

AEROHEAT® 650

INTERIOR & EXTERIOR

SOLVENT BASED

1K

Description:

A one component, solvent based, high temperature coating based on an air drying/baking silicone binder available in aluminium or special high temperature colours.

Intended Uses:

AEROHEAT® 650 is used for the protection of steel from corrosion on areas including flare stacks, kilns, flues, furnaces, muffler, exhausts, hot piping, stacks & other steel surfaces at elevated temperatures.

AEROHEAT® 650 will withstand continuous dry temperatures of 650°C and temperature surges of 700°C.

Features & Benefits:

- Maximum thickness which can be applied in a single coat without subsequent blistering on heating is 40µm DFT.
- Used for internal and external protection of steel surfaces.
- Excellent flexibility.
- Excellent abrasion and weathering resistance.

Certifications:

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Technical Data:

Colour	RAL 9006 White Aluminium, RAL 9004 Signal Black, RAL 5005 Signal Blue, RAL 3001 Signal Red or RAL 1003 Signal Yellow
Finish	Matt
Typical Film Thickness	• 25µm DFT • Total DFT of 50µm required
Method of Application	Aerosol spray
Number of Coats	2 coats by aerosol to achieve typical DFT
Temperature Resistance	• Dry continuous – 650°C • Intermittent – 700°C
Curing	This coating will air dry but must be heated to 200°C for 60 minutes to obtain full cure before use

Drying Information:

	0°C	5°C	10°C	25°C	30°C	40°C
Touch Dry	-	-	-	1 hr	-	-
Hard Dry	-	-	-	16 hr	-	-
Overcoating Data – See Limitations						
Substrate Temp.	0°C	10°C	15°C	25°C	30°C	40°C
Minimum	-	8 hrs	6 hrs	4 hrs	2 hrs	-
Maximum	-	-	-	48 hrs	-	-

* A curing temperature below 10°C is not recommended. Adequate ventilation should be maintained during application & curing.

AEROSOLS: AEROHEAT®

Whilst we endeavour to ensure that all advice we give about the product is correct, the information given in this data sheet is not intended to be exhaustive and any person using the product for any purpose other than that specifically recommended in this sheet without first obtaining written confirmation from us as to the suitability of the product for the intended purpose does so entirely at his own risk. As conditions of use, method of application and suitability of the substrate prior to painting are beyond our control, no guarantee is implied by the recommendations contained herein. We therefore do not accept any liability whatsoever or howsoever arising from the performance of this product or for any loss or damage arising out of the use of this product. The information contained in this sheet is liable to modification from time to time in the light of experience and ongoing product development programmes. It is the user's responsibility to ensure that this sheet is current prior to using the product

Systems & Compatibility:

Consult a Specialized Coating Systems technical representative for coating systems solutions.

Surface Preparation:

Accumulated dirt and soluble salts must be removed. Dry bristle brushing will normally be adequate for accumulated dirt. Soluble salts should be removed by freshwater rinsing. Oil or grease should be removed in accordance with SSPC-SP1 solvent cleaning.

Abrasive Blast Cleaning and Mechanical Preparation – Steel

Abrasive blast clean to SA 2½ (ISO 8501-1:2007) or SSPC-SP6. If oxidation has occurred between blasting and application of AEROHEAT® 650, the surface should be re-blasted to the specified visual standard. Surface defects revealed by the blast cleaning process should be ground, filled, or treated in the appropriate manner.

A surface profile of 25 – 50 microns is recommended

Hand or Power Tool Preparation

Any coating on the surface must be removed prior to the application of AEROHEAT® 650. Hand or power tool clean to a minimum of St3 (ISO 8501-1:2007) or SSPC-SP3. Note, all scale must be removed and areas which cannot be prepared adequately by chipping or needle gun should be spot blasted to a minimum standard of Sa2½ (ISO 8501-1:2007) or SSPC-SP6. Typically, this would apply to C or D Grade rusting in this standard.

Primed Surfaces

AEROHEAT® 650 is suitable for application to un-weathered steelwork freshly coated with zinc silicate shop primers.

If the zinc shop primer shows extensive or widely scattered breakdown, or excessive zinc corrosion products, overall sweep blasting will be necessary. Other types of shop primer are not suitable for overcoating and will require complete removal by abrasive blast cleaning. Weld seams and damaged areas should be cleaned to Sa2½ (ISO 8501-1:2007) or SSPC-SP6.

Aluminium Metal Spray

Metal sprayed surfaces should be fresh, clean, and free from moisture or surface contamination.

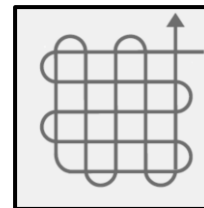
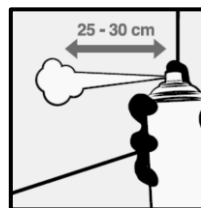
Application:

Mixing	Shake well. Specialized Coating Systems AEROHEAT products contain high quality material with a high pigment load for high coverage. Ensure that the can is shaken well as per the below instructions. Aerosols are supplied with a lid, to start using AEROHEAT® 650, it is necessary to remove the lid first. Turn the can upside down and strike the bottom of the can against the palm of your hand. Repeat this several times to loosen the ball from the pigments in the can. Once the ball is loose, keep the can right way up (the sediment will be at the bottom) and shake the can vigorously. Rotate the can in small circles to stir the pigments with the ball and continue shaking for at least 2 minutes. Make sure to always do the first spray on a test surface first as the top of the valve system may hold more solvent than pigment on the first spray. This is normal.
Aerosol	Move the can slowly and evenly back and forth changing direction only after the spray has moved past the object. This will help control the amount of paint being sprayed and will avoid finish defects.

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After spraying and for storage purposes, invert can and spray to clean the residue out of the nozzle.



Environment:

	Surface Temperature	Ambient Temperature	Relative Humidity
Minimum	5°C*	5°C	No lower limit
Maximum	45°C*	45°C	100%

* Higher temperatures result in reduced sag resistance & faster cure.

Limitations:

- Do not exceed the recommended dry film thickness.
- When using high heat coatings over Inorganic Zinc Primer, the products should be applied in strict accordance with film thickness specifications, since application of excessive thicknesses may cause blistering. Determine that the inorganic zinc primer is thoroughly cured prior to application of the high heat coating by following the curing instructions given on the relevant product technical data sheet.
- AEROHEAT® 650 is not suitable for exposure in acid or alkaline environments.
- Overcoating information is given for guidance only and is subject to local climate and environmental conditions. Consult a Specialized Coating Systems representative for specific recommendations.
- Unmixed material (in closed containers) should be maintained in protected storage in accordance with information given in the STORAGE section of this data sheet.
- Technical and application data herein is for the purpose of establishing a general guideline of the coating application procedures.
- Test performance results were obtained in a controlled laboratory environment and Specialized Coating Systems makes no claim that the exhibited published test results, or any other tests, accurately represent results found in all field environments. As application, environmental and design factors can vary, due care should be exercised in the selection and verification of the performance and use of the coating.

Pack Size:

400 ml aerosol (12 per carton)

Storage:

- Shelf Life: 12 months minimum at 25°C from date of manufacture. Subject to inspection thereafter.
- Store can with nozzle on, in dry conditions, out of direct sunlight, away from sources of heat or ignition.

Precautions:

For complete safety and handling information please refer to the appropriate Safety Data Sheets prior to using this product.