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## TECHNICAL INFORMATION SHEET

# 360 HI-TEMP SILVER ENAMEL

April 2009

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### Description and uses:

360 Hi-Temp Silver is a heat resisting enamel based on a silicone modified resin.

360 Hi-Temp Enamel has the following features:

- Withstands temperatures up to 510°C.
- Recoatable.
- Suitable for interior and exterior applications.

Typical areas of application are:

- Smoke and boiler stacks, oil refineries.
- Engine exhaust pipes and manifolds.
- Furnaces, ovens, stove and heater doors etc.

### Technical Specifications:

FINISH: Semi-Gloss Bright Silver.

THINNERS: T102 or T104.

VOLUME SOLIDS: 40 - 42%

COVERAGE: Approximately 12-14 Square metres per litre (at a D.F.T. of 25 microns).

RECOMMENDED FILM THICKNESS: 20-25 microns.

APPLICATION: Conventional and airless spray, brush and roller.

DRYING AT 25°C / 50% Humidity: Touch Dry: 2 - 4 Hours

Recoat: After overnight dry.

Handle: 24 Hours.

Full Cure: Product does not achieve maximum hardness until painted surface is exposed to temperatures above 200°C for a minimum of 2 hours.

# 360 HEAT RESISTING ENAMEL

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APPLICATION DETAILS – PAINTING SYSTEMS			
D.F.T. um			
System 1 Temperature 100 - 250°C	1 <sup>st</sup> Coat	20-25	360 Heat Resisting Primer (Thinner T102 or T104)
	2 <sup>nd</sup> Coat	20-25	360 Hi-Temp Silver (Thinner T102 or T104)
	3 <sup>rd</sup> Coat	20-25	Optional 360 Hi-Temp Silver (Thinner T102 or T104)

D.F.T. um			
System 2 Temperature 200 - 510°C	1 <sup>st</sup> Coat	20-25	360 Hi-Temp Silver (Thinner T102 or T104)
	2 <sup>nd</sup> Coat	20-25	360 Hi-Temp Silver (Thinner T102 or T104)

APPLICATION DETAILS – SURFACE PREPARATION		
SUBSTRATE	DETAILS	RECOMMENDED SYSTEM
Steel	Power tool clean to AS1627.2 class 2 or abrasive blast clean to AS1627.4 Class 2	1,2

## Surface Preparation:

- When overcoating; Aged paint coatings should be tested for adhesion using Crosshatch or Crosscut methods. If aged paint coating lifts remove it.
- Remove all rust, oxides, mill scale and loose paint from metal surface.
- Round off all sharp edges, welding joints and weld spatter.
- All surfaces to be painted should be clean and free from dust, dirt, oil, grease and moisture.
- All abrasive blast clean ferrous surfaces should be coated within 4 hours to avoid flash rusting.
- Do not apply at temperatures below 5° Celsius. Do not apply at relative humidity above 85%, or when the substrate surface is less than 3° Celsius above dewpoint.

## Equipment Application: (Conventional or Airless Spray Recommended).

As a Guide Use:

Brush or Roller - Apply even coats to prepared surface, more than one coat may be required to achieve specified film thickness.

Conventional Spray - 1.3 -2.0mm tip (or equivalent). Pressure pot set at 55 - 100kpa (8 - 15psi) and maintain gun air pressure 275 - 380kpa (40 -55psi).

Airless Spray - Use heavy-duty airless spray with 10 -15 “(0.25 – 0.38mm) plus tip and pump ratio 30:1

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## **Application Thinning:**

Brush or Roller – Thinning not normally required, up to 5% as required.

Conventional Spray – Thin approximately 10 - 20% and apply.

Airless Spray – Thinning not normally required, however up to 5% may assist.

Clean Up – T102, or T104.

## **Safety Instructions:**

Storage: Store in a cool, dry banded area out of direct sunlight as required for Flammable liquids DG Class 3, PG II, Hazchem 3(Y)E.

Flammability: Highly flammable, all sources of ignition must be eliminated in or near area of use, on burning fumes emitted are toxic. Do not smoke in immediate area.

Handling: Adopt adequate Occupational Work Practices to avoid personal contamination with product. Always wash hands before smoking, eating, drinking or using toilet. Food and Drink should be to stored and consumed in separate area.

Personal Protection: Avoid contact with skin or eyes; wear suitable clothing such as impervious overalls, PVC or neoprene gloves, safety goggles and face mask.

Using: Avoid inhalation of spray mist and vapours – use with adequate ventilation and suitable Personal Protection Equipment (PPE).

Engineering controls: Ensure ventilation is adequate. When spraying, ensure product is applied in a fully functional spray-booth. Keep containers closed when not in use. Do not use near ignition sources.

## **REFER MSDS BEFORE USE**

(Phone 02 9688 1999 or refer to [www.lacnam.com.au](http://www.lacnam.com.au) for copy MSDS)

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