

Technical Data Sheet

HYDROTHERM® 400 Primer

Serie 137550

PRODUCT DESCRIPTION

Fast drying anticorrosive primer based on water silicone polymers and heavy metal free corrosion inhibiting pigments. Good adhesion on steel and aluminium.

INTENDED USES

Primer of anticorrosive heat resistant system used primarily to coat heat exchangers, incinerators, valves, boilers and other surfaces where temperatures do not exceed 430°C. VOC < 10%.

TECHNICAL INFORMATION

| | | | | |
|------------------------------------|-----------------------------|----------------|--------------------------------|--------------------------|
| Product type | Water based silicone primer | | | |
| Colours | Grey, Light Green | | | |
| Solids (% +/- 2) | 53 (by Volume) | 65 (by Weight) | SOV/VOC (g/liter) | <80 Directive 2004/42/CE |
| Specific Gravity (g/liter +/- 100) | 1350 | | SOV/VOC (g/liter) (calculated) | <80 Directive 2010/75/CE |
| Flash Point (°C +/- 2) | > 61 | | | |
| Appearance | matt | | | |
| Temperature Resistance (°C) | up to 430 (dry) | | | |

APPLICATION DATA

| Application Range (min - max) Typical | Film thickness per coat in micron | | Theoretical spreading rate | | Consumption |
|---|-----------------------------------|------------|----------------------------|--------------------|------------------|
| | Dry | Wet | m ² /l | m ² /kg | g/m ² |
| | 60 - 100 | 114 - 189 | 8.8 - 5.3 | 6.5 - 3.9 | - |
| | 80 | 151 | 6.6 | 4.9 | 204 |

| | | | | | |
|------------------|---------------------------------|----------|-------------------|--------|---------|
| Room Temperature | min 10°C | Max 40°C | Relative Humidity | min 5% | Max 70% |
| Mixing Ratio | --- | | | | |
| Pot life | N.A. | | | | |
| Thinner/Cleaner | clear water (max. 5% by weight) | | | | |

Application methods Airless or conventional spray, brush or roller.

Guideline for airless spray

| | |
|--------------------|--|
| Pressure at nozzle | 15 Mpa (150 kp/cm ² , 2100 psi) |
| Nozzle tip | 0,46 - 0,58 mm (0,018 - 0,023") |

Ti.Pi.Ci. s.a.s. di C.M. Pinto & C.

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HYDROTHERM® 400 Primer**Series 137550****SURFACE PREPARATION**

STEEL: blast cleaning to Sa 3 (Sa 2,5).

ALUMINIUM: must be undamaged, degreased and dry.

CONDITION DURING APPLICATION

the temperature of the substrate should be min. 10°C and min. 3°C above the dew point of the air. The temperature and relative humidity should be measured in the vicinity of the substrate.

DRYING TIMES

Drying times are generally related to air circulation, temperature, film thickness and number of coats, and will be affected correspondingly. The figures given in the table are typical with: good ventilation (outdoor exposure or free circulation of air), recommended film thickness, one coat on top of inert substrate.

| Substrate temperature | Surface Dry ¹ | Hard Dry ² | Cured ³ | Dry to recoat ⁴ | |
|-----------------------|--------------------------|-----------------------|--------------------|----------------------------|----------------------|
| | | | | minimum ⁵ | Maximum ⁶ |
| 10°C | | 2 h | 48 h | 12 h | - |
| 20°C | | 1,5 h | 24 h | 8 h | - |
| 30°C | | 1 h | 24 h | 4 h | - |

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2 Data resulted by tests and experience in practical applications. A good ventilation can improve the drying time.

3 Data resulted by tests and experience in practical applications.

4 Recommended data given for recoating with same generic type of paint.

5 In case of multi-coat application, drying times will be influenced by the number in sequence and by the total thickness of previous coat applied.

6 The surface should be dry and free from any contamination prior to application of the subsequent coat.

Given data must be considered as guidelines only. Actual drying time can only be decided at site, depending on age of existing system, generic types, numbers of coats, thinning, temperature, ventilation, etc.

THIS PRODUCT IS INTENDED FOR PROFESSIONAL USE ONLY

The applicators and operators shall be trained, experienced and have the capability and equipment to mix/stir and apply the coatings correctly and according to Ti.Pi.Ci.'s technical documentation.

STORAGE AND PACKAGING**STORAGE**

the product should be stored in accordance with national regulations. The best storage conditions are to keep the packages in a dry space provided with adequate ventilation.

SHELF LIFE

12 months at room temperature.

PACKAGING

20 kg

HEALTH AND SAFETY

For detailed information on the health and safety hazards and precautions for the use of this product, we refer to the Material Safety Data Sheet.

Disclaimer

The information in this data sheet is given to the best of our knowledge based on laboratory testing and practical experience. However, as the product is often used under conditions beyond our control, we can not guarantee anything but the quality of the product itself. We reserve the right to change the given data without notice.

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