

412 HEAT RESISTING FINISH

PRODUCT DATA:

- ◆ *Excellent heat resistant property*
- ◆ *Easy application property*
- ◆ *Good resistance to moisture*
- ◆ *Good resistance to abrasion and weather*

PRODUCT INFORMATION

Designed to be a heat resistant finish coating for primed steel structures subjected to temperatures up to 200°C of industrial environments : petrochemical plants, power stations an offshore structures etc.

Suitable for use as a general purpose aluminium maintenance coating for steel under ambient exposure conditions.

APPLICATION:

PRACTICAL APPLICATION RATES

Micron Per Coat	Airless Spray		Conventional Spray	Brush	Roller
	Dry	Wet			
	25	44	25	25	25
	44		44	44	44

AVERAGE DRYING TIME

Ambient Temperature	Touch Dry	Hard Dry	Overcoating Interval	
			Minimum	Maximum
15°C	4 hours	12 hours	24 hours	Indenfinite
25°C	3 hours	8 hours	16 hours	Indenfinite
35°C	2 hours	6 hours	8 hours	Indenfinite

Application Method	Brush/Roller, Conventional Spray and Airless Spray.
Mixing Ratio (by volume)	None.
Thinner	Thinner No. 1.
Thinner Consumption	Brush – 0-5% Conventional Spray – 5-10% Airless Spray – 0-5%
Airless Spray	Nozzle Size : 0.33-0.38mm (13-15 thou) Fan Angle : 65° Operating Pressure : 110-150 kg/cm ² (1600-2100 psi)
Conventional Spray	Nozzle Size : 1.27mm (50 thou) Atomising Pressure : 3.5 kg/cm ² (50 psi) Fluid Pressure : 0.7-1.0 kg/cm ² (10-15 psi)
Brush	This product is suitable for brush application..
Roller	This product is suitable for roller application.



Application Method



65° Spraying Tip



Pratice Proper Cleaning



THE MAINTENANCE SOLUTOR
http://www.alspec.com

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APPLICATION CONDITIONS AND OVERCOATING

This product should preferably be applied at temperature in excess of 10°C, In conditions of high relative humidity i.e. 80-85%, good ventilation conditions are essential. Substrate temperature should be at least 3°C above the dew point.

At application temperature below 10°C, drying and curing time will be significantly impaired.

Application at temperature below 5°C is not recommended.

If it is desired to overcoat outside the times stated on the data sheet, please seek advice from **Alspec** representative.

PHYSICAL DATA:

Volume Solid	57%
Theoretical Coverage	22.7 m ² /litre @ 25 microns DFT
Type	One components
Packing Ratio	None
Colour Availability	Aluminium and selected colour range
Flash Point	38°C
Recommended Thickness	25 microns DFT
Recommended Thinner	Thinner No. 1

SURFACE PREPARATION:

Steel : This product is not designed to provide anti corrosive protection and it should be applied to abrasive blast cleaned surface that has been suitably primed.

Remove all wax, oil and grease by solvent cleaning in accordance with the guideline given by SSPC-SP1.

Dry brushing to remove soluble salts, dirt and dust.

Mechanically clean the surface using hand and power tools to a minimum standard of St.2 (ISO8501-1:1988) or SSPC-SP2.

The surface to be coated must clean and dry and free from all visible traces of surface contaminants.

