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TECHNICAL DATA SHEET

Aqua-Heat AC HS

Waterborne, air-drying heat resistant paint

Colours:	According to the colour chart
Field of application:	Paint suitable for aesthetic coating of metal surfaces continuously exposed to high temperature (boilers, fireplaces, mufflers, smoke pipes, heat technique fixture, etc.)
Appearance:	Black or metal grey suspension
Rel. Density: (23°C):	1,3 g/cm^3
Non volatile content: (180°C/30 min):	min. 45 m/m%
Efflux time (DIN4, 23°C):	50-100 s
Shelf life:	3 months from production if stored between +5 and +25°C. Frost sensitive.

PROPERTIES AND APPLICATION INSRTUCTIONS

Substrates:	Cold- or hot rolled steel, cast iron
Surface pre-treatment:	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).
Processing:	The paint can be applied both by conventional low-pressure or 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.)
Drying and cure:	Coating dries at 25°C temperature within 40-60 minutes. It is recommended to keep the physical drying time (15-20 min) before hot drying. Complete layer drying time can be shortened to 15-30 minutes at 80°C temperature. Only after this can the coated surface be exposed to higher temperatures, applying an even rate of heating.

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Rec. layer thickness:	90-145 µm wet / 15-25 µm dry
Adhesion:	0 grade (on blasted steel)
Heat resistance:	permanently 400°C for a short time 500°C
Theor. spreading rate:	12,5-13,0 m^2/kg 20 µm DFT
Thinning:	apply softened water when necessary
Clean up:	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).
Safety precautions:	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.