

APCOFINE 915 HR



PRODUCT DESCRIPTION

Two component, heat resistant polysiloxane coating

FEATURES & RECOMMENDED USE

- Self-priming; eliminates the usage of primer
- Excellent adhesion; Recommended on hand or power tool cleaned steel surface
- Suitable for exposure to dry heat up to 200°C and corrosion protection of steel under thermal insulation
- Continuous heat resistance to 200°C (392°F) & intermittent heat resistance up to 250°C (482°F)
- Good corrosion resistance; Good chemical resistance towards splash and spillage
- Cures at room temperature, no heat required before service
- Can be applied directly on hot metal surface of temperature up to 150°C

TECHNICAL DATA

Colour	Grey & Aluminium
Gloss	Satin
Volume Solids	Approx. 30%
Recommended DFT / Coat	30 - 40 µm
Theoretical Coverage Capacity	10.0 sq.mtr/ @ 30 µm 7.5 sq.mtr/ @ 40 µm
Drying time at 30°C	Surface dry : 2 hour Hard dry : 16 hours Full cure : 7 days
Over coating interval at 30°C	Min. : 16 hours Max. : 5 days, provided surface is cleaned from all contamination

The data given is for guideline only. The physical values are subject to normal manufacturing tolerances, colour and testing variances. The actual drying time/ overcoat interval may be shorter or longer, depending on film thickness, ventilation, humidity, temperature etc. The information provided above is at 30 °C and 65 % relative humidity.

DIRECTIONS FOR USE

Surface Preparation

General

- Surfaces must be dry, clean and free from contaminants
- Ensure removal of dirt, dust, oil and all other contaminants that could interfere with adhesion of the coating. Oil and grease should be removed as per SSPC - SP1 solvent cleaning
- Surface should be checked and treated in accordance with ISO 8504 prior to paint application

Blast Cleaning

- Steel, abrasive blast clean to min. Sa 3/2.5 Swedish specification prior to painting
- Surface should be clean, free from oil and grease before abrasive blasting
- A blasting profile of (Rz) 25-35 µm is recommended

For atmospheric exposure condition

- New hot-rolled steel; blast cleaned to min Sa 2.5 of Swedish specification
- Weathered steel; power tool cleaned to St 3 or hand tool cleaned to St 2
- Existing Coating; ensure removal of existing of old coatings and rust by scrubbing, then surface to be prepared to minimum St3/St2 by power tool / hand tool cleaning

Application Conditions

- Substrate temperature should be at least 3°C above dew point but not above 50°C
- Relative humidity should be below 85%
- Good ventilation is required in confined areas to ensure proper curing

Mixing

- Apcofine 915 HR is supplied in two packs. Stir the base and hardener separately. If settling is observed in the base, loosen the settled material with the help of hand stirrer followed by power driven stirrer for quick homogenous mixing
- Mix hardener gradually into the base under continuous stirring as per the mixing ratio. Once the unit has been mixed, it should be consumed within the working pot life. In case of part mixing (which should be avoided), close the lids of containers tightly to avoid contact with atmospheric moisture
- Thinner should be added after mixing the components. Addition of excessive thinner will lead to reduced sag resistance

Mixing Ratio (By volume)	Base : Hardner 9 : 1
Induction Time	NA
Pot Life at 30°C	4 hrs*

*Note : Mixed paint may appear in liquid condition for long period, but mixed material should be used within 4hrs

Application

Brush / Roller	
Recommended thinner	T - 131
Volume of thinner	NA
Air Spray	
Recommended thinner	T - 131
Volume of thinner	0 - 15 %*
Nozzle Orifice	1.5 - 3.00 mm
Nozzle Pressure	0.3- 0.4 MPa (approx 3-4 atm; 43-57 p.s.i.)
Cleaning Thinner	T - 131
Airless Spray	
Recommended thinner	T - 131
Volume of thinner	0 - 15 %*
Nozzle orifice	0.28 - 0.33 mm (11 - 13 Thou)
Nozzle pressure	10 - 13 MPa (approx.100-130atm ; 1400 -1800 p.s.i)
Cleaning Thinner	T - 131

*Note: Depending on recommended thickness & application condition

Cleaning

- Do not allow the product to remain in hoses, gun or spray equipment. Clean all equipments immediately after use with Thinner T - 131. It is recommended to periodically flush out spray equipment during the course of the working day. The frequency of cleaning will depend on amount sprayed, temperature and time gap
- All surplus material and empty containers should be disposed off in accordance with appropriate regional legislation

Product Characteristics

- When applying by air spray / brush, it may be necessary to apply multiple coats to achieve the total specified dry film
- Level of sheen and surface finish is dependent on application method. Best results in terms of gloss and appearance will be always obtained with conventional air spray application
- As common with all polysiloxane coatings, special care must be taken when applying multiple coats of Apcofine 915 HR to ensure that a continuous wet film is applied. Failure to do so may result in pin holing which will downgrade appearance and performance
- Condensation occurring during or immediately after application may result in matt finish and an inferior film
- On continuous exposure to 200°C temperature, gloss shrinkage and colour change will occur, but protective property will not get deteriorated
- Pot life time must not exceeded even though the material may be still liquid and appear usable. Failure to comply with this will result in film with inferior performance
- The product is not recommended for use in immersion condition
- The coating has been designed to give best protection when applied under controlled application parameters & as per given system recommendation
- Best performance can be obtained within two coats application

Note: It is recommended to mix a complete unit in the proportion supplied and can be used with in the pot life specified

PACK SIZE	10 L (Base : 9 L & Hardner : 1 L)
STORAGE	Shelf Life: At least 12 months at 30°C for original unopened pack, subject to inspection thereafter. Store in a cool, dry place and in accordance with local regulations
REGULATORY INFORMATION	Flash point: Base: Not less than 24°C Hardener : Not less than 24°C VOC: 600 ± 25 gm/ ltr (depending on shades)as per USA-EPA Method 24 Product Weight: Approx. 1.06 ± 0.03 kg/ ltr (depending on shades)

SAFETY INFORMATION

- As a general safety measure, inhalation of solvent vapours or paint mist and contact of liquid paint with skin & eyes should be avoided. Forced ventilation should be provided when applying paint in confined spaces or stagnant air. Even when ventilation is provided, respiratory, skin and eye protection are always recommended when spraying paint
- Please refer our Material Safety Data Sheet prior to using the product

Disclaimer: To the best of our knowledge the information provided herein are true and accurate at the date of issuance. Since we have no control over the quality or condition of the substrate or the various factors affecting the use and application of the product, we do not accept any responsibility or liability arising out of use of the product. The company reserves the right to modify data contained herein without prior notice. Any change in data would normally be followed by issue of a new data-sheet. The user should check with the nearest sales office of the company and confirm the validity of the information, prior to using the product.

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