISO 8504:2000. Ensure compatibility of the coated substrates with the selected paint system. If the remaining part of the existing coating system needs to be sweep-blasted, fine abrasive shall be used to avoid damage to the coating system. When recoating aged coated substrates, damaged areas must be removed back to a firm edge. Light abrade or sweep-blast the surface in order to provide a physical key for adhesion feathered.



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Typical coating system

For general purpose

Primer	Dixie Red oxide Primer	50μ
Topcoat	Dixie Aluminum Paint	2 X 25μ

For heat resistant purpose

2 coats	Dixie Aluminum Paint	2 X 25 = 50μ
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Other Information

- Continuous and dry heat resistance up to 250°C. Metallic luster (shine) can slightly reduce after thermal service of coated substrate.
- Recommendations given by Dixie Paints representative will supersede generic recommendations given in the Product Data Sheet.

Safety and Precautions

- Avoid skin and eye contact by wearing overalls, gloves, goggles, and mask etc.
- Eyes: In the event of accidental splash, flush eye with water immediately and obtain medical advice.
- Skin: Wash skin thoroughly with soap and water or medically approved cleaner.
- Avoid inhalation of vapors and paint mist by wearing suitable mask. In the event of ingestion seek medical attention immediately.
- This product is flammable, keep away from sources of ignition. Take precautionary measures against static discharge. In the case of fire – blanket flames with foam, carbon dioxide or dry chemicals. Painting must be carried out in well-ventilated area. Local safety regulation need to be followed.

NOTE: We warranty only the quality of our product and this data sheet is based on results obtained from experience and tests. We reserve the right to change data without prior notice. For safety details kindly refer safety data sheet.