

# APCOTHANE CF 676 ALUMINIUM PAINT / APCOTHANE 676 AL

## PRODUCT DESCRIPTION

Three component, aliphatic polyurethane aluminium coating

## FEATURES & RECOMMENDED USE

- Designed as a top coat for industrially polluted environments
- Good water resistance
- Good weather resistance

## TECHNICAL DATA

Colour	Aluminium
Gloss	Metallic
Volume Solids	Approx. 34 %
Recommended DFT / Coat	20 – 25 µm
Theoretical Coverage Capacity	17.0 sq.mtr/ltr @ 20 µm DFT 13.6 sq.mtr/ltr @ 25 µm DFT
Drying time at 30°C	Surface Dry : 1 hours Hard Dry : 12 hours Full cure : 7 days
Over coating interval at 30°C	Min. : 12 hours Max : Unlimited, provided surface is cleaned from all contamination

The data given is for guideline only. The physical values are subject to normal manufacturing tolerances, colour and testing variances  
The actual drying time/ overcoat interval may be shorter or longer, depending on film thickness, ventilation, humidity, temperature etc.  
The information provided above is at 30°C and 65% relative humidity

## DIRECTIONS FOR USE

### Surface Preparation

#### General

- Surfaces must be dry, clean and free from contaminants
- Ensure removal of dirt, dust, oil and all other contaminants that could interfere with adhesion of the coating. Oil and grease should be removed as per SSPC-SP1 solvent cleaning
- Surface should be checked and treated in accordance with ISO 8504 prior to priming

#### Primed Surfaces

- Suitable epoxy primer, epoxy/polyurethane undercoat; dry & free from all surface contamination
- Apcothane CF 676 Aluminium Paint / Apcothane 676 AL must be applied with the specified over-coating interval of the primer/ under-coat
- In case of aged epoxy coating, the surface should be clean & sufficiently roughened prior to painting

## Application Conditions

- Substrate temperature should be at least 3°C above dew point but not above 50°C
- Relative humidity should be below 85%
- Good ventilation is required in confined areas to ensure proper curing

## Mixing

- Apcothane CF 676 Aluminium Paint / Apcothane 676 AL is supplied in three packs. Stir the base (Part A) and hardener (Part C) separately
- Mix aluminium paste (Part B) gradually into the base (Part A) under continuous stirring till free from lump. Add hardener (Part C) until mixture is homogeneous
- Part A and Part C containers once opened, should be consumed completely. Partial mixing is not recommended
- In case of part mixing (which should be avoided), close the lids of containers tightly to avoid contact with atmospheric moisture
- Part C is likely to get spoiled if kept open for long time, hence should be opened just before mixing
- Once the unit has been mixed, it should be consumed within the working pot life. Thinner should be added after mixing the components and post the induction. Addition of excessive thinner will lead to reduced sag resistance

<b>Mixing Ratio (by weight)</b>	Part A : Part B : Part C 75 : 15 : 10
<b>Induction Time</b>	15 minutes
<b>Pot Life at 30°C</b>	3 hours

## Application

<b>Air Spray</b> Recommended thinner Volume of thinner Nozzle orifice Nozzle Pressure	T 213 0 – 10 % * 1.50 - 3.00 mm 0.3-0.4 MPa (= approx 3-4 atm, 43-57 p.s.i)
<b>Airless Spray</b> Recommended thinner Volume of thinner Nozzle orifice Nozzle Pressure	T 213 0 – 15 % * 0.28 - 0.33 mm 10 -13 MPa (= approx. 100-130 atm; 1400-1800 p.s.i)
<b>Brush / Roller</b> Recommended thinner Volume of thinner	T 213 0 – 5 % *

*\*Note: Depending on recommended thickness & application condition*

## Cleaning

- Do not allow the product to remain in hoses, gun or spray equipment. Clean all equipment's immediately after use with Thinner T 213. It is recommended to periodically flush out spray equipment during the course of the working day. The frequency of cleaning will depend on amount sprayed, temperature and time gap
- All surplus material and empty containers should be disposed off in accordance with appropriate regional legislation

## Product Characteristics

- The finish is dependent on the application method. The best finish is achieved by conventional spray application
- Minimum 2 coat application is recommended to provide adequate hiding and uniformity specially when applied by brush
- Apcothane CF 676 Aluminium Paint / Apcothane 676 AL must be thinned with the recommended thinner only. Usage of alternate thinners will affect the drying and curing process
- Premature exposure to condensation and rain may cause change in colour and finish
- This product is not recommended for use in immersion condition. Extended exposure of strong chemicals, solvents, spillage may result in discoloration

## Over-coating

- Apcothane CF 676 Aluminium Paint / Apcothane 676 AL can be top coated on most epoxy and polyurethane primers/undercoats as recommended by Asian Paints PPG representative.
- When over-coating after weathering or ageing, ensure the surface is free from all contaminations before application of Apcothane CF 676 Aluminium Paint / Apcothane 676 AL. Adhesion on such aged surface largely depends on the extent of secondary surface preparation

<b>PACK SIZE</b>	20 L (Part A - 15.83 L, Part B – 3.05 Kg, Part C – 2.09 L) 4 L (Part A – 3.17 L, Part B – 0.61 Kg, Part C – 0.42 L)
<b>STORAGE</b>	<b>Shelf Life:</b> At least 6 months at 30°C for original unopened pack, subject to inspection thereafter Store in a cool, dry place and in accordance with local regulations
<b>REGULATORY INFORMATION</b>	<b>Flash Point:</b> Base : Not less than 24 °C ; Hardener : Not less than 24 °C <b>VOC:</b> Approx. 610 ± 20 gm/ ltr (depending on shades) as per USA-EPA Method 24 <b>Product Weight:</b> 1.02 kg/ ltr (depending on shades)

## SAFETY INFORMATION

- As a general safety measure, inhalation of solvent vapour or paint mist and contact of liquid paint with skin & eyes, should be avoided. Forced ventilation should be provided when applying paint in confined spaces or stagnant air. Even when ventilation is provided, respiratory, skin and eye protection are always recommended when spraying paint
- Please refer our Material Safety Data Sheet prior to using the product

*Disclaimer: To the best of our knowledge the information provided herein are true and accurate at the date of issuance. Since we have no control over the quality or condition of the substrate or the various factors affecting the use and application of the product, we do not accept any responsibility or liability arising out of use of the product. The company reserves the right to modify data contained herein without prior notice. Any change in data would normally be followed by issue of a new data-sheet. The user should check with the nearest sales office of the company and confirm the validity of the information, prior to using the product.*

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