PRODUCT DATA SHEET

HDTHERM 600

Description: A single component, silicon acrylic coating. It is Aluminium pigmented product which cures to a hard film at ambient condition. It has good weather and water resistance.

Recommended use: For long-term protection of hot pipelines, exhaust pipes, smoke stacks and other hot surfaces. In corrosive environment. Designed as a heat resistant coating. Suitable for insulated and non insulated surfaces. Recommended as finish coat for insulated surfaces, in systems with suitable primers

Service temperatures: Maximum, dry exposure only: 600°C.

Physical Properties :

Colours/shade Nos.:	Aluminium
Finish:	Semi Flat
Volume solids, %:	45 ± 2 %
Theoretical spreading rate:	18 m²/litre, 25 micron/1 miles
Flash point:	32°C
Specific gravity:	1.25 kg/litre
Surface-dry:	1 hours at 30°C
Touch-dry:	3 hours at 30°C
VOC:	468 g/l

Application details:

Mixing ratio:	**Single pack**
Application method:	Airless spray Air Spray/Brush
Thinner :	HD HR Thinner 600
Thinner (max vol)	5 – 15 %(According to separate application)
Nozzle orifice:	.017"-.018”
Nozzle pressure:	125bar [1800 psi] *(Airless spray data are indicative and subject to adjustment)*
Indicated film thickness, dry:	25 - 40 micron *(see REMARKS overleaf)*
Indicated film thickness, wet:	60 – 80 micron
Overcoat interval, min:	According to Specification
Overcoat interval, max:	According to Specification

Safety: Handle with care. Wear Necessary PPEs like safety shoes, gloves, goggles.

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Surface preparation:	Remove oil, grease and other contaminants by suitable detergent cleaning. Remove salts, detergents and other contaminants by high pressure fresh water cleaning. All damage of shop primer and contamination from storage and fabrication should be thoroughly mechanically/chemically cleaned prior to final painting. **New build:** Abrasive blasting to min. Sa 2½ (ISO 8501-1) / SP 10 (SSPC). Remove dust, blast media and loose materials. **Maintenance and Repair:** Remove dust, blast media and loose materials. Flash rust degree of maximum FR M (ISO 8501-4). Spot abrasive blasting to min. PSa 2 (ISO 8501-2) / SP 6 (SSPC). Minor areas can be cleaned by power tool to St 3 provided the surface is roughened and not polished.
Application conditions:	Drying and curing times are determined under controlled temperatures and relative humidity below 85 %, and at average of the DFT range for the product.
Colour Stability :	After exposure to heat the gloss is reduced. On first exposure to heat the temperature increase from ambient temperature to the required service temperature must run over a period of 24 hours.
Application :	The coating will be fully cured after: 7 days , 20°C/68°F When the paint is applied on zinc silicate coatings, popping may occur after application or after first heating up. To avoid popping it is recommended to follow the procedure: A thin, undiluted coat is applied (the mist coat) and after a few minutes, a second coat is applied in the full specified film thickness.
Film thicknesses/thinning: (optional)	May be specified in another film thickness than indicated depending on purpose and area of use. This will alter spreading rate and may influence drying time and Overcoating interval. Normal range dry is: 20-40 micron/0.8-1.6 mils. Excessive film thickness must be avoided. Unilay HR Thinner 600 can be added at application to secure the low dry film thickness. For high temperature service, the total dry film thickness of the paint system should preferably be kept at maximum: 80 micron.
Overcoating note: (optional)	May be over coated when through dry: 24 hours 20°C/68°F Before Overcoating after exposure in contaminated environment, clean the surface thoroughly with high pressure fresh water hosing and allow drying.
Storage:	Shelf life : 24 months (25°C) Subject to re-inspection thereafter. Higher temperature during storage may reduce the shelf life and may lead to gelling in the tin. Store in tightly closed container in a dry, cool and well ventilated space, keep away from sources of heat and ignition.