

ALUMIGLASS ONE

HYDROTHANE SERIES H-3200



PRODUCT DATA SHEET

PRODUCT OVERVIEW	BENEFITS									
Alumiglass ONE is an NMP-free, one component, waterborne acrylic polyurethane coating designed for use on aluminum and fiberglass substrates.	This coating is easy to apply and dries quickly, offering excellent hardness and a wide array of IR reflective colors. Aluminum: Alumiglass ONE provides good corrosion resistance to aluminum when applied direct-to-metal.									
FEATURES	FIBERGLASS									
<ul style="list-style-type: none"> • Quick dry time • Excellent hardness • Good chemical resistance • Excellent water resistance 	Alumiglass ONE provides good water resistance to fiberglass.									
FINISH	SURFACE PREPARATION									
Gloss: Matte (< 15 GU) Color: Any	Aluminum: Lightly abrade the surface and remove debris. Wipe with acetone and let flash. Wipe with isopropyl alcohol and let flash. Ensure surface is clean and dry before applying Alumiglass ONE. Fiberglass: Lightly abrade the surface and remove debris. Wipe with acetone and let flash. Ensure surface is clean and dry before applying Alumiglass ONE.									
SPREAD RATE	APPLICATION METHODS									
Theoretical Coverage: 705 sq.ft. per gallon @ 1 mil DFT Recommended Coverage: 470 sq.ft. per gallon @ 1.5 mil DFT	Stir contents before use. Never shake or mix under high agitation. Alumiglass ONE can be sprayed, brushed or rolled onto vinyl. Spraying: Reduce to 30-33 seconds, Zahn #3. Apply a medium wet coat over the surface (provide a WFT recommendation). For best results, apply with a spray gun with tip size of 1.2-1.8 mm, air pressure should be 15-25psi for HVLP and 25-40 psi for conventional spray guns. Atomization pressure depends on viscosity. Apply 1 tack coat followed by 1 full coat (WFT 3 - 4 mils) of Alumiglass ONE. Brushing: Reduce to 30-38 seconds, Zahn#2. Apply one to two coats of Alumiglass ONE.									
SUBSTRATES	DRY TIMES									
<ul style="list-style-type: none"> • Aluminum (DTM or primed) • Fiberglass 	<i>Alumiglass ONE can be air dried or force cured.</i>									
SPECIFICATIONS	<table border="0"> <tr> <td>Cure Conditions:</td> <td style="text-align: center;">75°F/24°C @ 50% RH</td> <td style="border-left: 1px solid black; text-align: center;">120°F/49°C @ 50% RH</td> </tr> <tr> <td>Recoat:</td> <td style="text-align: center;">10 min</td> <td style="border-left: 1px solid black; text-align: center;">5 min</td> </tr> <tr> <td>Dry to Handle:</td> <td style="text-align: center;">60 min</td> <td style="border-left: 1px solid black; text-align: center;">20 min</td> </tr> </table>	Cure Conditions:	75°F/24°C @ 50% RH	120°F/49°C @ 50% RH	Recoat:	10 min	5 min	Dry to Handle:	60 min	20 min
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Binder Type: Acrylic-Urethane Volume Solids: 44 ± 6% *varies by color Weight Solids: 49 ± 2% *varies by color Weight per Gallon: 8.9 ± 0.1lb, clear Flash Point: TBD VOC, Material: 72 g/L VOC, Coating: 155 g/L Shelf Life: 12 months, unopened										
PERFORMANCE DATA	CLEAN-UP									
* At recommended DFT Dry Film Hardness (ASTM D3363): Aluminum: H	While coating is wet, water may be used for cleaning. After the coating dries, solvents may be required for clean up.									
PERFORMANCE DATA	CERTIFICATIONS									
	AAMA 2605-20 <i>In testing</i> AAMA 625-20 <i>In testing</i>									

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NOTES ON CLEANING COATED WINDOWS AND DOOR FRAMES

After the window has been coated, it should not be washed for two weeks to allow for complete curing of the coating. Once it has cured for two weeks, the coated vinyl surface may be cleaned with a mild soap* and water, using a lint-free rag or lint-free paper towel. Do not use solvent or abrasive materials, such as Scotch Brite pads. Clean the glass of the window with Windex or Ivory dish soap.

To clean:

- Vacuum dirt from sill and track areas before washing
- Clean window and/or door frames with a mixture of mild soap and water
- *Abrasive or caustic cleaners or solvents are never recommended because they may cause permanent damage to the frame finish*
- Mild, nonabrasive soaps are usually safest for most dirt and stain removal
- Always rinse completely with clean water and wipe or pat dry
- Check to make sure certain drainage or "weep" holes are always clear of dirt or obstruction both inside and outside the window or door