

**STATE OF CALIFORNIA****Department of Transportation Specification****Leafing Aluminum Finish Paint  
Waterborne Acrylic Latex Vehicle  
(Specification PWB-162A)****DESCRIPTION**

This specification covers a single component, waterborne leafing aluminum paint suitable for use as a finish coat on properly prepared metal surfaces. This coating is intended for spray application, limited application can be made by brushing and rolling. This paint is an industrial maintenance coating and is not for residential use. Typical use of this coating is for it to be applied over contrasting first finish coat, PWB 161A (or PWB 159D), non-leafing aluminum.

**Quality Assurance:**

All paint intended for use by the California Department of Transportation (Department) must be sampled, tested and approved by the Transportation Laboratory before shipment. The manufacturer shall take a representative one-quart sample of each batch of paint and ship the samples to the Transportation Laboratory for approval, unless other arrangements have been made. Raw materials and copies of batch records used in the manufacture of the paint shall be submitted if requested.

Transportation Laboratory, Chemical Testing Branch, 5900 Folsom Blvd.,  
Sacramento, CA 95819, attn.: Lisa Watson, Fax (916) 227-7168.

A batch shall be that amount of paint that was manufactured and packaged in a single operation. The paint container shall be labeled with, but not limited to, the State Specification number, date of manufacture and batch number. The Department also reserves the right to retest any batch after delivery. Results from such retesting shall prevail over all other tests and will be the basis of rejection. Material not meeting the specification shall be removed and replaced by the supplier at their expense, including all costs for handling, retesting and shipping.

All tests shall be conducted in accordance with the appropriate ASTM test methods referenced and methods used by the Transportation Laboratory.

Composition:

Paint shall be mixed in the following proportions and sequence. Combine the aluminum paste pigment, stabilizer and half of the coalescent solvent. Mix well, cover mixing vessel to help prevent evaporation of solvents and allow mixture to sit undisturbed for two hours. Then, add the acrylic latex and the remainder of the coalescent solvent to the grind. Do not over grind the aluminum pigment using high shear. This will cause fragmentation of the inhibited aluminum pigment that could result in the formation of hydrogen gas and pressure build up in sealed containers which is a safety hazard.

All properties listed shall be maintained for a minimum of one year after acceptance. If the vendor is making this paint for the first time, the Transportation Laboratory in Sacramento must be consulted.

<b><u>Grind Ingredients:</u></b>	<b><u>Weight percent</u></b>	<b><u>Lbs./ 100gal</u></b>
(1) Aluminum paste	17.54	160
(2) Pigment stabilizer	1.42	13.0
(3) Coalescent, (divided)	4.68	43.0
(4) Acrylic Latex	75.4	688.0
(5) Defoamer	0.55	5.0
(6) Amonium Hydroxide (28 %)	0.44	4.0
(7) Preservative	0.11	1.0
(8) Thickener	~ 0.26	~ 2.4

<b><u>Characteristics of Finished Paint:</u></b>	<b><u>Measurements:</u></b>
VOC, g/L, ASTM D 6886, maximum	120
Density, g/mL, ASTM D 1475	1.09 – 1.11
Nonvolatile content, percent, ASTM D 2369, B	44.9 – 46.3
Pigment content, percent, ASTM D 3723	12.0 – 13.0
Consistency, ASTM D 562, grams Equivalent KU	150 – 175 72 – 78

<u>Characteristics of Finished Paint:</u>	<u>Measurements:</u>
High-shear viscosity, ASTM D 4278 0 to 5-P cone, shear rate 12 000 s <sup>-1</sup>	0.3 – 0.5
pH	8.5 – 9.5
Fineness of grind, Hegman, ASTM D 1210, minimum	6
Specular gloss, 60°, ASTM D 523	30 – 40
Color tolerance <sup>1</sup> , ASTM D 2244, maximum CIE 1976 L*a*b*, 10° Standard observer, Illuminant D 65 <sup>1</sup> Color to match color chip PWB 162A on file at the Transportation Laboratory	ΔE* 2
Color tolerance after 300 hours of UV exposure, maximum ASTM D 4587, Cycle 2, UVA 340 bulbs	ΔE* 2
Film hardness, ASTM D 3363, minimum	2B
Package stability, ASTM D 1849, 14 days, 52°C Viscosity, slight change Appearance, 4 mil wet film.	No pressure build up 3 KU max No change
Salt fog exposure, 100 hours, ASTM B 117 Rust rating, ASTM D 610 Blister rating, ASTM D 714	10 minimum No more than 8F
Drying time, 4 mil wet film, ASTM D 1640 Set to touch, hours, maximum Dry through, hours, maximum	$\frac{1}{2}$ 1

#### Material Ingredients of Paint:

- 1) LPW 980 Leafing aluminum paste (Schlenk- Both Metallic Pigments)
- 2) Raybo 41-Spangle (Raybo Chemical Co.)
- 3) Texanol™ 2,2,4-Trimethylpentanediol-1,3-monoisobutyrate (Eastman Chemical Co.)
- 4) Maincote™ HG-54D (Dow®)
- 5) Foamaster® 111 (Henkel)
- 6) Ammonium Hydroxide (28 %)
- 7) Proxel™BD20 (Avecia Inc.) or CANGUARD BIT 20 AS (Dow®)

## 8) Acrysol™ RM-12W (Dow®)

Packaging:

The containers shall be new, round and of no more than twenty-liter (20 L) capacity. Pails larger than fifteen liters shall be standard, full open head. Three liter and larger containers shall have ears and bails. All containers shall be suitably lined or constructed so as to prevent any reaction between the container and contents and also must comply with U.S. Department of Transportation or I.C.C. Regulations as applicable. Labels must be marked with the volatile organic content (VOC), mixing instructions, and the following provision in addition to any other labeling required.

Mixing Procedure:

Mix well using mechanical stirring; do not shake. Avoid incorporating air into the paint.

Application:

The paint shall be applied to a total dry film thickness of 1.5 to 3.0 mils. Paint should not be applied when the ambient or surface temperature is above 100°F or below 50°F, when the relative humidity exceeds 75 percent, or when the surface temperature is less than 5°F above the dew point.

Clean-up

Use tap water for clean up. 10 % ammonia, acetone or other suitable solvent may be used to remove dried paint from spray guns and other equipment.