

HR36 Heat Resisting Stoving Aluminium Finish

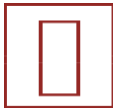
TECHNICAL DATA SHEET

Product Description

HR36 is an aluminium heat resisting coating suitable for application to prepared ferrous and light alloy surfaces. HR36 can be used on exhaust manifolds and engine stubs.

- Single pack
- Conventional solids
- Heat resistant to 250°C

Components



Mix Ratio (by volume)

- Supplied ready for use

Specifications



HR36 is qualified to:

- AFS 621A

Note: PPG Aerospace recommends you check the most recent specification QPLs for updated information.

Surface Preparation and Pretreatment



Ensure surface is clean, dry and intact using a high performance solvent cleaner. DeSoto® CN20 or Desoclean™ 45 solvent cleaners are recommended. Observe recommended overcoating window for primers. For further information, refer to Technical Data Sheets for the relevant primers.

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Instructions for Use



Base may require mechanical agitation. Ensure all components are adequately dispersed prior to application.

Note: All products and components should be placed in ambient conditions of 15-30°C (59-86°F) for at least 24 hours prior to mixing and application.



Induction Time:

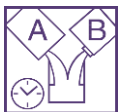
Not required



Viscosity: (23°C/73°F)

• AFNOR4	26-30 seconds
• BSB3	47-58 seconds
• BSB4	26-30 seconds
• FORD4	22-25 seconds
• ISO4	45-58 seconds
• ZAHN2	29-35 seconds

Note: Viscosities quoted are typical ranges obtained when using specified mix ratio.



Pot Life:

Not applicable

Application Guidelines

Recommended Application Conditions:

Temperature	15 - 35°C (59 - 95°F)
Relative Humidity	30 - 85%

Application:

Apply a single coat to achieve the recommended dry film thickness of 15-20 µm.



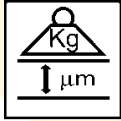
Theoretical Coverage: (ready for use)

11 m²/Lt @ 20 µm dry film thickness
440 ft²/US gal @ 0.8 mil dry film thickness

Recommended Dry Film Thickness:

15-20 µm
0.6-0.8 mil

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Dry Film Density:

1.56 g/cm³
13.1 lbs/US gal

Dry Film Weight:

31 g/m² @ 20 µm dry film thickness
0.006 lbs/ft² @ 0.8 mil dry film thickness

Note: These application guidelines represent PPG's best advice for usage in standard conditions. Some parameters will be influenced by environmental conditions, equipment settings, and other variables.

Equipment:



Equipment Type	Tip Size	Air Pressure
Conventional Air Spray	1.0-1.8 mm	29 to 44 psi (2 to 3 bar)



Equipment Cleaning:

Clean spray equipment before use and as soon as possible after use. DeSoto[®] CN20, CN44 or Desoclean[™] 45 solvent cleaners are recommended

Physical Properties



Colour:

Aluminium



Gloss:

Not applicable

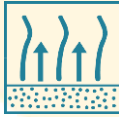


Drying Times:

Stove 30 minutes at 120°C (248°F)

Note: Drying times listed above are dependent upon film thickness applied, air flow conditions and application technique.

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Flash Off Time:
20 minutes prior to stoving



VOC: (ASTM)
HR36 Mixed ready for use 610 g/Lt



Flash Point:
HR36 25°C (77°F)

Shelf Life:
HR36 24 months in original unopened container

Note: Shelf life may vary due to OEM specification requirements. Refer to container label for specific shelf life information.

Note: The application and performance property values above are typical for the material, but not intended for use in specifications or for acceptance inspection criteria because of variations in testing methods, conditions and configurations.

Storage Recommendations



Inspect the condition of the container to ensure compliance. The material should be stored at temperatures between 5°C to 35°C (41°F to 95°F) to ensure shelf life.

Note: When procuring to a qualified material specification, follow those storage instructions.

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Health Precautions

This product is safe to use and apply when recommended precautions are followed. Before using this product, read and understand the Safety Data Sheet (SDS), which provides information on health, physical and environmental hazards, handling precautions and first aid recommendations. An SDS is available on request. Avoid overexposure. Obtain medical care in case of extreme overexposure.

For industrial use only. Keep away from children.

Additional information can be found at: www.ppgaerospace.com

For sales and ordering information call the local PPG office at the numbers listed below:

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