

### Product description:

1-component coat on the basis of specific heat-reactive silicone resins, solvent-based.

### Applications:

Systems that become warm or hot and are exposed to weather such as exhaust gas lines, cupola furnaces, rotary kilns, annealing furnaces and smelting furnaces as well as exhaust systems. In a system with suited primary coats it ensures very good corrosion protection while being resisting to weather. Full resistance is only reached when the system has been exposed to a temperature of 200 °C for 2 hours. The systems are resisting to a continuous exposure up to 450 °C and to a short-time exposure up to 550 °C.

### Hardener:

Not applicable

### Article numbers, colour:

SD05-0906 approx. RAL 9006 aluminium silver

SD05-0905 approx. RAL 9005 deep black

Other colour shade upon request

### Technical specifications (relating to the mixture):

Flash point:	above +23 °C
Viscosity:	intrinsically viscous
Density:	approx. 1.0 g/ml
Mixture ratio:	---
Pot life:	---
Dry film thickness (DFT):	20-25 µm
Solid density:	approx. 19 %
Gloss class:	sheeny
Tinctural power (theoretical):	approx. 9.4 m <sup>2</sup> /kg at 20 µm DFT
VOC value:	approx. 720 g/l
Organic solvent content:	approx. 71 % by weight
Temperature stability:	max. +450 °C, dry heat (continuously resistant) max. +550°C dry heat (short-time resistant)

The Technical Data indicated are subject to variations depending on colour shade and production process.

### Drying times:

**Dust-dry:** after approx. 25 minutes

**Fast to handling:** after approx. 60 minutes

**Ready for rework:** after approx. 2 hours (with the same product)

The values indicated apply to the dry film thickness at (standard atmosphere) +20 °C and 55 % relative humidity.

### Working temperature/humidity of air:

+5 °C to +35 °C

The substrate temperature must be at least 3 °C above the dew point of the ambient air.

The relative humidity of air should not exceed 85 %.

### Thinner:

VESTOCOR thinner VN62-, also for tool cleaning.

### Priming coats:

Depending on requirements VESTOCOR products based on:  
1K-ESI Zinc powder, SI Zinc powder

### Substrate preparation:

**Steel:** before application of the overall system abrasive blasting according to preparation grade Sa 3 as per DIN EN ISO 12944-4. Round grain is not suited.

### Applying:

**Brush/roller:** processing in delivery state. Use soft brushes, apply liberally and work quickly when applying with brushes. Use new lamb-skin rollers for roller application.

**Airless spray painting:** generally in delivery state, if required add 5 weight per cent VESTOCOR thinner as a maximum.

**Minimum pressure:** approx. 120 bar

**Nozzle:** approx. 0.23-0.48 mm

### Repair of transport and installation damages:

When using coats for repair work on weld seams that are exposed to high temperatures re-blasting according to preparation grade Sa 2.5 as per DIN EN ISO 12944-4 is required. Then, the repair has to be done with the specified coats.

### Storage and identification according to hazardous substance/workplace safety regulations:

For the identification according to valid hazardous substance regulations see the associated Material Safety Data Sheets and labels.

### Storage life:

**Main component:** approx. 6 months in case of proper storage of non-opened drums at +5 °C to +25 °C.

### Safety and protection precautions:

When processing note the safety and health at work rules from the trade association, BGR 500, chapter 2.29, as well as the relevant EC Material and Safety Data Sheets. In liquid state, the products are classified to be hazardous to waters, and therefore they must not come into waters.

### Notes:

As the VESTOCOR SI system will reach its full resistance only after an exposure to a temperature of 200 °C for 2 hours, rather use VESTOTHERM 1K-ESI-Zinkstaub in the workshop for objects that are subject to a longer building time. These priming coats harden without heat supply under absorption of air moisture. Avoid a film thickness in excess of 30 µm DFT for the separate top coatings. Avoid an overall film thickness in excess of 100 µm DFT. Otherwise stresses between substrate and coating system may occur under varying temperature exposures.

Information and recommendations in this document are based on today's state of our knowledge and are intended to inform purchasers. They do not exempt purchasers to check the products for their suitability and application. We guarantee a perfect quality within the scope of our general terms and conditions of business. All previous Technical Data Sheets cease to be valid.