

Technical Data Sheet

HYDROTHERM® GF 1000

Serie 160457

PRODUCT DESCRIPTION

Fast drying water based glass flakes reinforced anticorrosive paint based on modified silicone resins and heavy metal free corrosion inhibiting pigments. Excellent adhesion properties on stainless steel for operating temperatures up to 1000 ° C.

INTENDED USES

Particularly suitable as a single coat for protection of stainless steel structures exposed to very high temperatures (up to 1000°C) as stoves, heat exchangers or muffler. HYDROTHERM GF 1000 can be used in combination with zinc silicate coatings and zinc silicone coatings (up to 400°C) or on other primer of HYDROTHERM brand.

TECHNICAL INFORMATIONS

Product type	Water based modified silicone coat glass flakes reinforced				
Colours	Black				
Solids (% +/- 2)	53 (by Volume)	56 (by Weight)	SOV/VOC (g/liter)	<95	Directive 2004/42/CE
Specific Gravity (g/liter +/- 100)	1250		SOV/VOC (g/liter) (calculated)	<95	Directive 2010/75/CE
Flash Point (°C +/- 2)	not flammable				
Appearance	matt, slightly textured				
Temperature Resistance (°C)	1000 (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
20 - 50	38 - 95		26.5 - 10.6	21.2 - 8.5	-
30	57		17.7	14.1	71

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

Application methods

Airless or conventional spray.
PRACTICAL NOTE: HYDROTHERM GF 1000 is dry to touch in about 30-45 minutes. If the product has not been heat cured, wait at least 24 hours before packing and shipping the structures avoiding mechanical damage and abrasion.
The exposure at 120 ° -150 ° C for a time period of at least 15-20 minutes will increase the surface hardness, the complete polymerization will take place once the structure will placed into service.

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® GF 1000**Series 160457****SURFACE PREPARATION**

STAINLESS STEEL: must be undamaged, degreased and dry, blast cleaning to Sa 3 - Sa 2,5.

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		1 h	48 h	2,5 h	-
20°C		30 - 45 min.	24 h	1,5 h	-
30°C		30 min.	24 h	1 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 As provided for recoating with the 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 contaminants before applying the next 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** 5 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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