

Technical Information

senotherm® - Three-Pack-Hydro-Decor



Product series/Article No.:
2860

Waterbased three-pack coating material offering a temperature resistance up to approx. 400° C.

PRODUCT DESCRIPTION

senotherm®-Three-Pack-Hydro-Decor finishes of series –2860- are based on temperature-resistant silicone resins and temperature-resistant pigments. Use of this type of coatings does not cause any silicone contamination. An interaction with other products, however, can not be excluded.

The system consists of paint of series 2860 (component A), hardener 19-2861-705955 (component B) and catalyst 20-0600-707326 (component C).

The mixing ratio by weight is 100 parts component A : 66 parts hardener : 1.4 parts catalyst.

To achieve the unique properties of the system it is necessary to mature the material prior to application. Key parameters for the maturing process are shearing force, temperature and time. The higher the shearing force or temperature, the shorter the maturing time. The mixture of paint, catalyst and hardener must be stirred for 1 hour with a suitable mixer at approx. 2000 rpm. As the material gets warm during this process it is recommended to allow the material to cool down to approx. 30° C prior to processing.

In contrast to conventional temperature-resistant coating system, cross-linking of the film takes place at 10 min/100° C object temperature. Apart from the surface hardness achieved, the coated surfaces are further virtually free from fumes and odours when being put into operation.

By this means the end user's steadily raising awareness of health and environmental protection has also been taken into account.

senotherm®-Three-Pack-Hydro-Decor is available in various colours, effects and metallic shades. Red coloured shades are restricted in temperature resistance up to 300°C.

TYPICAL FIELDS OF APPLICATION

Stoves, stovepipes accessories and other appliances and lines subjected to high thermal stress.

GENERAL APPLICATION RECOMMENDATIONS

Preparation respectively maturing of the material	<p>: At first the catalyst must be mixed with the hardener. Subsequently the total quantity of the catalyst/hardener mixture (in the specified mixing ratio by weight) must be added to the paint (component A) while stirring continuously.</p> <p><u>Please take care that materials are always mixed in the specified order, i.e. mix catalyst and hardener and then add to the paint under stirring!</u></p> <p>The whole mixture must then be stirred thoroughly with a suitable stirrer for 1 hour at approx. 2000 rpm.</p>
System	<p>: One-coat – The dried system is not re-coatable with itself.</p>
Substrate	<p>: Steel, cast iron; Substrates have to be tested with respect to suitability</p>
Pretreatment	<p>: The substrate must be clean and free from grease, corrosion and other contaminations. Grit blasting with corundum (90-120 mesh) to obtain a surface roughness Ra of 2,5 – 3,5 is necessary and a basic requirement for good coating results.</p> <p>Alkaline detergents or organic solvents can be used for degreasing.</p> <p>Sand blasting with alumina (corundum, Al₂O₃) having a particle size of 80-100 mesh should result in a surface roughness of at least Ra = 2.5 µm. This is the recommended optimum for a good adhesion of the coating.</p>
Application method	<p>: Conventional air-atomizing spray or electrostatic spray on fully insulated lines.</p> <p><u>Attention:</u> Storage tanks and containers must always be closed in order to avoid drying on the surface, as dried particles can not be stirred into the lacquer again.</p>

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Cure	<p>: 10 min/100° C object temperature and 35 ± 5 microns DFT.</p> <p>During the drying process methyl alcohol is released. Therefore it is necessary to take care for proper ventilation!</p> <p>Full mechanical resistances and properties are achieved after a reaction time of approx. 7 days.</p> <p>At temperatures below 10° C there is no sufficient through drying.</p>
Rec. film thickness	: 35 ± 5 microns
Pot life	<p>: Under standard conditions the pot life is 24 hrs, however, it can be prolonged by means of a storage at temperatures between 5° and 20 °C.</p> <p>However, temperatures above 25 °C as well as different altering condition may reduce pot life.</p>
Shelf life	: At least 6 months in sealed original packaging. Material is to be protected against heat and frost. Storage temperature should preferably be between +5 and +35° C.

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The above indications were determined under lab conditions and in practice as being reference values. They correspond to today's developments in technique. Application equipment and application technique are beyond our influence. This information is given to the best of our knowledge, however, no liability or obligation whatsoever is assumed in connection with it.