

52300 KANTHERM 600 ALU

PRODUCT DESCRIPTION

52300 KANTHERM 600 ALU is a silicone resin based, one component, air drying, metallic coating curing with heat. It contains aluminium pigments for improved heat resistance. It has outstanding resistance to severe weathering. It exhibits excellent elasticity along with low permeation to moisture. Service temperature range is 0-600°C dry temperature.

RECOMMENDED USE

It is used as a protective coating on heated steel surfaces exposed up to 600°C continuous dry temperature for;

- Exteriors of furnaces.
- Exteriors of steel chimneys.
- Exteriors of exhaust systems and gas channels .
- Other exposures in industrial areas subjected to high temperatures.

PRODUCT CHARACTERISTICS

Finish: Metallic	Density (g/ml) 1,18±0,10
Colour: Silver	Spreading Rate (m ² /l) 13,20 (25 microns DFT)
Thinner: Kanat Thinner 0672	Flash Point 38°C
Mixed Product; Volume Solids (%) 33±2	VOC (Volatile Organic Content) 577 g/l
	Application Methods Airless Spray, Conventional Spray, Roller

DRYING SCHEDULE(*)

(25 microns/1 mil film thickness)

	Dry to Touch	Hard Dry	Dry to Over Coat Minimum
5°C	9 hours	-	9 hours
15°C	7 hours	-	7 hours
25°C	5 hours	-	5 hours
35°C	3 hours	-	3 hours
170-200°C	-	1 hour	-

Drying values are valid for defined dry film thickness and below 80% relative humidity.

(*) Drying time depends on temperature, humidity and film thickness.

PACKAGING

One pail of **52300 KANTHERM 600 ALU** is 16 l.

SHELF LIFE

1 year when the material is stored in a cool and dry place in unopened original containers.

HEALTH/SAFETY PRECAUTIONS

Refer to the MSDS sheet prepared according to EU directives before use.

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SURFACE PREPARATION

Surfaces must be dry, clean, free of oil, grease and other foreign material.

New Steel Surfaces: Surfaces should be blasted to near-white metal surface cleanliness according to SSPC-SP10 or ISO 8501-1 Sa 2½. Blast profile on steel should be 40-50 microns in depth. Depending on ambient conditions, blasted surfaces must be primed in maximum 5 hours with **52300 KANTHERM 600 ALU**.

Previously Painted Surfaces: Remove all the old paint to bare steel by abrasive blasting.

Rusty Surfaces: Contact KANAT PAINTS & COATINGS Project Group.

Touch-up: Remove all dust, dirt and other foreign material and keep dry. Blast the surface to Sa 2½ level mechanically according to ISO 8501-1 and complete the touch-up application as soon as possible. **52300 KANTHERM 600 ALU** can be safely used for touch-up.

APPLICATION PROCEDURES (Mixing Procedure)

This is one-component paint. Add thinner if necessary and homogenize the mixture with a power mixer before use.

APPLICATION CONDITIONS

For the best results;

Temperature must be more than 5°C during the application and/or the curing process.

Surface temperature: At least 3°C above dew point.

Relative humidity: 80% maximum.

Good ventilation is required during application

APPLICATION

Stripe coat all crevices, welds and sharp angles. Apply paint at the recommended film thickness and spreading rate.

Application of coating above maximum or below minimum recommended spreading rate may adversely affect coating performance. 24 hours drying or 170-200°C for 1 hour forced drying is recommended before the second coat for best results. Do not apply more than 100 microns (4 mils) WFT to prevent sagging. When using spray application, use a 50% overlap with each pass of the gun to avoid holidays, bare areas and pinholes. If necessary, cross spray at a right angle.

CURING

Paint system shall not be exposed to high temperatures before full drying (at least 24 hours at 20°C). Paint film should be cured at 170-200°C for 1 hour to acquire high temperature resistance. Painted small parts shall be cured in an appropriate furnace. Painted parts in the plants shall be cured by adjusting service temperature to 170-200°C for 1 hour after full drying.

CLEAN UP

KANAT THINNER 0644, KANAT THINNER 0672

APPLICATION EQUIPMENT

(The table is a guide for 20°C)

Application Equipment	Airless Spray	Conventional Spray	Roller
Thinner maximum	5%	15%	5%
Pressure minimum (bar)	100	2,5	-
Nozzle(inch)	0,011-0,015	1,4-1,6	-

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PRECAUTIONS

- Contact KANAT PAINTS & COATINGS Project Group in case surface preparation is not applicable either by blasting or mechanical cleaning.
- If maximum recoating time is exceeded abrade surface, if the surface is highly contaminated apply pressurized fresh water cleaning before recoating.
- DFT of the paint system should not exceed 75 microns for maximum high temperature resistance.

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