

**PRODUCT DATA HEAT-RESISTANT SYSTEM ALU TOPCOAT 4215**

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**DESCRIPTION**

RUST-OLEUM® Heat-Resistant System Aluminium Topcoat 4215 is based on a silicone modified alkyd resin.

**RECOMMENDED USES**

RUST-OLEUM 4215 should be used on new, bare steel or blasted steel surfaces primed with RUST-OLEUM 4268 Orange Primer.

RUST-OLEUM 4215 is intended for brush and roller application and can also be applied by spray.

RUST-OLEUM 4215 provides heat resistance up to 425°C dry heat in sheltered or interior environments, if applied on RUST-OLEUM Heat-Resistant System 4268 Orange Primer. On blasted steel two coats of RUST-OLEUM Primer 4268 should be applied prior to the application of RUST-OLEUM Aluminium Topcoat 4215.

**TECHNICAL DATA**

Appearance: Metallic (sparkling)  
Colour: Aluminium  
Density: 1.14 kg/l  
Solids Content: 24.1% by volume  
Viscosity: 76 - 78 KU /Krebs Stormer Units at 20°C  
Recommended film thickness: 15 µm dry, equals 60 µm wet

VOC-content: 598 g/l max.  
Ready-to-use mixture: 642 g/l max.  
Category: A/i  
EU Limit values: 600 g/l (2007) / 500 g/l (2010)

<b>Drying times</b>	20°C/50% r.h.	10°C/60% r.h.	30°C/50% r.h.
To touch:	2 hours	3 hours	30 minutes
To handle:	8 hours	12 hours	6 hours
To recoat:	After 24 hours	After 48 hours	After 16 hours
Full hardness:	24 hours after minimum service temperature is reached. Heat up the coating slowly (max. 50°C/hr) until 150°C .		

Heat resistance: 425°C (dry heat)

**Coverage**

Theoretical: 16.0 m<sup>2</sup>/l at 15 µm dry  
Practical: Practical coverage depends on many factors such as porosity and roughness of the substrate and material losses during application.

**SURFACE PREPARATION**

Remove grease, oil and all other surface contaminations by alkaline- or high pressure (steam) cleaning in combination with appropriate detergents. Prime with the recommended RUST-OLEUM Orange Primer 4268. Sand previous coatings which are in good condition to roughen the surface slightly. The surface must be clean and dry during application.

**DIRECTION FOR USE**

To ensure homogeneity, coating materials should be thoroughly stirred prior to use.

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**APPLICATION & THINNING**

- Brush: Up to 10 vol. %; RUST-OLEUM Thinner 150.  
Use natural bristles, long hair brushes.
- Roller: Up to 10 vol. %; RUST-OLEUM Thinner 150.  
Use medium nap, polyamide (perlon 8 -12 mm) rollers.
- Air-atomised spray: 10-20 vol.%; RUST-OLEUM Thinner 150.  
Gravity cup and pressure cup.  
Tip size: 1.2 -1.8 mm.  
Atomizing pressure: 2 - 4 bar.
- Airless spray: If required up to 5 vol. % RUST-OLEUM Thinner 150.  
Pneumatic and electric airless equipment.  
Tip size: 0.013-0.015 inch (use reverse tips)  
Fluid pressure: 110 - 150 bar.  
Check wet film thickness, avoid excessive film thickness.
- Cleanup: Use RUST-OLEUM Thinner 150/160 or aromatic hydrocarbons

**APPLICATION CONDITIONS**

Temperature of air, substrate and coating material between 5 and 35°C and relative humidity below 85%. The substrate temperature must be at least 3°C above dew point.

**REMARKS**

Maximum dry film thickness per coat: 30 µm dry, equals 125 µm wet.

**SAFETY**

Consult Safety Data Sheet and Safety Information printed on the can.

Attention: due to possible gassing first remove carefully the sticker from the lid of the can.

**SHELLIFE / STORAGE CONDITIONS**

5 years from date of production in unopened cans, if stored in dry, well ventilated areas, not in direct sunlight at temperatures between 5° and 35°C.

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