



**FESTÉKIPARI**  
KUTATÓ KFT.

1108 Budapest, Venyige u. 3.  
Telefon: +36 1 432-8831

1479 Budapest, Pf.: 36  
Fax: +36 1 432-8830

@ fki@festekkutato.hu  
@ www.festekkutato.hu

## TECHNICAL DATA SHEET

### Aqua-Heat

*Waterborne, air-drying heat resistant paint*

<b>Colours:</b>	According to the colour chart
<b>Field of application:</b>	Paint suitable for aesthetic coating of metal surfaces continuously exposed to high temperature (boilers, fireplaces, mufflers, smoke pipes, heat technique fixture, etc.)
<b>Appearance:</b>	homogenous suspension
<b>Non volatile content: (180°C/30 min):</b>	min. 35 m/m%
<b>Efflux time (DIN4, 23°C):</b>	min. 20 s
<b>Shelf life:</b>	3 months from production if stored between +5 and +25°C. Frost sensitive.

### PROPERTIES AND APPLICATION INSTRUCTIONS

<b>Substrates:</b>	Cold- or hot rolled steel, cast iron
<b>Surface pre-treatment:</b>	Substrates must be clean, dry and free from any contamination. All oil, dirt, grease, dust, foreign material and oxide layer must be removed prior to coating. Blast cleaning provides a roughened surface that improves adhesion. Abrasive blast clean to Sa 2½ (ISO 8501-1:2007).
<b>Processing:</b>	The paint can be applied both by conventional low-pressure, HVLP atomization or dipping. By conventional air spray 1,3-1,5 mm nozzle and 2,5-4 bar atomizing pressure is advised. Stir paint carefully each time before spraying. (Intense stirring may cause foaming.)
<b>Drying and cure:</b>	After drying at room temperature for dust dry stage (15-20 min) full physical hardening will occur by curing at 180°C for about 30 minutes. Higher baking temperature (200-220°C) is advantageous because it improves the hardness and the scratch resistance of the coating. Only after this can the coated surface be exposed to higher temperatures, applying an even rate of heating.
<b>Rec. layer thickness:</b>	80-100 µm wet / 20-25 µm dry



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<b>Adhesion:</b>	0 grade (on blasted steel)
<b>Heat resistance:</b>	max. 600°C (slight fading may happens)
<b>Theor. spreading rate:</b>	8,5 m <sup>2</sup> /kg 25 μm DFT
<b>Thinning:</b>	apply softened water when necessary
<b>Clean up:</b>	The cleaning of tools and surfaces contaminated with paint can be done with tap water immediately after application. The removal of the dried paint can only be done by organic solvent (e.g. aromatic solvent).
<b>Safety precautions:</b>	The paint is basically for use by professional applicators in accordance with information in this Technical Data Sheet and the applicable Material Safety Data Sheet (MSDS). Refer to the product MSDS before using this material.

*We recommend the field of application and usage technologies according to our best technical knowledge. These recommendations do not substitute for the detailed application technology / method statement which has to be developed with respect to the local circumstances and application requirements. In this sense this TDS should be considered as information only.*