

TECHNICAL DATA SHEET

PERMABOND HR 200

ACRYLIC MODIFIED SILICONE H.R. FINISH

DESCRIPTION:	Single component, heat resistant silicone finish.		
RECOMMENDED USE:	For the long term protection of steel surfaces, operating in a temperature up to 300°C. For maximum corrosion protection prime with inorganic zinc silicate primer.		
RESISTANCE TO:	Moisture - Good	Abrasion – Good	
	Weather - Good	Heat - Excellent	
PRODUCT INFORMATION:			
Colour:	Off white and Aluminum		
Finish:	Semi-matt		
Volume solids %:	30 ± 2% (ASTM-D2697-86)		
V.O.C.:	600 g/l (NB. – Thinning will affect VOC compliance and volume solids)		
Typical thickness:	25 - 50 microns dry film thickness		
Theoretical coverage:	12 m2/ltr. @ 25 microns dft		
Density:	1.10 ± 0.10 g/cc		
Mixing ratio:	Not applicable		
Shelf life:	24 months from the date of manufacture		
Pot life:	Not applicable		
Pack size:	20 & 5 litres		

FILM THICKNESS AND SPREADING RATE:	MIN.	MAX.	UNIT
Dry film thickness	25	50	µm
Wet film thickness	84	167	µm
Spreading rate	12	6	m ² /l (theoretical)

This figure makes no allowance for surface profile, uneven application, overspray or losses in containers and equipment. Film thickness will vary depending on actual use and specification.

SERVICE TEMPERATURE: 300°C maximum dry

RECOMMENDED THINNER: Thinner No. 22 (5%)

DRYING & CURING TIME:

SUBSTRATE TEMPRATURE	15°C	23°C	35°C
Touch dry	2 hours	1 hour	¾ hour
Dried to over coat (minimum)	6 hours	4 hours	3 hours
Walk-on-dry	24 hours	16 hours	12 hours

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SURFACE PREPARATION:

Ensure surfaces to be coated are clean, dry and free from all surface contamination.

RECOMMENDED COATING SYSTEM:

Primer:	PERMAZINC IO 90
Topcoat:	PERMABOND HR 200

Note: For high temperature services, the total DFTs of paint system should not exceed 75 microns.

RECOMMENDED APPLICATION METHODS:

Airless spray, conventional spray, roller, brush

APPLICATION EQUIPMENT DETAILS:

1. AIRLESS SPRAY

Nozzle Size: 0.38mm (15 thou)

Fan Angle: 30°

Operating Pressure: 233kg/cm² (3300 psi)

2. CONVENTIONAL SPRAY

Nozzle Size: 1.27mm (50 thou)

Atomising Pressure: 2.8kg/cm² (40 psi)

Fluid Pressure: 0.7kg/cm² (10 psi)

APPLICATION CONDITIONS AND OVER COATINGS:

This material should preferably be applied at temperatures 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 and always above 0°C. At application temperatures below 10°C, drying and curing times will be significantly extended, and spraying characteristics may be impaired. Application at ambient air temperatures below 5°C is not recommended.

HEALTH AND SAFETY:

Please observe the precautionary notices displayed on the container. Do not breathe or inhale mist. Avoid skin contact. Spillage on the skin should immediately be removed with suitable cleanser, soap and water. Eyes should be well flushed with water and medical attention sought immediately.

Consult Product Health and Material Safety Data Sheet for information on safe storage, handling and application of this product.

Disclaimer: The information in this document is given to the best of KPC Paint's knowledge that based on laboratory testing and practical experience Products are often used under conditions beyond KPC's control and KPC Paints cannot guarantee anything but the quality of the product itself.

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