



Axalta 13204S™ Aluminum Alloy and Metal Cleaner



GENERAL

DESCRIPTION

An aqueous phosphoric-acid based cleaner designed to provide deep cleaning and conditioning of metal surfaces in preparation for a subsequent conversion coating. This step is commonly referred to as acid etch treatment recommended for use with higher copper-containing alloys.

RECOMMENDED USES

13204S™ Aluminum Alloy and Metal Cleaner is recommended as part of an aluminum pre-treatment system with 13206S™ Aluminum Conversion Coating. 13204S™ is recommended for high copper aluminum alloys where 13205S™ is not recommended.

Following conversion coating, recommended primers include Corlar® 13580S™ Non-Chromate Epoxy Primer-High Build and Corlar® 13550S™ Corrosion-Resistant Epoxy Primer.

The products referenced herein may not be sold in your market. Please consult your distributor for product availability.



MIXING

COMPONENTS

13204S™ Aluminum Alloy and Metal Cleaner

MIX RATIO

Heavy oxidation and corrosion removal: Dilute 1 part 13204S™ with 1 part water
Light oxidation and corrosion removal: Dilute 1 part 13204S™ with 2 parts water



APPLICATION

SUBSTRATES AND SURFACE PREPARATION

Substrate must be properly prepared for application. As a minimum, aluminum surfaces should be scrubbed/scuffed with Scotch-Brite™ 7447 pads (or coarser) using an alkaline aviation cleaner. Work area should be kept wet and rinsed with clean water, not allowing detergent to dry on the clean surface. Surface must be “water break free”, meaning water sheets out completely over the metal surface. Any beading up or breaks indicate surface contamination where cleaning must be repeated.

ENVIRONMENTAL CONDITIONS

13204S™ should be applied between room temperature and 45°C.

PRE-TREATMENT PROCESS

The usual process to prepare aluminum substrate for priming is:

1. Apply the 13204S™ Aluminum Alloy and Metal Cleaner solution
2. Water rinse
3. Apply the 13206S™ Aluminum Conversion Coating solution
4. Water rinse – look for water break
5. Check pH, should be neutral
6. Rinse
7. Assure surface is dry before continuing



Tips for Success

- Select size of area to be treated considering method of application, condition of surface, and temperature. Typical treatment time where 13204S™ is in contact with the metal surface prior to rinsing is between one and two minutes.
- Do not allow 13204S™ solution to dry on surface prior to thorough rinsing. Rinsing removes residual phosphoric acid solution, salts, and lifted contaminants.
- Removal of heavy corrosion can be aided by scrubbing with a Scotch-Brite™ pad.
- While rinsing, look for water break free sheeting of the rinse water. Any areas not showing smooth sheeting must be re-cleaned. Scrub with Scotch-Brite™ 7447 pads using alkaline aviation cleaner or 13204S™ Aluminum Cleaner until rinse is water break free.
- Repeat 13204S™ application and thorough rinse.



PHYSICAL PROPERTIES

VOC	Less Exempts (LE)	As Packaged (AP)
13204S™	528 g/L	216 g/L

FACTORY-PACKAGED CLEANER

Colour	Clear
Shelf Life	2 years (Unopened at 10°-45°C)
Specific Gravity	1.14 g/mL

VOC REGULATED AREAS

These directions refer to the use of products which may be restricted or require special mixing instructions in VOC regulated areas. Follow mixing usage and recommendations in the VOC Compliant Products Chart for your area.

SAFETY AND HANDLING

For industrial use only by professional, trained painters. Not for sale to or use by the general public. Before using, read and follow all label and SDS precautions. If mixed with other components, mixture will have hazards of all components.

Ready to use paint materials containing isocyanates can cause irritation of the respiratory organs and hypersensitive reactions. Asthma sufferers, those with allergies and anyone with a history of respiratory complaints must not be asked to work with products containing isocyanates.

Do not sand, flame cut, braze or weld dry coating without an approved air purifying respirator with particulate filters, complying with AS/ANZ 1716:2012 and gloves.