



PRODUCT DATA ALSEAL HX

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Description and Uses

Alseal HX is for use on exhaust headers and is formulated to provide a shiny chrome appearance when properly burnished and also to protect ferrous alloys from both high temperature heat oxidation and at the same time offer sacrificial (cathodic) protection to the base metal. Because of its high temperature capabilities, it offers excellent protection when exposed to cyclic high temperature and corrosive salt environments, continuing to provide sacrificial properties at temperatures to 1150°F. Although a ceramic coating, it combines thermal stability, excellent adhesion and hardness, along with good flexibility... a property not found in most ceramic coatings. As mentioned above it offers salt corrosive protection to 1150°F. At about 1200°F. the aluminum oxidizes to a point where it no longer provides its excellent sacrificial properties, however, it will continue to offer excellent heat oxidation continuously to 1600°F. and in some cases, depending on metal substrate,

has offered heat oxidation protection to 2200°F.

Tests have been conducted using low carbon steel alloys. There was no loss of weight after several weeks continuous exposure at 1000°F. After exposure to 5% salt spray for 1000 hours, there was no evidence of corrosion.

Further, the coating formed from Alseal HX composition offers superb thermal shock resistance. The coated metal will not crack, spall, or fail after shocking from 1100°F. to room temperature repeatedly.

The coating formed from Alseal HX composition has properties vastly superior to those of organic paints and coatings. Specifically, the film formed from Alseal HX coating composition offers greater protective properties in combination of heat, weathering, corrosion, and oxidation resistance than organic paints and is lighter in weight and more flexible than most ceramic coatings.

Technical Data

Volume Solids:	32% ± 2%
Number of Coats:	Dependent on application.
Film Thickness:	2 mils DFT unless otherwise specified two coats required for 2 mils.
Theoretical Coverage @ 2 mils DFT:	320 sq. ft./gallon
Dry Time @ 75°F., 50% R.H.:	To touch - 20 minutes
Prebake Oven Time @ 175°F.:	15 minutes minimum
Cure Temperature 500°F. - 600°F. Preferred:	30 minutes minimum
Thinner:	Do not thin, use as received
Method of Application:	Spraying preferred
Clean Up:	Water
Shelf Life:	1 year, if unopened

Surface Preparation

Special care must be exercised in the preparation of the surface for all high quality, premium performance coatings.

1) Degreasing. All oil, grease and other organic deposits must be removed by suitable degreasing operation or by heating parts to temperature sufficiently high to facilitate removal.

2) Cleaning and Roughening. All old coats, mill scale, rust, or other tightly adherent deposits must be removed by a method such as dry grit blasting or vapor blasting. Grit blast, using clean aluminum oxide (AL₂O₃) grit, is the recommended cleaning procedure which is necessary for maximum adhesion to steel, although other abrasive methods may be satisfactory.

Application of Coating

Before applying coating, it is important that all aluminum powder be completely dispersed. Aseal HX coating composition should be applied by spray application to obtain optimum smoothness and uniform film thickness. Use standard paint spray equipment. Equipment can be readily cleaned using tap water.

There are instances such as high humidity when it is harder to obtain a uniform film build. For these instances, it is recommended to use 1ml of the Aseal HX Anti-sag and Flow additive to 20ml of Aseal HX to aid in the sprayability of the coating. It is not recommended to use the additive at a ratio greater than 1ml of additive to 10ml of Aseal HX. The additive can also be used in other instances when sprayability is a concern.

Note: This product is not to be thinned, use as received.

Number of Coats

Two coats with a minimum of 2 mils total dry film thickness is generally recommended, although there may be instances where one coat will suffice or where a thickness tolerance dictates one coat.

Curing Procedures

1) Dry to room temperature for a minimum of 15 minutes or until color is uniform matte light gray. If humidity is high and coating is drying slowly, it may be necessary to force dry at a low temperature, approximately 100 to 125°F. with air movement.

2) Prebake at 175°F. metal surface temperature for a minimum of 20 minutes (no maximum time). Large parts act as heat sinks and will require longer times.

3) Cure at a minimum of 500°F. for minimum of 30 minutes (no maximum time). Surface temperature of coated part must reach recommended cure temperature for 30 minutes.

4) Apply second coat immediately after parts have cooled to prevent possible contamination. Repeat cure cycle in steps 1, 2 and 3. **Note :** preferred cure temperature of 600°F. will yield a somewhat harder more abrasion resistant coating.

Note: This coating may be cured as low as 400°F. for two hours. Surface temperature must reach 400°F. and be held there for 2 hours. At 400°F. the coating will not be as hard or as abrasion resistant as when cured at higher temperatures, but will retain its excellent corrosion resistant properties.

Surface Treatment

Coating must be made electrically conductive to obtain sacrificial properties. There are two ways this can be done.

A) Coating may be post cured at 1025°F. for 60 minutes.

B) Coating may be burnished by any suitable method such as glass bead peening, or using aluminum oxide. It is important when using a blast cabinet for burnishing that 25 to 35 PSI be used in a suction blast cabinet and 5 to 10 PSI in a pressure blast cabinet.

IMPORTANT: In order to create the shiny chrome appearance, the coating must be burnished using a tumble or vibratory burnishing machine. The proper burnishing media is either ceramic beads or steel pellets in a soapy solution. A preferred burnishing machine is manufactured by SWECO, Inc.

Note: It is important that the coating is electrically conductive. Using light pressure with probes of an ohm meter held 1" apart, a reading of 10 ohms or less should be obtained.

Removal of Coating

If it should be necessary to remove the cured coating, it can be stripped by grit blasting or immersing in a hot (approximately 150°F.) caustic soda solution (approximately 10% caustic soda) then lightly grit blasting. Care should be taken when using a caustic solution since hydrogen will be generated. Area should be well ventilated.

Toxicity

Alseal HX composition contains phosphoric acid and a small amount of chromic acid which are toxic. Normal precautions should be taken against ingestion, inhalation, and contact with eyes. Precautions should be taken to insure that the wet compound does not come in contact with sores or cuts.

Toxic phosphide may be given off in fire or other very high temperature conditions.

Contains hexavalent chromium. The national toxicology program lists chromium and certain chromium compounds to be carcinogenic.

See material safety data sheet before using.

Precautions

Contains aluminum metal powder, phosphate and dichromate. Normal precautions should be taken for handling of acidic materials. Avoid ingestion. Harmful or fatal if swallowed. Avoid inhalation of

spray mist and contact with eyes. In case of eye contact flush immediately with plenty of water and consult a physician. Avoid prolonged or repeated contact with skin. For skin contact flush with plenty of water.

When spraying, a suitable exhaust system should be used. If spray mist is not completely removed from air, a suitable respirator should be used such as #9910 manufactured by 3M Co., or an equivalent type.

In case of spill, use absorbing material to soak up and neutralize with sodium bicarbonate. Do not use strong alkalis. Then flush with water.

Waste Disposal Method: Filter to remove aluminum and discard as solid chemical waste. Treat remaining liquid with sodium metabisulfite, then precipitate trivalent chromium by neutralizing with alkali such as lime. Dispose of waste in accordance with federal, state and local environmental control regulations.

Important: Avoid direct contact with alkalis and strong oxidizing or reducing agents since this may produce hydrogen gas.

Since this compound contains aluminum powder, a clean spray area and duct system are important. It is hazardous to allow an accumulation of dried material to occur since this dried material in the form of dust could be ignited by sparks or other means and possibly cause a dust explosion as with any finely divided powdered material.

Note: Some manufacturers requiring this coating composition develop their own procedure specifications and in all cases they should be followed in place of the foregoing procedures.