

# ALUSPRAY

Aluspray is based on aluminium flakes. It can be applied either without primer on an old, non-corroded hot-dip galvanisation or metallisation layer or as topcoat on top of ZINGA. Aluspray is mainly applied for esthetical reasons as it gives a nice aluminium aspect.

## PHYSICAL DATA AND TECHNICAL INFORMATION

### WET PRODUCT

Components	- Aluminium powder - Aromatic hydrocarbons - Binder
Density	0,656 Kg/dm <sup>3</sup> (± 0,05 Kg/dm <sup>3</sup> ) at 20°C
Propellant	Dimethylether
Content	Liquid
Flashpoint	-41°C (~ propellant)
VOC	619 g/L

### DRY FILM

Colour	Aluminium (~RAL 9006: comparable to hot-dip)
Special features	- Good resistance to mechanic shocks, abrasion and erosion - Very economical - Efficient and solid
Temperature resistance dry film	- Minimum -40°C - Maximum +150°C

### PACKING

500 mL	Spray can
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### CONSERVATION

Shelf life	2 years in original, unopened packing.
Storage	Store vertically in a dry place with a temperature between 5°C and 40°C (preferably at room temperature ±18°C)

## CONDITIONS

### SURFACE PREPARATION

Surface preparation	<ul style="list-style-type: none"> <li>- Aluspray can be applied on ferro-metals and (damaged) zinc surfaces.</li> <li>- For optimal performance, the metal should first be degreased, preferably by steam-cleaning. Alternatively, the surface can be degreased using solvent (e.g. Zingasolv), but <b>never use white spirit</b>.</li> <li>- For optimal performance, clean to SA 2,5 (ISO 8501:2007). For non-critical (small) areas, cleaning to St 3 is sufficient (using a steel brush).</li> </ul>
Roughness	<ul style="list-style-type: none"> <li>- Aluspray should be applied on a metal substrate that has a roughness grade of fine to medium G (<b>Rz 50 to 70 µm</b>) according to the standard ISO 8503-2:2012.</li> <li>- This can be obtained by <b>grit-blasting</b> (with sharp particles) but not by shot-blasting (with spherical particles). <b>Make sure that the surface is degreased before the grit-blasting</b>.</li> <li>- This high degree of roughness is not needed when Aluspray is applied on a hot-dip galvanisation or a metallisation layer, or when it is applied on top of an existing ZINGA layer. Make sure Zinc salts are removed from the surface to ensure a good electrochemical connection between the two layers. Old hot-dipped surfaces have adequate roughness, new hot-dipped surfaces require a sweep blast.</li> <li>- For small, non-critical areas, roughness can be obtained by using a steel wire brush.</li> </ul>
Maximum time to application	Apply the Aluspray as soon as possible on the prepared metal substrate (max. 4 hours waiting time). If contamination occurs before coating, the surface must be cleaned again as described above.

### ENVIRONMENTAL CONDITIONS DURING APPLICATION

Ambient temperature	<ul style="list-style-type: none"> <li>- Minimum 5°C</li> <li>- Maximum 40°C</li> </ul>
Relative humidity	<ul style="list-style-type: none"> <li>- Maximum 90%</li> <li>- Do not apply on a damp or wet surface</li> </ul>
Surface temperature	<ul style="list-style-type: none"> <li>- Minimum 3°C above the dew point.</li> <li>- No visual presence of water or ice</li> <li>- Maximum 60°C</li> </ul>

## APPLICATION INSTRUCTIONS

### GENERAL

Shaking	Aluspray must be shaken <b>thoroughly</b> before application. Shake the can vigorously for <b>minimum 30 seconds</b> after liberating the balls. Repeat this every time the can is not used for some time.
Application	Keep the spray between 10 and 20 cm away from the substrate and move in a continuous speed from left to right. Repeat with a spray application from top to bottom.
Cleaning	Cleaning of equipment or spills with Zingasolv.

## OTHER INFORMATION

### COVERAGE AND CONSUMPTION

Theoretical coverage	For 40 µm DFT: 4 m <sup>2</sup> /L
Practical coverage and consumption	Depends upon the roughness profile of the substrate and the application method

### DRYING PROCESS AND OVERCOATING

Drying process	Aluspray dries by evaporation of the solvent. The drying process is influenced by the total WFT, the ambient air (humidity and temperature) and the steel surface temperatures.
Drying time	For 40 µm DFT at 20°C in a well-ventilated environment: » Touch dry: 15 minutes » Dry to handle: 1 hours » Fully cured: 48 hours
Overcoating with a new layer of Aluspray	- <b>Always apply 2 layers, apply the second coat 1 hour after touch dry.</b> - Maximum overcoat time depends on environmental conditions. If zinc salts have formed, they should first be removed.

### RECOMMENDED SYSTEM

Unique system	Aluspray is advised for <b>touch-up</b> (HDG, metallisation or on ZINGA) and application on small areas only. It should be applied in two layers.
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For more specific and detailed recommendations concerning the application of Aluspray, please contact the Zingametall representative.

For detailed information about the health and safety hazards and precautions for use, refer to the Aluspray safety data sheet.