



COATINGS FOR INDUSTRY, INC.

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manufacturers of



Aseal DB-10

Application

High temperature sealer for use over Aseal 500, 518, 519, or the HX series.

Description

Aseal DB-10 is a high temperature resistant composition supplied as a two component mix for use over Aseal 500 and Aseal 518. The purpose of this sealer is to enhance the smoothness of the Aseal sacrificial basecoats and to extend the long term corrosion protection by retarding the sacrificial consumption of these coatings.

Colors

Available in Standard Green/Gold, Forest Green, Valley Green, Emerald Green, Tan, Chestnut Brown, Yellow, Sky Blue, Midnight Blue, Light Gray, Chrcoal, and Black.

Surface Preparation

Aseal 500, 518, 519, or HX should be applied as per specification. After application and curing the surface should be aluminum oxide blasted using #240 to #320 grit at approximately 30 psi air pressure (suction blaster) so as to make the surface conductive (10 ohms or less with probes of ohm meter 1" apart) without noticeable removal of coating. Blasting grit should be removed using an oil free air blast.

Application of Sealer

Mix component B (1 part by volume) to component A (10 parts by volume) and stir thoroughly.

Apply sealer using standard siphon feed spray gun as used for lacquer type materials. A light mist coat should be applied first then followed with a heavier coat. This sealer is only applied at 0.1 to 0.2 mils. After spraying, it should have a uniform wet glossy appearance. Coating film should be allowed to air dry for a minimum of 20 minutes.

Curing Procedure

After 20 minute air dry, parts should be oven dried at 175° F. for a minimum of 20 minutes, then cured at 600° F. for 30 minutes. In certain specific applications, the parts may be cured at 400° F. for two hours. This is used where parts cannot tolerate the 600° F. cure.

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 solution then lightly grit blasting. Care should be taken when using a caustic solution since hydrogen will be generated due to the aluminum base coat. Area should be well ventilated.

Toxicity

Aseal DB-10 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.

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 dichromate and a small amount of organic solvent (part B). 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.

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

Waste Disposal Method: Treat 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.

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

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Seller's and manufacturer's only obligation shall be to replace such quantity of the product proved to be defective at the time the sealed container is first opened, and in no event beyond the shelf date printed on the label. Neither seller nor manufacturer shall be liable for any injury, loss or damage, direct or consequential, arising out of the use of or the inability to use the product. Before using, user shall determine the suitability of the product for his intended use, and user assumes all risk and liability whatsoever in connection therewith.

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