

# Chrome Finish Aluminum

## Technical Data Sheet (TDS)

### Product Description

**Crown Chrome Finish Aluminum** is a single component ready-to-use, leafing aluminum paint providing a chrome-like uniform appearance that provides heat resistance up to 400°F (204°C).

#### Product features:

- Chrome-like aluminum finish
- Heat reflective and heat resistant up to 400°F
- UV resistant with good corrosion resistance
- Brush, roll, or spray
- Lead, Chrome, and Heavy metal free

### Recommended Uses

Chrome Finish Aluminum is intended for industrial applications, either new build or maintenance for interior or exterior use. Chrome Finish Aluminum is an excellent choice for metal built-up roofs, storage tanks, bridges, fences, furnaces, radiators, and piping.

#### Industries:

- Oilfield & Energy Service
- Industrial Equipment
- Construction Equipment
- Agricultural equipment
- General Metal applications

### Mixing

**Chrome Finish Aluminum is a single component product.**

**Stir each container thoroughly prior to use.**

### Product Characteristics

Typical Physical Properties	
<b>Gloss:</b>	High: 85+ GU at 60°
<b>Volume Solids: (Single Component Unreduced) E417 Chrome Finish Aluminum</b>	43% ± 2%
Volume solids will vary by color	
<b>VOC (Unreduced): EPA Method 24 E417 Chrome Finish Aluminum</b>	450 g/l 3.753 lb /gal
VOC content will vary with each color	
<b>Shelf Life:</b>	
<b>Chrome Finish Aluminum</b>	2 Years
For unopened product (77°F (25°C))	
<b>Weight Gallon: E417 Chrome Finish Aluminum</b>	8.2 ± 0.2lb/gal

### Surface Prep

Surfaces to be finished must be clean, dry and free of dirt, oil or any contamination that would adversely affect adhesion, protective properties or appearance of the coating. Prepare metal surfaces to SSPC-SP2, SSPC-SP3 for normal requirements.

**Note: For optimal corrosion resistance and adhesion, iron phosphate treatment is recommended and/or P300 Series Metal Primer.**

For questions regarding other substrates contact your Crown Representative.

### Application Method

Chrome Finish Aluminum can be applied by most spray painting systems including heated and dip application. It can also be applied by advanced application equipment such as turbo disk or bell.

Follow recoats times of primer if applied prior to topcoating with Chrome Finish Aluminum.

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**Note: Not recommended for brush or roller application over large areas. Small touch-up areas may be brushed.**

### Spray Gun Setup

Feed Type	Fluid Tip	Application Pressures (heel of gun)	Fluid Delivery
Siphon Feed	1.6-1.8 mm	40-50 psi	
Gravity Feed	1.6-1.8 mm	30-40 psi	
Pressure Feed	1.4-1.8 mm	50-60 psi	10-14 oz/min
Air Assist Airless	9 -13 Thou	1,000-1,800 psi	
Airless	9-13 Thou	1,700-3,000 psi	

### Spray Viscosity

Supplied Viscosity - [ 77°F (25°C)]	
#2 Zahn Cup	40 - 45 secs.

**Note: Material is packaged at a viscosity requiring little or no reduction for application by airless spray equipment.**

**Note: Spraying viscosity and thinning will depend on ambient conditions, spray equipment used, and the desired surface finish.**

IF THINNING IS REQUIRED:	
Temperature Range	Recommended Thinner
<b>Below 65° F (18° C)</b>	Toluol /TS100
<b>65 ° F- 80 ° F (18-27 ° C)</b>	Xylol /TS105
<b>Above 80°F</b>	Xylol /TS105
<b>Above 80°F:</b> SC-100 or SC-150 can be used as a retarder solvent to reduce dry spray and increase flow and leveling. Limit the level of SC-150 to 5% as a retarder solvent.	
<b>Note: VM&amp;P Naphtha or Mineral Spirits should never be used.</b>	

### Film Build

Chrome Finish Aluminum has a recommended film build thickness of:

<b>Wet: WFT Unreduced</b>	<b>4.0 – 5.0 mils</b>	<b>100 – 150 microns</b>
<b>Dry: DFT</b>	<b>1.5 – 2.0 mils</b>	<b>38 – 50 microns</b>

Theoretical coverage at 1.0 mil (25 microns).  
DFT: 689ft<sup>2</sup> per gallon at 100% transfer efficiency.

### Dry Times

	70°F (21°C)
<b>To Touch</b>	1 Hour
<b>To Handle</b>	2 Hours
<b>To Recoat</b>	1 Hour
<b>Through Dry</b>	18 Hours

Optimum drying conditions are 60°F to 90°F (16°C to 32°C) at 50% R.H. Lower temperatures and high humidity will slow dry time. Surface must be dry and at least 5°F (3°C) above the dew point.

**Note: Product may also be force cured to enhance dry. Force cure temperatures in the range of 110-180°F may be utilized to accelerate solvent evaporation and speed oxidation.**

### Clean Up

Clean all equipment immediately after use with xylol, or aromatic solvent for spray guns and line, pots and other equipment.

Follow manufacturer's safety recommendations when using any solvent.

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#### Ordering Information (sizing)

Package sizes available:  
Aerosol, 1 gallon, 5 gallons, 55 gallon drum,  
300 gallon tote.  
Custom colors and sizes may be available.

#### Environmental Conditions

For optimum coating performance product, substrate and ambient temperature should be above 50°F (10°C). To prevent condensation during application the surface temperature must be 5°F (3°C) or more above the dew point.

**Note: For use outside this range please contact your Crown Representative.**

#### Specifications

Test	Method	Result
Salt Spray/ Corrosion	ASTM B117	240 hours. no field rusting, less than 1/8" creep from scribe 336 hours w/P315
Adhesion:	ASTM D3359	5A; 100% B-1000 panel
Impact resistance	ASTM D2794	20 lbs direct 10 lbs reverse
Flexibility	ASTM D522	1/8 mandrel bend: Pass

#### Storage Conditions

**Storing partially used container:**  
Pour a small amount of the recommended thinner over the surface. Do not stir. Replace lid securely. Store away from heat or open flame.

**Mix thoroughly before reusing.**