



JOHNSON MANUFACTURING COMPANY

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# TECHNICAL BULLETIN

## JOHNSON'S DEOXALUMINITE™ Part Number Series: 155-00



The original and still best high-aluminum content, organic, weldable, (weld-through) deposite primer that meets existing specifications required for many certified applications. Deoxaluminite, "Deox" for short, is used to inhibit rust, corrosion, and the resulting clean-up that would be necessary, whenever parts must be stored for an intermediate time before welding can occur. There is no requirement to remove Deox before or after welding. Instead, welding through Deox minimizes pinholes and weld porosity because it contains fine aluminum powder, not zinc powder or dust. This enables fine-grain, deep-penetration, high quality welds, after which, its coating is compatible with overcoat paints.

### Physical Properties:

Flash Point	60°F, Open Cup
Viscosity	9-15 s @ 80°F (Ford #4 Cup)
Appearance	Aluminum Pigmented Liquid
Odor	Pungent Solvents
Coverage	270 sqft/Gal @ 1 mil DFT without loss
%Solids	16.8 - by volume
VOC Rating	5.89
Shelf Life	18 months from date of Manufacturing

Surface must be clean, dry, free of dust or oil, before applying Deox. A Wheelabrator shot blasted surface provides the ideal profile to maximize consistency, uniformity, coverage, and adhesion. Aluminum oxide applied through a pressure blasting system, is also adequate, although the surface profile is spiked, so be sure to factor-in when calculating coverage requirements. Air blast or vacuum surfaces to remove all residual abrasive particles. Thinning Deox is not recommended, yet, when necessary, Xylene is preferred, even though it raises the VOC. Using Xylene may also speed the cleanup process.

**Stir well** and apply uniformly with a minimum dry film thickness of (DFT) of 0.75 to 2.0 mil maximum, per coat. Spray wet film thickness (WFT) should be between

2.0 to 2.5 mil max, per coat. Apply between the min/max with ambient and surface temperatures of 40°F to 100°F. Do not apply if relative humidity is more than 90%, or if surface temperature of the parts is within 5°F of the dew point.

Extensive testing has shown that the most consistent and economical method of application is with a HVLP (high volume, low pressure) spray system. However, successful application is also possible when brushing, dipping, or using standard spray equipment such as Binks 18, or equivalent, with a fluid tip 66 and air nozzle 66SD, or Binks equivalent with fluid tip 78 and air nozzle 78S.

Drying time at 70°F, to touch is 15 to 30 minutes. Recoat by spray or brush is 30 minutes. Hard cured is 24 hours.

### **Packaging:**

Item	P/N Single	P/N Case	Case QTY	Ship Wt (lb)
1 Gallon Pail	155-01	155-02	2	18.0
		155-04	4	36.0
5 Gallon Pail	155-05	-	-	45.0

### **Transport:**

Gallons and 5-Gallon Pails ship via UPS Ground

Due to their hazardous nature, these goods **cannot** ship via UPS Air.

All sizes ship via LTL Ground transportation as **NMFC 44500, Sub2, CL92.5, Flammable Liquid, NOI.**

***This material is flammable and ships as hazardous under UN1263, Paint, 3, PGII.***

### **Handling:**

Wear protective clothing and eye wear when handling Deoxaluminite. Always use in a well-ventilated area and avoid breathing fumes. Please refer to the OSHA Safety Data Sheet for additional information.

### **Waste Disposal:**

We cannot make specific recommendations due to variations in local laws. Consult your local waste disposal facility for specific recommendations.

***Before use, read and understand the manufacturer's instructions, Safety Data Sheet (SDS), and your employer's safety practices.***