



Technical Data Sheet

Date of Issue: 30/09/2022 Revision Date 30/09/2022 | Version 5.0

Product name

# PLASCOTHERM 540 SB

## HIGH TEMPERATURE RESISTANT COATING (HRA 6)



### PRODUCT DESCRIPTION

A single pack high temperature resistant modified silicone resin-based coating.

### INTENDED USES

- This product is recommended for stacks, furnaces, boilers, exhausts, jet engines and metal parts which operate at elevated temperatures.
- A high temperature resistant finish for maintenance and new construction.

### FEATURES AND BENEFITS

- Durable finish with excellent decorative appearance
- No long-term over-coating restrictions
- Cures at ambient temperature but resistant to temperatures up to 540 °C.
- Excellent corrosion resistance when applied over an inorganic zinc primer.

### PRODUCT INFORMATION

Appearance	Gloss
Colour	Aluminium
Volume Solids	± 11% (typical)
Recommended DFT	Min: 15µm, Max: 25µm
Recommended WFT	Min: 140µm, Max: 230µm
Theoretical spreading rate	5.4m <sup>2</sup> /L at 20µm DFT at stated volume solids.
Practical spreading rate	The practical spreading rate will vary depending on the porosity and profile of the substrate as well as the application techniques & tools used.
VOC	<755g/L
Flash Point	24°C
Viscosity	35 – 40seconds (typical)Ford Cup No. 4



## APPLICATION DETAILS

Mixing	Stir well with a power agitator until completely homogeneous.		
Method	Airless and conventional spray and brush and roller.		
	Airless spray: Recommended Tip Size: 0.017” – 0.019” Nozzle pressure: 172 bar (2500 p.s.i.)		
	Conventional Spray: Recommended Tip Size: 0.015” – 0.020” Nozzle pressure: 2.8 – 4.2 bar (40 - 60 p.s.i.)		
	Brush and roller : suitable as supplied		
Application environment	Surface Temperature	Min*: 10°C	Max: 40°C
	Ambient Temperature	Min*: 10°C	Max: 40°C
	Relative Humidity	Min*: 10%	Max: 85%
	*Or 3°C min. above dew point		
Thinning	THINNER 5030(PUR 1)		
Cleaning	THINNER 5030(PUR 1)		
Drying Time	Touch dry	6h at 23°C	
	Over coating(Min)	24h at 23°C	
	Over coating(Max)	Indefinite at 23°C	
	Dry to handle	24h at 23°C	
	Full Cure	This coating will air dry but must be heated to 300 °C for 60 minutes to obtain full cure before use	

## STORAGE AND PACKAGING

Store away from direct sun, heat, open flames, sparks and severe cold.

Shelf Life: 24 months

Single Pack: 5L

## SURFACE PREPARATION

All surfaces must be firm, dry, and clean, free from oil, grease, or any other contaminants.

All surfaces before painting should be assessed and treated in accordance with ISO 8504 -1:2000 and 8504 -2:2000



## MILD STEEL

- Oil and grease should be removed using STEELTECT 7100 SB(GR1) followed by clean water rinses.
- Soluble chloride content may not exceed 75mg/m<sup>2</sup>.
- Dust and debris not to exceed 0.3% when tested in accordance with SANS test method 769.
- Preferred surface preparation is abrasive blast clean to SA 2½ of the International standard ISO 8501-1:2007 to achieve an angular blast profile 50 -75 µm or if abrasive blasting is impossible, mechanically abrade to Grade ST3 ISO 8501-1:2007 – this is not as effective as abrasive blasting and will reduce the life expectancy of the coating system.
- The primer must be applied before oxidation of the steel occurs. If oxidation does occur the entire oxidised area should be re-blasted or abraded to the standards specified above.
- In aggressive corrosive atmospheres prime with PLASCOZINC 1 PRIMER (PZI 233).
- Self-prime: must achieve a minimum temperature of 250 °C to be sintered into the metal. (Otherwise flash rusting may occur).

## APPLICATION INFORMATION

- Apply 2 coats to suitably prepared steel at the recommended DFT. Allow 24h drying between coats.
- Surfaces should be painted at ambient temperature and allowed to dry for 24 hours before heat is applied otherwise blistering and bubbling will occur.
- Recommended temperature for full cure is 45 – 60min at 250°C.
- Do not use below or above the minimum or maximum temperature limits.

## SAFETY PRECAUTIONS

- Always keep paint out of reach of children.
- Ensure good ventilation during application and drying.
- If accidental contact with skin should occur, wash immediately with soap and water or a recognised skin cleaner.
- Take care to avoid contact with the eyes. In case of contact, immediately rinse the eyes with plenty of water and seek medical attention.
- Harmful if swallowed. Seek medical attention and do not induce vomiting.
- Do not smoke while painting.
- Flammable. Store in a cool dry place away from heat and sparks.
- Refer to Safety Data Sheet for complete information.



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### **DISCLAIMER**

The recommendations contained herein are given in good faith and are meant to guide the specifier or the user. They are based on results gained from our tests and experiences and are believed to be dependable. No guarantee is implied by the recommendations contained herein since conditions of use, method of application and cleanliness of the substrate prior to painting are beyond our control.

**NB:** Technology may change with time necessitating changes to this Technical Data Sheet (TDS). It is the responsibility of the user to ensure that the latest TDS is being used.

**NB: TO ORDER:** Quote product name, product code number, packaging, and colour.

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