

Axalta 13206S™ Aluminum Conversion Coating



GENERAL

DESCRIPTION

An aqueous chromic-acid based conversion coating designed to provide a chromate conversion coat on aluminum and aluminum alloys. The coating formed by 13206S™ is gold to tan in color and formulated to provide for adhesion of subsequent primer as well as corrosion protection.

RECOMMENDED USES

13206S™ Aluminum Conversion coating is recommended as part of an aluminum pre-treatment system with 13204S™ Aluminum Alloy and Metal Cleaner or 13205S™ Aluminum Cleaner. 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

13206S™ Aluminum Conversion Coating

MIX RATIO

Ready to use (no dilution required)



APPLICATION

ENVIRONMENTAL CONDITIONS

13206S™ should be applied between room temperature and 40°C.

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.
- After achieving “water break free” surface, phosphoric-acid based cleaner/etchant must be applied per recommendations prior to 13206S™ application.

PRE-TREATMENT PROCESS

The usual process to prepare aluminum substrate for priming is:

1. Apply the 13204S™ or 13205S™ cleaner solution
(see individual product data sheets)
2. Water rinse
3. Apply the 13206S™ Aluminum Conversion Coating solution
4. Water rinse
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 13206S™ is in contact with the metal surface prior to rinsing is between two and five minutes at temperatures between room and 40°C.
- Do not allow 13206S™ solution to dry on surface prior to thorough rinsing. If drying does occur, rewet surface with 13206S™ solution prior to water rinsing.
- Thorough clean water rinsing is required to remove chemical salts from the metal surface. Residual salts due to poor rinsing can result in blistering and corrosion problems.
- Forced drying may be used to shorten dry time after rinsing provided air does not redeposit contaminants and metal temperature does not exceed 60°C.
- Surface color will range from light gold to dark tan depending on several factors including type of alloy, metal hardness, metal age, and method of cleaning.
- Powdering of a conversion coat can affect paint adhesion, and can result from application problems including poor cleaning, drying, or over reacting. Powder should be removed from the dried surface with a clean, dry rag—gently wiping without abrading the conversion coating. Do not redeposit oils, lint, or other contaminants on the surface.
- Surface should be primed as soon as possible after completing the conversion coating process in order to minimize contamination and oxidation of the metal surface less than 24 hours unless verified by manufacturer otherwise.



PHYSICAL PROPERTIES

VOC	Less Exempts (LE)	As Packaged (AP)
13206S™	0.0 g/L	0.0 g/L

FACTORY-PACKAGED CLEANER

Colour	Amber
Shelf Life	2 years (Unopened at 10°-45°C)
Gallon Weight	1.01 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 MSDS 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.