

# MEGATHERM SILICONE RESIN PAINT

## PRODUCT INFORMATION



<b>Designation of type</b>	⇒ SI	State of 4/18
<b>Product description</b>	<ul style="list-style-type: none"><li>⇒ Highly heat-resistant single-coat paint, low in aromatics and free of heavy metals</li><li>⇒ SI 708.4 dark grey                  heat resistant up to 500 °C without loss of adhesion</li><li>⇒ SI 710 aluminium coloured heat resistant up to 650 °C without lost of adhesion</li><li>⇒ SI 711 black                  heat resistant up to 650 °C without lost of adhesion</li><li>⇒ Good protection against corrosion (SI 708.4 no resistance to water shocks)</li><li>⇒ Minor colour changes and loss of gloss above 230 °C</li><li>⇒ Good mechanical properties when air drying</li><li>⇒ Excellent adhesion to steel, aluminium, non-ferrous metals</li><li>⇒ Final hardness and corrosion resistance after heat treatment</li><li>⇒ Does not cause silicone damage when processing other coatings</li></ul>	
<b>Application area</b>	<ul style="list-style-type: none"><li>⇒ SI 708.4 for interior use, for example furnaces, heating tunnels, electrical and gas heaters</li><li>⇒ SI 710, SI 711 for interior and exterior use for example funnels, barbecue devices, car silencers</li></ul>	
<b>Binder</b>	⇒ Silicone resin	
<b>Substrate/Preparation</b>	<ul style="list-style-type: none"><li>⇒ Steel: at least degrease, better hand or eccentric sanding St 2-3 (P80-P220) or sand blasted to Sa 2 ½ DIN EN ISO 12944, part 4</li><li>⇒ Cast iron: sand blasted to Sa 2½ DIN EN ISO 12944, part 4</li><li>⇒ Aluminium: sweeping or hand sanding</li><li>⇒ Stainless steel: at least degrease, better slightly sanding or pickling</li><li>⇒ All surfaces dry, free of fat, oil, grease and dirt</li></ul>	
<b>Processing</b>	<ul style="list-style-type: none"><li>⇒ Gravity feed gun: 1.3-1.7 mm nozzle, 3-4 bar atomisation pressure, 10-15 % thinner VS 50</li><li>⇒ HVLP: 1.4-1.7 mm nozzle, 1.5 -2.0 bar atomisation pressure, 5-10 % thinner VS 50</li><li>⇒ Double-diaphragm-pump: 1.0-1.2 mm nozzle, 2.5-3.5 bar atomisation pressure, material pressure 0.8-2.0 bar, 5-10 % thinner VS 50</li><li>⇒ Airmix: 0.18-0.23 mm nozzle, 3-4 bar atomisation pressure, material pressure from 70 bar up, 0-5 % thinner VS 50</li><li>⇒ Pre-spray once in difficult-to-reach areas</li><li>⇒ Dependent on film thickness 1-2 spraying cycles, 3-6 minutes intermediate flash off time</li><li>⇒ Ambient temperature: at least + 10° C, relative air humidity: max. 75 %</li><li>⇒ Object temperature: at least. + 5° C and at least 3° C above the dew point</li></ul>	
<b>Viscosities</b>	<ul style="list-style-type: none"><li>⇒ Viscosity at delivery:                  30-40 sec. 4 mm / DIN</li><li>⇒ Compressed-air spraying:                  20-30 sec. 4 mm / DIN</li><li>⇒ Double-diaphragm-pump:                  25-35 sec. 4 mm / DIN</li><li>⇒ Airmix:                  ca. 40 sec. 4 mm / DIN</li></ul>	

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<b>Thinner</b>	⇒ VS 50	
<b>Drying time at 20° C</b>	⇒ Tack-free ⇒ Ready for installation ⇒ Final hardness	after approx. 45 minutes after a few hours after heat treatment (at least 200° C)
<b>Heat hardening</b>	⇒ Flash off time before heat hardening 10-15 minutes ⇒ 90 minutes at 200° C or ⇒ 60 minutes at 220° C or ⇒ 45 minutes at 250° C	
<b>Colours</b>	⇒ SI 708.4 dark grey, SI 710 aluminium coloured, SI 711 black ⇒ Limited availability for all SI-types	
<b>Degree of gloss</b>	⇒ Silk-matt before and matt after heat treatment	
<b>Specific weight</b>	⇒ Ø 1.3 g/cm³	
<b>Solid matter content</b>	⇒ Ø 68 % (percent by weight)	
<b>Solvent content</b>	⇒ Ø 32 % (percent by weight)	
<b>Film thickness</b>	⇒ 40-60 µm dry film thickness / 75-115 µm wet film thickness ⇒ At sand blasted to Sa 2½ (roughness depth 45 µm) at least 60 µm dry film thickness	
<b>Theoretical coverage</b>	⇒ Ø 9.0 m²/kg at 40 µm dry film thickness	
<b>Practical consumption</b>	⇒ Compressed-air spraying: approx. 0.16 kg/m² or 6.3 m²/kg at 40 µm dry film thickness ⇒ Airless: approx. 0.21 kg/m² or 4.8 m²/kg at 60 µm dry film thickness	
<b>VOC-value ready to use</b>	⇒ 480 g/l ⇒ Limiting value industrial coating: no specification Coating of other metal and plastic surfaces	
<b>Standard packaging</b>	⇒ 10 kg / 25 kg	
<b>Shelf life</b>	⇒ At + 10 to + 30° C and unopened packaging ½ year	
<b>Material safety data sheet</b>	⇒ No. 015	
<b>Flash point</b>	⇒ > + 23° C	

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