

DuPont™ 13206S™

Aluminum Conversion Coating

Type

DuPont 13206S™ is an aqueous chromic-acid based conversion coating.

Description

DuPont 13206S™ provides a chromate conversion coat on aluminum and aluminum alloys. The coating formed by DuPont 13206S™ is gold to tan in color and provides for adhesion of subsequent primer as well as corrosion protection.

Recommended Uses

DuPont 13206S™ Aluminum Conversion Coating is recommended as part of an aluminum pre-treatment system with either DuPont 13204S™ Aluminum Alloy and Metal Cleaner or DuPont 13205S™ Aluminum Cleaner. Following conversion coating, recommended primers include Corlar® 13550S™ Corrosion-Resistant Epoxy Primer and Corlar® 13570S™ Non-Chromate Epoxy Primer.

General Information for Use

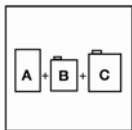
Components

DuPont 13206S™ Aluminum Conversion Coating



Mix Ratio

Ready to use (no dilution required).



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



Aviation Finishes

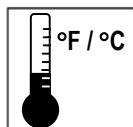
Pre-Treatment Process

The usual process to prepare aluminum substrate for priming is:

1. Apply the DuPont 13204S™ or DuPont 13205S™ cleaner solution
(see individual product data sheets)
2. Water rinse
3. Apply the DuPont 13206S™ Aluminum Conversion Coating solution
4. Water rinse
5. Dry

Tips for Success

- Select size of area to be treated considering method of application, condition of surface, and temperature. Typical treatment time where DuPont 13206S™ is in contact with the metal surface prior to rinsing is between two and five minutes at temperatures between room and 100°F (38°C).
- Do not allow DuPont 13206S™ solution to dry on surface prior to thorough rinsing. If drying does occur, rewet surface with DuPont 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 140°F (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.



Environmental Conditions

DuPont 13206S™ should be applied between room temperature and 100°F (38°C).

Physical Properties

VOC	Less Exempts (LE)	As Packaged (AP)
DuPont 13206S™	0.0 lbs/gal	0.0 lbs/gal

Factory-Packaged Cleaner

Color	Amber
Shelf Life	2 years (Unopened at 50° – 110°F)
Gallon Weight	8.4 lbs/gal

Safety and Handling

DuPont is committed to helping you develop and maintain a safe working environment. Carefully read the specific warnings and precautions printed on the labels and material safety data sheets (MSDS) of all DuPont products before handling and using. These products are for industrial use by trained professional painters only. Do not permit anyone in the painting area without protective equipment per product MSDS.

Revised 8/2005



Aviation Finishes